

# HAYNES<sup>®</sup> 82 RTW<sup>™</sup> Filler Metal

## Product Description:

HAYNES<sup>®</sup> 82 RTW<sup>™</sup> filler metal wire is used for gas metal arc, gas tungsten arc and submerged arc welding of alloy 600, 601, 800 and 825. The alloy can also be used in dissimilar welding applications with carbon and stainless steels, HAYNES<sup>®</sup> and HASTELLOY<sup>®</sup> alloys and nickel-copper alloys. The weld metal has good corrosion and oxidation resistance. 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 ERNiCr-3      UNS N06082  
ASME-SFA-5.14 ERNiCr-3    ASME IX F-43

## Composition:

<b>Nickel:</b>	67.0 min.	<b>Silicon:</b>	0.50 max.
<b>Chromium:</b>	18.0-22.0	<b>Copper:</b>	0.50 max
<b>Manganese:</b>	2.5-3.5	<b>Other:</b>	0.50 max
<b>Iron:</b>	3.0 max	<b>Carbon:</b>	0.10 max.
<b>Niobium:</b>	2.0-3.0	<b>Phosphorus:</b>	0.03 max.
<b>Tantalum:</b>	0.30 max.	<b>Sulfur:</b>	0.03 max.
<b>Titanium:</b>	0.75 max.	<b>Cobalt:</b>	0.12 max.*

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	80,000
<b>Mpa</b>	552
<b>Elongation (%)</b>	30

## 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.*