

**TURBINE AIRFOIL HARDFACING AND WELDING WIRES**

Polymet Alloy	Tradename	Specifications				Nominal Composition													Rockwell Hardness		Process		Available Forms		Applications		
		GE	Pratt & Whitney	Rolls-Royce	Other	Ni	Co	Fe	Cr	W	Mo	Al	Si	Mn	Nb	Ti	Ta	Zr	C	Other	GTAW	PTA	Braze	Solid Spooled		Solid Cut Length	
<b>NICKEL BASE ALLOYS</b>																											
P•Met 802	Mar M 002			MSRR 7210		BAL 5.0	8.5	9.5	5.5												✓	✓	✓	✓	✓	Structural Components	
P•Met 808	Rene 108	B50TF262				BAL 9.5	8.0	9.5	5.5						0.8	3.0	0.01	0.10	1.5Hf		✓	✓	✓	✓	✓	Structural Components	
P•Met 811	GTD 111	B50A880					Proprietary Material															✓	✓	✓	✓	✓	Buckets & Tip Repairs
P•Met 813	Inconel 713		AMS 5391			BAL	14.0	15.5	6.1	4.2	6.1	1.0*	0.2	0.1*	1.0*	0.1	0.12	0.012B			✓	✓	✓	✓	✓	Blades	
P•Met 814	Haynes 214					BAL	4.0	13.0	4.5			1.0*	0.2	0.1*	1.0*	0.01*	0.05	0.003Y			✓	✓	✓	✓	Hot section Components		
P•Met 815	Amdry 915					BAL	3.0*	15.5	1.0*	9.0	1.1	1.0*	1.0*	0.6*	0.6*	0.06*	2.8B			✓	✓	✓	✓	✓	Braze Repairs		
P•Met 817	Inconel 617		UNS N06617			BAL 12.5	3.0*	22.0	3.2	0.5	3.3	1.0	0.3								✓	✓	✓	✓	✓	Combusitors	
P•Met 820	Rene 220	B50TF239	PCC 1-59-02.061			BAL 12.0	19.0														✓	✓	✓	✓	✓	Structural Components	
P•Met 822	GTD 222	C50TF101	PCC 1-59-02E.078				Proprietary Material															✓	✓	✓	✓	Combusitors	
P•Met 823	GTD 222	B50A940					Proprietary Material															✓	✓	✓	✓	Combusitors	
P•Met 834	Inconel 738 LC					BAL 8.5	0.5*	16.0	2.6	1.8	3.4	0.3*	0.2*	0.9	3.4	1.8	0.06	0.11			✓	✓	✓	✓	✓	Buckets & Tip Repairs	
P•Met 838	Inconel 738	B50TF191				BAL 8.5	0.5*	16.0	2.6	1.8	3.4	0.3*	0.2*	0.9	3.4	1.8	0.10	0.17			✓	✓	✓	✓	✓	Buckets & Tip Repairs	
P•Met 839	Inconel 939	B50TF250				BAL 19.0	22.5	2.0	1.9					1.0	3.7	1.4	0.10	0.15			✓	✓	✓	✓	✓	Blades & Vanes	
P•Met 840	Inconel 939					BAL 19.0	0.2*	22.5	2.0	1.9	0.1*	0.1*	0.1*	1.0	3.8	1.4	0.04*	0.15			✓	✓	✓	✓	✓	Blades & Vanes	
P•Met 842	Rene 142	B50TF274				BAL 12.0	6.8	4.9	1.5	6.1				6.3	0.02*	0.12	2.8Re1.2Hf				✓	✓	✓	✓	✓	Blade Tip Repairs	
P•Met 843	Rene N5	C50TF87				BAL 7.5	0.20*	7.0	5.0	1.5	6.2	0.20*	0.01*	0.1*	0.04*	6.5	0.01*	0.05			✓	✓	✓	✓	✓	Blades	
P•Met 845	C 242		AS EMS 55447			BAL 10.0	1.0*	20.0	10.3	0.2*	0.3	0.3		0.3*				0.3			✓	✓	✓	✓	✓	Vanes & Repairs	
P•Met 847	Mar M 247					BAL 10.0	5.0*	8.2	10.0	7.0	5.5	0.20*	0.20*		3.0	0.05*	0.16	1.5Hf			✓	✓	✓	✓	✓	Vanes	
P•Met 849	CM5X-4					BAL 10.0	6.5	6.0	0.6	5.6				1.0	6.0			3Re 0.1Hf			✓	✓	✓	✓	✓	Blades	
P•Met 850	B1900		RR AL 73638-40			BAL 10.0	0.35*	8.0	0.1*	6.0	6.0	0.25*	0.2	0.1*	1.0	4.3	0.08	0.1			✓	✓	✓	✓	✓	Vanes	
P•Met 851	B1900 mod					BAL 10.0	0.35*	10.0	0.1*	3.0	6.0	0.25*	0.2	0.1*	1.0	7.0	0.1	0.015B			✓	✓	✓	✓	✓	Vanes	
P•Met 854	Haynes 230		AMS 5878			BAL 3.0*	3.0*	22.0	14.0	2.0	0.4	0.5	0.7					0.08*			✓	✓	✓	✓	✓	Combusitors	
P•Met 860	Inconel 625		AMS 5837			BAL 1.0*	5.0*	21.5	9.0	0.4*	0.5*	0.5*	3.6	0.4*				0.1			✓	✓	✓	✓	✓	Blade repairs	
P•Met 875	Hastelloy X		AMS 5798			BAL 1.5	18.5	21.8	0.6	9.0	1.0*	1.0*						0.1			✓	✓	✓	✓	✓	Combusitors	
P•Met 880	Rene 80	B50TF259				BAL 9.5	14.0	4.0	4.0	3.0				5.0				0.06*	0.17		✓	✓	✓	✓	✓	Blade Tip Repairs	
P•Met 895	Rene 195						Proprietary Material															✓	✓	✓	✓	Blades	
<b>COBALT BASE ALLOYS</b>																											
P•Met 905	L605		AMS 5796			10.0	BAL	3.0*	20.0	15.0				1.0*	1.5			0.10			✓	✓	✓	✓	✓	Engine Components	
P•Met 906	Alloy 6		AMS 5788			BAL	27.0	4.0										1.0			✓	✓	✓	✓	✓	Engine Components	
P•Met 909	Mar M 509	B50TF89	CHROM RT 5027-835			10.0	BAL	23.5	7.0						0.2	3.5	0.4	0.6			✓	✓	✓	✓	✓	Blades & Vanes	
P•Met 910	ADH	RMD6000 CLB				21.3	BAL	1.7*	23.5	6.0				0.7	0.8*			0.7	0.021*	0.4	0.45B	✓	✓	✓	✓	Vane Braze Repairs	
P•Met 911	RMD 6000						Proprietary Material															✓	✓	✓	✓	Vane Braze Repairs	
P•Met 912	Alloy 12		AMS A5.13-80/RCG-8			BAL	2.5	29.0	8.0									1.5			✓	✓	✓	✓	✓	Engine Components	
P•Met 913	Alloy 12 HC					BAL	2.5	29.0	9.0									1.9			✓	✓	✓	✓	✓	Blades	
P•Met 914	FSX 414					10.5	BAL	2.0*	29.5	7.0				1.0*	1.0*			0.25			✓	✓	✓	✓	✓	Vane Repairs	
P•Met 918	Mar M 918	B50A824	AMS 5814			20.0	BAL	20.0										0.06			✓	✓	✓	✓	✓	Vane Repairs	
P•Met 919	Nozzaloy						Proprietary Material															✓	✓	✓	✓	Vane Repairs	
P•Met 920	Bktaloy	B50AG7					Proprietary Material															✓	✓	✓	✓	Blade Tip Repairs	
P•Met 921	Alloy 21	B50AG17					5.0											0.2			✓	✓	✓	✓	✓	Engine Components	
P•Met 931	Alloy 31		AMS 5835			10.5	BAL	25.0	7.5					0.7				0.51			✓	✓	✓	✓	✓	Blade Z Notch Repairs	
P•Met 940	Ultimet		AMS 5789			9.0	BAL	3.0	26.0	2.0	5.0							0.06			✓	✓	✓	✓	✓	Engine Components	
P•Met 972	Merl 72		UNS R31233			15.0	BAL	20.0	9.0					4.4				0.35	1.0Hf		✓	✓	✓	✓	✓	Blade Tip Repairs	
P•Met 980	T800	B50TF193	SNECMA DMR 34-071			BAL	17.5							29.0				0.04			✓	✓	✓	✓	✓	Blade Z Notch Repairs	
P•Met 988	HS188		AMS 5801			22.0	BAL	3.0*	22.0	14.5				0.4	1.25*			0.1	0.075La		✓	✓	✓	✓	✓	Engine Components	
P•Met 994	CM 64	B50TF55				5.0	BAL	28.0	20.0									0.9	1.0V		✓	✓	✓	✓	✓	Blade Z Notch Repairs	

\*Maximum  
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