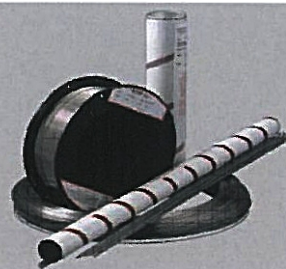


# Wire and Welding products

## **HAYNES** International



## **HAYNES® M418 RTW™ Filler Metal**

### **Product Description:**

HAYNES® M418 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of M400, K-500 and other nickel-copper alloys. The weld metal has good corrosion resistance to many media including sea water and reducing acids. The alloy can be used for the overlay and cladding of steels, but care should be taken to determine if a butter layer of ERNi-1 is needed first. 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 ERNiCu-7

UNS N04060

ASME-SFA-5.14 ERNiCu-7

ASME IX F-42

### **Weld Deposit Chemistry:**

Ni	62.0 - 69.0
Cu	Balance
Mn	4.0 max.
Ti	1.5 - 3.0
Fe	2.5 max.
Si	1.25 max.

Al	1.25 max.
Other	0.50 max.
C	0.15 max.
P	0.02 max.
S	0.015 max.

### **Minimum Mechanical Properties:**

Tensile (psi)	70,000
Mpa	483
Elongation (%)	30

### **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.