

RA333® weld fillers are designed to match the high temperature properties of the nickel based superalloy RA333. This alloy is characterized by exceptional oxidation resistance right up to the incipient melting point in open-fired environments, excellent carburization resistance and ability to tolerate repeated thermal shock. RA333 weld fillers have been used for many applications other than welding RA333 base metals. The exceptional strength of RA333 filler metal is often used for welding cast furnace parts such as radiant tubes or hangers. RA333 weld filler is also often used for similar and dissimilar welds involving other high strength alloys such as 800H/AT, RA 253 MA®, and RA330®.

Specifications

UNS: W86333 [Except Manganese]

Chemical Composition, %

	Cr	Ni	Mo	Co	W	Mn	Si	C	Fe
RA333 Weld	25.0	45.0	3.0	3.0	3.0	3.0	1.0	0.05	17.0

Features

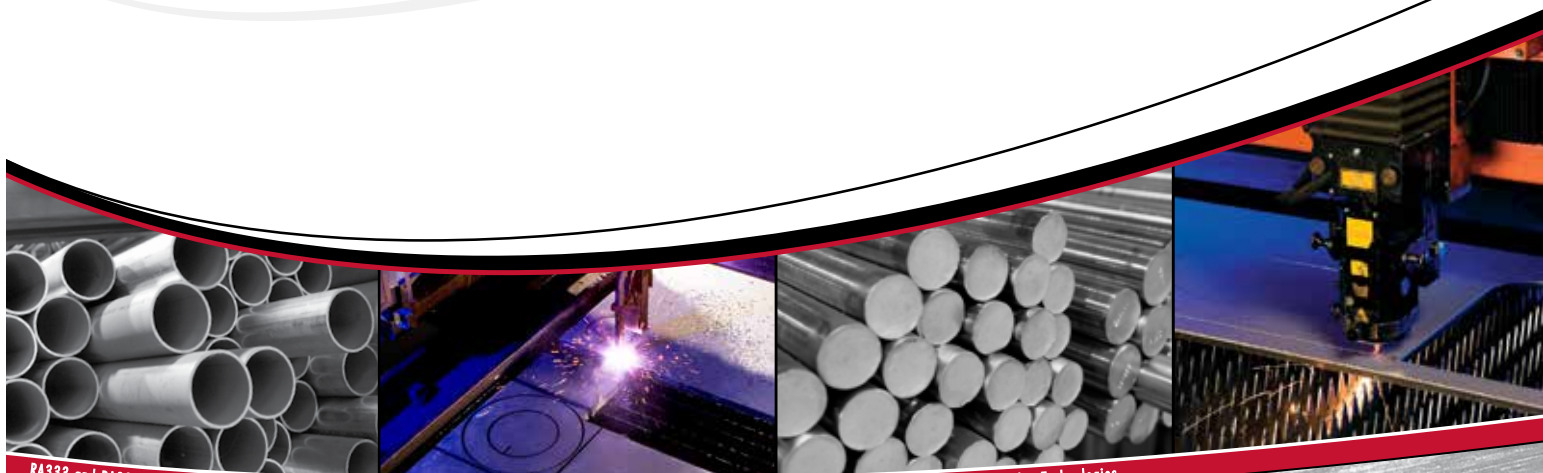
- Very resistant to metal dusting environments
- Welder appeal – excellent flow & tie in
- Excellent oxidation resistance up to 2200°F
- High creep-rupture strength
- Immune to many forms of stress corrosion cracking

Applications

- Joining RA333 base metals for both high temperature and aqueous corrosion applications
- Repair of furnace fixtures
- Welding cast alloys
 - MO-RE® 2, 22-H, Super 22H
- Welding wrought alloys
 - 800H/AT, RA 253 MA, and RA330

Availability

GMAW	Diameter, in	0.035"	0.045"	0.062"				0.218"
GTAW	Diameter, in			1/16"	3/32"	1/8"		
Electrode	Diameter, in				3/32"	1/8"	3/16"	



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