

HAYNES® 200 RTW™ Filler Metal

Product Description:

HAYNES® 200 RTW™ filler metal is used for the gas metal and gas tungsten arc and submerged arc welding of a variety of cast iron grades including gray, malleable and ductile. The weld deposits are easily machinable and can be deposited using a variety of processes. HAYNES® 200 grade is equivalent to filler metal 99 grades and can be used to weld cast iron materials to a variety of carbon steels. The RTW™ filler metal finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNi-CI UNS N02215

ASME SFA5.15 ERNi-CI

Composition:

Nickel:	99.0 min.	Silicon:	0.35 max.
Iron:	0.40 max.	Sulfur:	0.01 max.
Copper:	0.25 max.	Carbon:	0.015 max.
Manganese	0.35 max.	Other:	1.00 max.

Minimal Mechanical Properties:

Tensile (psi)	71,000
Mpa	490
Elongation (%)	12

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.

ËSize not available on reels.

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

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