

# HAYNES<sup>®</sup> 200 RTW<sup>™</sup> Filler Metal

## Product Description:

HAYNES<sup>®</sup> 200 RTW<sup>™</sup> filler metal is used for the gas metal and gas tungsten arc and submerged arc welding of a variety of cast iron grades including gray, malleable and ductile. The weld deposits are easily machinable and can be deposited using a variety of processes. HAYNES<sup>®</sup> 200 grade is equivalent to filler metal 99 grades and can be used to weld cast iron materials to a variety of carbon steels. The RTW<sup>™</sup> 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-CI     UNS N02215  
ASME SFA5.15 ERNi-CI

## Composition:

<b>Nickel:</b>	99.0 min.	<b>Silicon:</b>	0.35 max.
<b>Iron:</b>	0.40 max.	<b>Sulfur:</b>	0.01 max.
<b>Copper:</b>	0.25 max.	<b>Carbon:</b>	0.015 max.
<b>Manganese</b>	0.35 max.	<b>Other:</b>	1.00 max.

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	71,000
<b>Mpa</b>	490
<b>Elongation (%)</b>	12

## Available Product Forms and Sizes:

<b>Diameter in</b>	0.030	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	*0.125	*0.156x	0.187x
<b>Diameter mm</b>	0.76	0.80	0.89	1.00	1.10	1.20	1.60	2.00	2.40	*3.20	*4.00x	*4.70x

Filler metals are available in MIG spools, TIG cut lengths, reels, and coils from the above diameters.

\*Size not available in MIG spools.

•••Size not available on reels.

Standard TIG straight lengths are available in 36" (914mm) lengths. *Other lengths available upon request.*