

# HASTELLOY® S RTW™ Filler Metal

## Product Description:

HASTELLOY® S RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of S alloy. The deposited weld metal has excellent thermal stability, low thermal expansion and excellent oxidation resistance to 2000°F. S weld metal retains its strength and ductility after aging at temperatures of 800°F to 1600°F. The filler metal also is a great candidate for dissimilar joining in cyclic heating applications and long term temperature exposure. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear contact tips.

## Specification:

AMS 5838 UNS N06635

## Composition:

<b>Nickel:</b>	Remainder	<b>Aluminum:</b>	0.10-0.50
<b>Chromium:</b>	14.50-17.00	<b>Copper:</b>	0.35
<b>Molybdenum:</b>	14.00-16.50	<b>Lanthanum:</b>	0.01-0.10
<b>Iron:</b>	3.00 max.	<b>Carbon:</b>	0.02 max.
<b>Cobalt:</b>	2.00 max.	<b>Phosphorus:</b>	0.02 max.
<b>Manganese:</b>	0.30-1.00	<b>Sulfur:</b>	0.015 max.
<b>Tungsten:</b>	1.00 max.	<b>Boron:</b>	0.015 max.
<b>Silicon:</b>	0.20-0.75		

## Minimum 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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