

# Wire and Welding products

**HAYNES**  
Wire Company



## **HAYNES® N-61 RTW™ Filler Metal**

### **Product Description:**

HAYNES® N61 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of nickel 200 and 201 grades. The alloy has good resistance to alkalines and can also be used for the overlay and cladding of carbon and low alloy steels. Dissimilar welding applications include nickel 200 and 201 to carbon and stainless steels, copper-nickel alloys and other HAYNES® and HASTELLOY® grades. The RTW™ filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### **Specifications:**

AWS A5.14 ERNi-1  
ASME SFA 5.14 ERNi-1

UNS N02061  
ASME IX F-41

### **Weld Deposit Chemistry:**

Ni.....93.0 min.  
Ti.....2.0 - 3.5  
Al.....1.5 max.  
Mn.....1.0 max.  
Fe.....1.0 max.  
Si.....0.75 max.

Other.....0.50 max.  
Cu.....0.25 max.  
C.....0.15 max.  
P.....0.03 max.  
S.....0.015 max.

### **Minimum Mechanical Properties:**

Tensile (psi)           60,000  
Mpa                       414  
Elongation (%)           20

### **Available Product Forms:**

<b>Diameter in</b>	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
<b>Diameter mm</b>	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.  
Straight lengths are available in 36" lengths.

HW-7024B

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