

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® G-35® RTW™ Filler Metal

Product Description:

HASTELLOY® G-35® RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of G-35® alloy. The weld metal has outstanding corrosion resistance to "wet process" phosphoric acid, other oxidizing acids, alkalis, and chloride-bearing media. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 - ERNiCrMo-22

Weld Deposit Chemistry:

Ni	Balance	Cu	0.30 max.
Cr	32.25 - 34.25	Mn	0.50 max.
Fe	2.00 max.	Si	0.60 max.
Mo	7.60 - 9.00	P	0.03 max.
Co	1.00 max.	C	0.05 max.
W	0.60 max.	S	0.015 max.
Ti	0.20 max.	Al	0.40 max.
V	0.20 max.	Nb + Ta	0.50 max.

Minimum Mechanical Properties:

Tensile (psi) 85,000
Mpa 590

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-7038A

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