

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® G-30® Coated Electrodes

Product Description:

HASTELLOY® G-30® coated electrodes are used for the shielded metal arc welding of G-30® alloy. The deposited weld metal has superior corrosion resistance over most other nickel and iron-base alloys in commercial phosphoric acids as well as many complex environments containing highly oxidizing acids such as nitric/hydrochloric, nitric/hydrofluoric, and sulfuric acids. The electrodes can also be used for the overlay and cladding of carbon steels where enhanced corrosion resistance is needed.

Specifications:

AWS A5.11 ENiCrMo-11

ASME IX F-45

ASME SFA-5.11 ENiCrMo-11

UNS W86200

Weld Deposit Chemistry:

| | | | |
|-------|-------------|-------|-----------|
| Ni | Balance | Co | 5.0 max. |
| Cr | 28.0 - 31.5 | Mn | 1.5 max. |
| Fe | 13.0 - 17.0 | Si | 1.0 max. |
| Mo | 4.0 - 6.0 | C | 0.03 max. |
| W | 1.5 - 4.0 | P | 0.04 max. |
| Cu | 1.0 - 2.4 | S | 0.02 max. |
| Nb+Ta | 0.3 - 1.5 | Other | 0.50 max. |

Minimum Mechanical Properties:

| | |
|----------------|--------|
| Tensile (psi) | 85,000 |
| Mpa | 590 |
| Elongation (%) | 25 |

Available Product Forms:

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

Packaged in Hermetically Sealed Containers

HW-7052

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