

# HASTELLOY® B-3® RTW™ Filler Metal

## Product Description:

HASTELLOY® B-3® RTW™ filler metal is used for the gas metal and gas tungsten arc welding of B-3® alloy. The alloy has outstanding resistance to hydrochloric and sulfuric acids in the as-welded condition and excellent thermal stability. B-3® is a great candidate for overlay and cladding where resistance to hydrochloric and sulfuric acids is needed. 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 ERNiMo-10      UNS N10675  
ASME-SFA-5.14 ERNiMo-10      Kennblatt 7615.02 (Spools)\*  
Kennblatt 7616.03  
\*Specify at time of order

## Composition:

<b>Nickel:</b>	65.0 min.	<b>Carbon:</b>	0.01 max.	<b>Vanadium:</b>	0.20 max.
<b>Molybdenum:</b>	27.0-32.0	<b>Sulfur:</b>	0.01 max.	<b>Silicon:</b>	0.10 max.
<b>Cobalt:</b>	3.0 max.	<b>Aluminum:</b>	0.50 max.	<b>Phosphorus:</b>	0.03 max.
<b>Manganese:</b>	3.0 max.	<b>Other:</b>	0.50 max.		
<b>Iron:</b>	1.0-3.0	<b>Titanium:</b>	0.20 max.		
<b>Chromium:</b>	1.0-3.0	<b>Copper:</b>	0.20 max.		
<b>Tungsten:</b>	3.0 max.	<b>Niobium + Tantalum:</b>	0.20 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.*