

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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