

HAYNES® 25 RTW™ Filler Metal

Product Description:

HAYNES® 25 RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of HAYNES® 25 alloy. The deposited weld metal has excellent strength, good oxidation resistance to 1800°F (980°C), very good sulfidation resistance, and relatively good resistance to wear and galling. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AMS 5796 UNS R30605

Composition:

Cobalt:	Remainder	Manganese:	1.0-2.0
Chromium:	19.0-21.0	Silicon:	1.0 max.
Tungsten:	14.0-16.0	Carbon:	0.05-0.15
Nickel:	9.0-11.0	Phosphorus:	0.04 max.
Iron:	3.0 max.	Sulfur:	0.03 max.

Minimal Mechanical Properties:

Tensile (psi)	140,000
Mpa	965
Elongation (%)	40

Available Product Forms and Sizes:

Diameter in	0.030	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	*0.125	*0.156x	0.187x
Diameter mm	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.*