

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® C-2000® Coated Electrodes

Product Description:

HASTELLOY® C-2000® coated electrodes are used for the shielded metal arc welding of C-2000® alloy. The deposited weld metal has excellent resistance to uniform corrosion conditions in a variety of media including oxidizing and reducing environments. The alloy makes a great candidate for dissimilar joining of other nickel-chromium-molybdenum alloys and also molybdenum containing stainless steels. The electrodes are also used for the overlay and cladding of carbon steels where enhanced corrosion resistance is needed. The coating is designed for great operability, especially in out-of-position welding.

Specifications:

AWS A5.11 ENiCrMo-17
ASME Code Case 2334

Kennblatt 9677.03*
UNS W86200

*Specify at time of order

Weld Deposit Chemistry:

Ni.....Balance
Cr.....22.0 - 24.0
Mo.....15.0 - 17.0
Fe.....3.0 max.
Co.....2.0 max.
Cu.....1.3 - 1.9
Mn.....0.50 max.

Other.....0.50 max.
Si.....0.20 max.
C.....0.02 max.
P.....0.03 max.
S.....0.015 max.

Minimum Mechanical Properties:

Tensile (psi) 100,000
Mpa 690
Elongation (%) 25

Available Product Forms:

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

Packaged in Hermetically Sealed Containers

HW-7020

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