

HAYNES[®] 230-W[®] RTW[™] Filler Metal

Product Description:

HAYNES[®] 230-W[®] RTW[™] filler metal is used for the gas tungsten arc and gas metal arc welding of HAYNES[®] 230-W[®] alloy. The filler metal may also be used to weld UNS N06617. The deposited weld metal combines excellent high temperature strength and oxidation resistance with superior long-term stability and good fabricability. The RTW[™] finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCrWMo-1 UNS N06231

ASME SFA-5.14 ERNiCrWMo-1

AMS 5839

Composition:

Nickel:	Remainder	Silicon:	0.25-0.75
Chromium:	20.0-24.0	Aluminum:	0.20-0.50
Tungsten:	13.0-15.0	Copper:	0.50 max.
Cobalt:	5.0 max.	Other:	0.50 max.
Iron:	3.0 max.	Carbon:	0.05-0.15
Molybdenum:	1.00-3.00	Phosphorous:	0.03 max.
Manganese	0.30-1.00	Sulfur:	0.015 max.

Minimal Mechanical Properties:

Tensile (psi)	110,000
Mpa	760
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.*