

## HAYNES<sup>®</sup> 214<sup>®</sup> RTW<sup>™</sup> Filler Metal (Structural)

### Product Description:

HAYNES<sup>®</sup> 214<sup>®</sup> RTW<sup>™</sup> filler metal is used for the gas metal arc and gas tungsten arc welding of HAYNES<sup>®</sup> 214<sup>®</sup> alloy. The deposited weld metal has outstanding oxidation resistance to 2300°F and excellent resistance to carburization and excellent resistance to chlorine-bearing environments. The alloy is used in demanding industrial heating applications and specialized gas turbine parts, such as honeycomb seals. The RTW<sup>™</sup> finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

### Specifications:

HAYNES PS-6076-2 UNS N07214

### Composition:

<b>Nickel:</b>	Balance	<b>Titanium:</b>	0.50 max.	<b>Phosphorus:</b>	0.015 max.
<b>Chromium:</b>	15.00-17.00	<b>Tungsten:</b>	0.50 max.	<b>Sulfur:</b>	0.015 max.
<b>Aluminum:</b>	4.10-5.00	<b>Silicon:</b>	0.20 max.	<b>Magnesium:</b>	0.010 max.
<b>Iron:</b>	2.00-4.00	<b>Niobium:</b>	0.15 max.	<b>Boron</b>	0.004 max.
<b>Cobalt:</b>	2.00 max.	<b>Carbon:</b>	0.05 max.		
<b>Manganese:</b>	0.50 max.	<b>Yttrium:</b>	0.003-0.04		
<b>Molybdenum:</b>	0.50 max.	<b>Zirconium:</b>	0.02 max.		

### Minimal Mechanical Properties:

<b>Tensile (psi)</b>	-
<b>Mpa</b>	-
<b>Elongation (%)</b>	-

### Available Product Forms and Sizes:

<b>Diameter in</b>	0.030	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	*0.125	*0.156x	0.187x
<b>Diameter mm</b>	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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