

HASTELLOY® X Coated Electrodes

Product Description:

HASTELLOY® X coated electrodes are used for the shielded metal arc welding of X alloy. The deposited weld metal has possesses 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, 1600°F (650,760 and 870°C) for 16,000 hours. The filler metal is often used as a dissimilar filler metal between other solid-solution strengthened high-temperature alloys.

Specifications:

AWS A 5.11 ENiCrMo-2 ASME SFA 5.11 ENiCrMo-2

Composition:

Nickel:	Balance	Silicon:	1.0 max.
Chromium:	20.5-23.0	Copper:	0.50 max.
Molybdenum:	8.0-10.0	Other:	0.50 max.
Iron:	17.0-20.0	Carbon:	0.05-0.15
Cobalt:	0.50-2.50	Sulfur:	0.03 max.
Tungsten:	1.0 max.	Phosphorus:	0.04 max.
Manganese:	1.0 max.		

Minimum Mechanical Properties:

Tensile (psi)	95,000
Mpa	650
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