

# Wire and Welding products

**HAYNES**  
Wire Company



## MULTIMET<sup>®</sup> Coated Electrodes

### Product Description:

MULTIMET<sup>®</sup> coated electrodes are used for the shielded metal arc welding of HAYNES<sup>®</sup> HR-120<sup>®</sup> alloy. The electrodes are also a great candidate for dissimilar joining of other high-temperature materials including HAYNES<sup>®</sup> 556<sup>®</sup> alloy, HAYNES<sup>®</sup> HR-160<sup>®</sup> alloy and other nickel and cobalt high-temperature alloys. The coating is designed for great operability, especially in out-of-position welding.

### Specifications:

AMS 5795

### Weld Deposit Chemistry:

Fe.....	Remainder	Mn.....	1.0 - 2.5
Cr.....	20.0 - 22.5	Nb + Ta.....	0.75 - 1.25
Ni.....	19.0 - 21.0	Si.....	1.0 max.
Co.....	18.5 - 21.0	C.....	0.10 max.
Mo.....	2.5 - 3.5	P.....	0.04 max.
W.....	2.0 - 3.0	S.....	0.03 max.

### Minimum Mechanical Properties:

Tensile (psi)	90,000
Mpa	620
Elongation (%)	25

### Available Product Forms:

<b>Diameter (in)</b>	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
<b>Length (in)</b>	10	14	14	14
<b>Pkg Wt (lbs)</b>	5	10	10	10
<b>Current (A) DCEP</b>	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7030

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