

Alloy C-276

CATEGORY GMAW-GTAW Solid wires

TYPE Nickel based filler metal for welding similar NiCrMo alloys.

APPLICATIONS 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.

CLASSIFICATION

AWS	A 5.14: ER NiCrMo-4
EN ISO	18274: S Ni 6276 (NiCr15Mo16Fe6W4)
DIN: W.Nr.	2.4886
DIN	1736: EL-NiMo16Cr16W

SUITABLE FOR N10276, W.Nr: 2.4819, NiMo16Cr15W, alloy C4

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD METAL ANALYSIS % (TYPICAL)

C	Ni	Cr	Mo	W	V	Fe	Si
<0.01	Rem	16	16	3,5	0,2	6	<0.1

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>470	>740	>32	>100			

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
0.8	16-26	80-180	S-300 / drum	15 / 150	1080 / 600
1.0	16-29	100-250	S-300 / drum	15 / 150	1080 / 600
1.2	18-29	125-290	S-300 / drum	15 / 150	1080 / 600
1.6	21-32	160-330	S-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC EN ISO 14175: I1, I3 (Ar-He)