

Wire and Welding products

HAYNES
Wire Company



HASTELLOY® C-22 RTW®

Product Description:

HASTELLOY® C-22 RTW® is used for the gas metal arc, gas tungsten arc, and submerged arc welding of alloys C-22, C-276, 625 and molybdenum-bearing stainless steels. The weld metal has excellent resistance to preferential corrosive attack in various media and thus is a great candidate for overlay and cladding of carbon steels. The alloy makes a great candidate for dissimilar welding of other nickel-chromium-molybdenum alloys and stainless steels. The RTW® finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCrMo-10

ASME-SFA-5.14 ERNiCrMo-10

Kennblatt 4536.05(C/L)*

UNS N06022

ASME IX F-43

Kennblatt 4535.04 (Spools)*

*Specify at time of order

Weld Deposit Chemistry:

Ni.....	Balance	Other.....	0.50 max.
Cr.....	20.0 - 22.5	Cu.....	0.50 max.
Mo.....	12.5 - 14.5	V.....	0.35 max.
Fe.....	2.0 - 6.0	Si.....	0.08 max.
W.....	2.5 - 3.5	P.....	0.02 max.
Co.....	2.5 max.	C.....	0.015 max.
Mn.....	0.50 max.	S.....	0.010 max.

Minimum Mechanical Properties:

Tensile (psi)	115,000
Mpa	793
Elongation (%)	40

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.

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158 N. Egerton Road P.O. Box 677 Mountain Home, North Carolina USA 28758-0677
Telephone: 828-692-5791 800-438-7263 FAX: 828-697-9818 haynesintl.com

HASTELLOY® C-22 Reduced Tip Wear (RTW®)