

Wire and Welding products

HAYNES
Wire Company



HAYNES® 718 RTW™ Filler Metal

Product Description:

HAYNES® 718 RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of alloys X-750 and 718. Alloy 718 is an age-hardenable alloy with excellent strength to 1200°F (650°C). The alloy is used extensively in gas turbine components and gas turbine repairs. In addition, the alloy can be used for cladding and overlay of parts in the oil and gas industry. 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 ERNiFeCr-2
ASME-SFA-5.14 ERNiFeCr-2

UNS N07718
AMS 5832

Weld Deposit Chemistry:

Ni.....	50.0 - 55.0	Mn.....	0.35 max.
Fe.....	Balance	Si.....	0.35 max.
Cr.....	17.0 - 21.0	Al.....	0.40 max.
Nb + Ta.....	4.75 - 5.50	Cu.....	0.30 max.
Mo.....	2.80 - 3.30	C.....	0.08 max.
Al.....	0.20 - 0.80	P.....	0.015 max.
Other.....	0.50 max.	S.....	0.015 max.

Minimum Mechanical Properties:

Tensile (psi)	165,000
Mpa	1,138
Elongation (%)	-

Heat Treatment: 1325°F(720°C) for 8 hrs / Furnace cool to 1150°F (620°C) for 8 hrs / Air cool

Available Product Forms:

Diameter in	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter mm	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-7012B

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