

HASTELLOY® X RTW™ Filler Metal

Product Description:

HASTELLOY® X RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of X alloy. The deposited weld metal has an exceptional combination of oxidation resistance, fabricability and high-temperature strength. It has also been found to be exceptionally resistant to stress-corrosion cracking in petrochemical applications. X alloy exhibits good ductility after prolonged exposure at temperatures of 1200, 1400, and 1600°F (650, 760, and 870°C) for 16,000 hours. The filler metal is also a good candidate for dissimilar welding between solid solution nickel-based alloys and Ni-Fe-Cr alloys. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear I contact tips.

Specifications:

AWS A5.14 ERNiCrMo-2 UNS N06002

ASME SFA-5.14 ERNiCrMo-2

Composition:

Nickel:	Remainder	Tungsten:	0.20-1.00
Chromium:	20.5-23.0	Copper:	0.50 max.
Iron:	17.0-20.0	Other	0.50 max.
Molybdenum:	8.0-10.0	Carbon	0.05-0.15
Cobalt:	0.50-2.50	Phosphorus:	0.04 max.
Manganese:	1.00 max.	Sulfur:	0.03 max.
Silicon:	0.50 max.		

Minimal Mechanical Properties:

Tensile (psi)	950,000
Mpa	660
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.

ËÿSize not available on reels.

Standard TIG straight lengths are available in 36" (914mm) lengths. *Other lengths available upon request.*

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