

Wire and Welding products

HAYNES
Wire Company



HAYNES® 625 RTW™ Filler Metal

Product Description:

HAYNES® 625 RTW™ filler metal is used for the gas metal arc, gas tungsten arc and submerged arc welding of alloys 625, 825 and a wide range of austenitic and super-austenitic stainless steels. The alloy is also used for cladding and overlay of carbon and stainless steels. The deposited weld metal has good resistance to localized corrosion, including pitting and crevice corrosion. 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 ERNiCrMo-3
ASME-SFA-5.14 ERNiCrMo-3
AMS 5837

UNS N06625
ASME IX F-43

Weld Deposit Chemistry:

Ni.....	58.0 min.	Cu.....	0.50 max.
Cr.....	20.0 - 23.0	Other.....	0.50 max.
Mo.....	8.0 - 10.0	Al.....	0.40 max.
Fe.....	1.0 max.	Ti.....	0.40 max.
Nb + Ta.....	3.15 - 4.15	Co.....	0.10 max.
Mn.....	0.50 max.	P.....	0.02 max.
Si.....	0.50 max.	S.....	0.015 max.

Minimum Mechanical Properties:

Tensile (psi)	105,000
Mpa	724
Elongation (%)	30

Available Product Forms:

Diameter in	0.031	0.035	0.039	0.045	0.047	0.062	0.078	0.093	0.125
Diameter mm	0.8	0.9	1.0	1.1	1.2	1.6	2.0	2.4	3.2

Filler metals are available in spools and in cut lengths from the above diameters.
Straight lengths are available in 36" lengths.

HW-7011B

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