

E Alloy C-276

CATEGORY	SMAW Stick Electrodes	
TYPE	Nickel based electrode (SMAW)	
APPLICATIONS	Ceweld E alloy C276 is used for welding materials of similar composition. This low carbon nickel-chromium-molybdenum filler metal can also be used for dissimilar welding between nickel base alloys and stainless steels, as well as for surfacing and cladding on low alloyed steels.	
PROPERTIES	Due to high molybdenum content this alloy offers excellent resistance too stress & corrosion cracking, pitting and crevice corrosion. High mechanical properties with excellent weldability on DC+.	
CLASSIFICATION	AWS	A 5.11: E NiCrMo-4 (UNS W80276)
	EN ISO	14172: E Ni 6276 (NiCr15Mo15Fe6W)
	DIN: W.Nr.	2.4887
	DIN	1736: EL-NiMo15Cr15W
SUITABLE FOR	Hasteloy C-276, NiCrMo alloys, agressive media, against pitting and crevice corrosion, dissimilar joint of nickel alloys and stainless steels,	
APPROVALS	CE approved	
WELDING POSITIONS:		

WELD METAL ANALYSIS %

C	Mn	Si	S	Ni	Mo	Fe	W	Cr	P
0.012	0.40	0.14	0.004	59.10	16.10	5.50	3.25	15.50	0.012

MECHANICAL PROPERTIES

Heat Treatment	Tensile strenght		Yield strenght		Enlongation (%)
	(PSI)	(MPA)	(PSI)	(MPA)	
AW	106,000	73	78,500	540	39

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current DC+ (A)	kg / can	kg / 6 pack	kg / 1000
2.4	229	40-65			
3.2	356	60-90			
4.0	356	90-125			