

HASTELLOY® W RTW™ Filler Metal

Product Description:

HASTELLOY® W RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of dissimilar solid solution strengthened nickel alloys. The filler metal is widely used for that purpose in gas turbines, aerospace and chemical process industries. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiMo-3 UNS N10004
ASME SFA-5.14 ERNiMo-3

Composition:

Nickel:	Remainder	Tungsten:	1.00 max.
Molybdenum:	23.0-26.0	Vanadium:	0.60 max.
Iron:	4.0-7.0	Copper:	0.50 max.
Chromium:	4.0-6.0	Carbon:	0.50 max.
Cobalt:	2.50 max.	Other:	0.12 max.
Manganese:	1.00 max.	Phosphorus:	0.04 max.
Silicon:	1.00 max.	Sulfur:	0.03 max.

Minimum Mechanical Properties:

Tensile (psi)	100,000
MPa	690
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.

• Size not available on reels.

Standard TIG straight lengths are available in 36" (914mm) lengths. *Other lengths available upon request.*