

# HAYNES<sup>®</sup> 230-W<sup>®</sup> RTW<sup>™</sup> Filler Metal

## Product Description:

HAYNES<sup>®</sup> 230-W<sup>®</sup> RTW<sup>™</sup> filler metal is used for the gas tungsten arc and gas metal arc welding of HAYNES<sup>®</sup> 230-W<sup>®</sup> 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<sup>™</sup> 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:

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

## Minimal Mechanical Properties:

<b>Tensile (psi)</b>	110,000
<b>Mpa</b>	760
<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.*