

HAYNES® M418 RTW™ Filler Metal

Product Description:

HAYNES® M418 RTW™ filler metal is used for the gas metal, gas tungsten and submerged arc welding of M400, K-500 and other nickel-copper alloys. The weld metal has good corrosion resistance to many media including sea water and reducing acids. The alloy can be used for the overlay and cladding of steels, but care should be taken to determine if a butter layer of ERNi-1 is needed first. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCu-7 UNS N04060
ASME SFA 5.14 ERNiCu-7 ASME IX F-42

Composition:

Nickel:	62.0-69.0	Aluminum:	1.25 max.
Copper:	Balance	Other:	0.50 max.
Manganese:	4.0 max.	Carbon:	0.15 max.
Titanium:	1.5-3.0	Phosphorus:	0.02 max.
Iron:	2.5 max.	Sulfur:	0.015 max.
Silicon:	1.25 max.		

Minimal Mechanical Properties:

Tensile (psi)	70,000
Mpa	483
Elongation (%)	30

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.*

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