

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:

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

Minimal Mechanical Properties:

Tensile (psi)	110,000
Mpa	760
Elongation (%)	-

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.*