

# HAYNES<sup>®</sup> N-61 RTW<sup>™</sup> Filler Metal

## Product Description:

HAYNES<sup>®</sup> N61 RTW<sup>™</sup> filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of nickel 200 and 201 grades. The alloy has good resistance to alkalines and can also be used for the overlay and cladding of carbon and low alloy steels. Dissimilar welding applications include nickel 200 and 201 to carbon and stainless steels, copper-nickel alloys and other HAYNES<sup>®</sup> and HASTELLOY<sup>®</sup> grades. 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 ERNi-1      UNS N02061  
ASME SFA 5.14 ERNi-1    ASME IX F-41

## Composition:

<b>Nickel:</b>	93.0 min.	<b>Other:</b>	0.50 max.
<b>Titanium:</b>	2.0-3.5	<b>Copper:</b>	0.25 max.
<b>Aluminum:</b>	1.5 max.	<b>Carbon:</b>	0.15 max.
<b>Manganese:</b>	1.0 max.	<b>Phosphorus:</b>	0.03 max.
<b>Iron:</b>	1.0 max.	<b>Sulfur:</b>	0.015max.
<b>Silicon:</b>	0.75 max.		

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	60,000
<b>Mpa</b>	414
<b>Elongation (%)</b>	20

## Available Product Forms and Sizes:

<b>Diameter in</b>	0.8	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
<b>Diameter mm</b>	0.031	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

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.*