

MULTIMET[®] Coated Electrodes

Product Description:

MULTIMET[®] coated electrodes are used for the shielded metal arc welding of HAYNES[®] HR-120[®] alloy. The electrodes are also a great candidate for dissimilar joining of other high-temperature materials including HAYNES[®] 556[®] alloy, HAYNES[®] HR-160[®] alloy and other nickel and cobalt high-temperature alloys. The coating is designed for great operability, especially in out-of-position welding.

Specifications:

AMS 5795

Composition:

Iron:	Remainder
Chromium:	20.0-22.5
Nickel:	19.0-21.0
Cobalt:	18.5-21.0
Molybdenum:	2.5-3.5
Tungsten:	2.0-3.0

Manganese:	1.0-2.5
Niobium + Tantalum	0.75-1.25
Silicon:	1.0 max.
Carbon:	0.10 max.
Phosphorus:	0.04 max.
Sulfur:	0.03 max.

Minimal Mechanical Properties:

Tensile (psi)	90,000
Mpa	620
Elongation (%)	20

Available Product Forms and Sizes:

Diameter in	0.093	0.125	0.156	0.187
Diameter mm	2.40	3.20	4.00	4.70
Length in	10	14	14	14
Length mm	254	355.6	355.6	355.6
Package Weight lbs.	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150