

HASTELLOY® G-35® RTW™ Filler Metal

Product Description:

HASTELLOY® G-35® RTW™ filler metal is used for the gas metal and gas tungsten arc welding of G-35® alloy. The weld metal has outstanding corrosion resistance to “fertilizer-grade” 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 UNS N06035

Composition:

| | | | |
|--------------------|-------------|---------------------------|------------|
| Nickel: | Balance | Manganese: | 0.30 max. |
| Chromium: | 32.25-34.25 | Silicon: | 0.50 max. |
| Iron: | 2.00 max. | Other: | 0.60 max. |
| Molybdenum: | 7.60-9.00 | Phosphorus: | 0.03 max. |
| Cobalt: | 1.00 max. | Carbon: | 0.05 max. |
| Tungsten: | 0.60 max. | Sulfur: | 0.015 max. |
| Titanium: | 0.20 max. | Aluminum: | 0.40 max. |
| Vanadium: | 0.20 max. | Niobium + Tantalum | 0.50 max. |

Minimal Mechanical Properties:

| | |
|-----------------------|--------|
| Tensile (psi) | 85,000 |
| Mpa | 590 |
| Elongation (%) | - |

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.*