

HAYNES® 617 RTW™ Filler Metal

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Product Description:

HAYNES® 617 RTW™ filler metal is used for the gas metal arc and gas tungsten arc welding of HAYNES® 617 alloy. The alloy has high-temperature strength, good oxidation resistance and is used in many high-temperature applications. 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 ERNiCrCoMo-1 UNS N06617
ASME-SFA-5.14 ERNiCrCoMo-1 ASME IX F-43
AMS 5887 ASTM-B-166

Composition:

| | |
|--------------------|-----------|
| Nickel: | Balance |
| Chromium: | 20.0-24.0 |
| Cobalt: | 10.0-15.0 |
| Molybdenum: | 8.0-10.0 |
| Iron: | 3.0 max. |
| Aluminum: | 0.8-1.5 |
| Manganese: | 1.0 max. |

| | |
|--------------------|------------|
| Silicon: | 1.0 max. |
| Titanium: | 0.60 max. |
| Copper: | 0.50 max. |
| Other: | 0.50 max. |
| Carbon: | 0.05-0.15 |
| Phosphorus: | 0.03 max. |
| Sulfur: | 0.015 max. |

Minimal Mechanical Properties:

| | |
|-----------------------|--------|
| Tensile (psi) | 90,000 |
| Mpa | 620 |
| Elongation (%) | 25 |

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.*