

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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