

HASTELLOY® C-86 Filler Metal

Product Description:

HASTELLOY® C-86 filler metal is used for the gas metal and gas tungsten arc welding of UNS N06686 and other alloys of similar composition. The filler metal is used as a corrosion-resistant overlay on carbon and low alloy steels and as an overmatching filler metal for alloys of similar compositions, such as C-276. The matte finish on the spooled wire promotes smooth feeding through welding equipment and reduced tip wear in contact tips.

Specifications:

AWS A5.14 ERNiCrMo-14 UNS N06686
ASME-SFA-5.14 ERNiCrMo-14 ASME IX F-43

Composition:

Nickel:	Balance	Tungsten:	3.0-4.4
Chromium:	19.0-23.0	Silicon:	0.08 max.
Iron:	5.0 max.	Other:	0.50 max.
Molybdenum:	15.0-17.0	Aluminum:	0.50 max.
Copper:	0.5 max.	Sulfur:	0.02 max.
Titanium:	0.25 max.	Phosphorus:	0.02 max.
Manganese:	1.0 max.	Carbon:	0.01 max.

Minimal Mechanical Properties:

Tensile (psi)	110,000
Mpa	760
Elongation (%)	30

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.*

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