

# HASTELLOY® C-4 RTW™ Filler Metal

## Product Description:

HASTELLOY® C-4 RTW™ filler metal is used for the gas metal and gas tungsten arc welding of C-4 alloy. The deposited weld metal has outstanding high-temperature stability in the 1200°F to 1900°F range. The weld metal has excellent resistance to stress corrosion cracking and oxidizing atmospheres up to 1900°F. It also resists a wide variety of chemical process environments. 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 ERNiCrMo-7 UNS N06455

ASME SFA-5.14 ERNiCrMo-7

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	100,000
<b>Mpa</b>	690
<b>Elongation (%)</b>	-

## Composition:

<b>Nickel:</b>	Remainder	<b>Copper:</b>	0.50 max.
<b>Chromium:</b>	14.0-18.0	<b>Other:</b>	0.50 max.
<b>Molybdenum:</b>	14.0-18.0	<b>Tungsten:</b>	0.50 max.
<b>Iron:</b>	3.0 max.	<b>Silicon:</b>	0.08 max.
<b>Cobalt:</b>	2.0 max.	<b>Phosphorus:</b>	0.04 max.
<b>Manganese:</b>	1.0 max.	<b>Sulfur:</b>	0.03 max.
<b>Titanium:</b>	0.70 max.	<b>Carbon:</b>	0.015 max.

## 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.

•••Size not available on reels.

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