

HAYNES[®] 230-W[®] Coated Electrodes

Product Description:

HAYNES[®] 230-W[®] coated electrodes are used for the shielded metal arc welding of HAYNES[®] 230[®]. The deposited weld metal has excellent high-temperature strength and outstanding resistance to oxidizing environments up to 2100°F for prolonged exposures. The deposited weld metal also has excellent long-term stability.

Specifications:

AWS A 5.11 ENiCrWMo-1 UNS W86231

Composition:

Nickel:	Remainder	Silicon:	0.25-0.75	Sulfur:	0.0015
Chromium:	20.00-24.00	Other:	0.50 max.		
Tungsten:	13.00-15.00	Copper:	0.50 max.		
Cobalt:	5.00 max.	Aluminum:	0.50 max.		
Iron:	3.00	Titanium:	0.10 max.		
Molybdenum:	1.00-3.00	Carbon:	0.10 max.		
Manganese:	0.30-1.00	Phosphorus:	0.02 max.		

Minimal Mechanical Properties:

Tensile (psi)	90,000
Mpa	620
Elongation (%)	20

Available Product Forms and Sizes:

Diameter in	0.093	0.125	0.156	0.187
Diameter mm	2.40	3.20	4.00	4.70
Length in	10	14	14	14
Length mm	254	355.6	355.6	355.6
Package Weight lbs.	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150