

INCONEL® Filler Metal 53MD

INCONEL Filler Metal 53MD is used for the gas-tungsten-arc and gas-metal-arc welding of INCONEL alloy 693, and the overlaying of carbon steels and stainless steels to provide a nickel-chromium-aluminum alloy corrosion resistant surface. The high chromium and aluminum levels provide excellent resistance to metal dusting in chemical and petrochemical applications. The product also provides excellent resistance to carburization, sulfidation, and other high temperature corrosion forms.

Specifications	AWS A5.14 as classification ERNiCrFeAl-1 UNS N06693
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Limiting Chemical Composition (%)	Ni Remainder	Cr 27.0 to 31.0
	C 0.15 max.	Al 2.5 to 4.0 max.
	Mn 1.0 max.	Ti 1.0 max.
	Fe 2.5 to 6.0	Co 0.12 max.
	S 0.01 max.	Nb+Ta 0.50 to 2.5
	Si 0.50 max.	P 0.03 max.
	Cu 0.30 max.	Others 0.50 max.

Typical Mechanical Properties	Tensile Strength, psi	110,000
	MPa	760
	Elongation, (4d) %	45

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.

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