

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® C-4 Coated Electrodes

Product Description:

HASTELLOY® C-4 coated electrodes are used for the shielded metal arc welding of C-4 alloy. The weld metal has good resistance to a wide range of corrosive attack including contaminated mineral acids and chlorine contaminated media. In addition, the electrodes can be used for the overlay and cladding of carbon and stainless steels where enhanced corrosion resistance is required. The coating is designed for great operability, especially in out-of-position welding.

Specifications:

AWS A5.11 ENiCrMo-7
ASME SFA-5.11 ENiCrMo-7
Kennblatt 02667.05*

ASME IX F-43
UNS W86455

*Specify at time of order

Weld Deposit Chemistry:

Ni.....	Balance	Cu.....	0.50 max.
Cr.....	14.0 - 18.0	Other.....	0.50 max.
Mo.....	14.0 - 17.0	W.....	0.50 max.
Fe.....	3.0 max.	Si.....	0.20 max.
Co.....	2.0 max.	P.....	0.04 max.
Mn.....	1.5 max.	C.....	0.015 max.
Ti.....	0.70 max.	S.....	0.03 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-7016

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