

# HASTELLOY® G-35® RTW™ Filler Metal

## Product Description:

HASTELLOY® G-35® RTW™ filler metal is used for the gas metal and gas tungsten arc welding of G-35® alloy. The weld metal has outstanding corrosion resistance to “fertilizer-grade” phosphoric acid, other oxidizing acids, alkalis, and chloride-bearing media. The RTW™ finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

## Specifications:

AWS A5.14 ERNiCrMo-22 UNS N06035

## Composition:

<b>Nickel:</b>	Balance	<b>Manganese:</b>	0.30 max.
<b>Chromium:</b>	32.25-34.25	<b>Silicon:</b>	0.50 max.
<b>Iron:</b>	2.00 max.	<b>Other:</b>	0.60 max.
<b>Molybdenum:</b>	7.60-9.00	<b>Phosphorus:</b>	0.03 max.
<b>Cobalt:</b>	1.00 max.	<b>Carbon:</b>	0.05 max.
<b>Tungsten:</b>	0.60 max.	<b>Sulfur:</b>	0.015 max.
<b>Titanium:</b>	0.20 max.	<b>Aluminum:</b>	0.40 max.
<b>Vanadium:</b>	0.20 max.	<b>Niobium + Tantalum</b>	0.50 max.

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	85,000
<b>Mpa</b>	590
<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.

• Size not available on reels.

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

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