

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® B-3® Coated Electrodes

Product Description:

HASTELLOY® B-3® coated electrodes are used for the shielded metal arc welding of B-3® alloy materials. The weld metal has excellent resistance to hydrochloric acids at all temperatures and also withstands hydrogen chloride, sulfuric, acetic and hydrofluoric acids. The alloy has improved thermal stability and resistance to stress corrosion cracking over alloy B-2. The electrode can be used for the overlay and cladding of carbon and stainless steels with no butter layer needed. The coating is designed for great operability, especially in out-of-position welding.

Specifications:

AWS A5.11 ENiMo-10
ASME SFA.5.11 ENiMo-10
Kennblatt 7617.02*

ASME IX F-43
UNS W80675

*Specify at time of order

Weld Deposit Chemistry:

Ni.....Balance
Mo.....27.0 - 32.0
Fe.....1.0 - 3.0
Cr.....1.0 - 3.0
Co.....3.0 max.
W.....3.0 max.
Mn.....2.0 max.

Cu.....0.50 max.
Other.....0.50 max.
Si.....0.20 max.
C.....0.02 max.
S.....0.03 max.
P.....0.04 max.

Minimum Mechanical Properties:

Tensile (psi) 100,000
Mpa 690
Elongation (%) 25

Available Product Forms:

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

Packaged in Hermetically Sealed Containers

HW-7014

HAYNES
Wire Company

158 N. Egerton Road P.O. Box 677 Mountain Home, North Carolina USA 28758-0677
Telephone: 828-692-5791 800-438-7263 FAX: 828-697-9818 haynesintl.com

HASTELLOY® B-3® Coated Electrodes