



FILLER METAL C276 (ENiCrMo-4)

DESCRIPTION: Filler Metal C276 is used for shielded-metal-arc welding of Alloy C276 and other nickel-chromium-molybdenum alloys. It is also used for surfacing of steel. The weld metal has excellent corrosion resistance in many media and is especially resistant to pitting and crevice corrosion. Filler Metal C276 Welding Electrode is useful for various dissimilar joints involving nickel alloys, stainless steels, and low-alloy steels. The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

SPECIFICATIONS: AWS A5.11 ENiCrMo-4 (UNS W80276)
 ASME 11, Part C, SFA-5.11, ENiCrMo-4 (UNS W80276)
 ASME IX, F-No.43
 *DIN 1736 EL-NiMoISCrSW (2.4887)
 *(EN) I S 0 14172 - ENi6276 (NiCrISMoSIFeW)

*Supply to these specifications available upon request For manufacture to ASME III (NCA3800, NB2400), MIL and other specifications please refer your inquiry to the Technical Department prior to order placement.

TYPICAL CHEMISTRY:

Ni+Co Remainder	Cu0.50 max.
C0.02 max.	Co2.5 max.
Mn1.0 max.	Cr14.5-16.5
Fe4.0-7.0	MO15.0-17.0
P0.04 max.	V0.35 max.
S0.03 max.	W3.0-4.5
Si0.2 max.	Others0.50 max.

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	25

AVAILABLE PRODUCT FORMS:

Diameter	mm	2.4	3.2	4.0	4.8
	in	3/32	1/8	5/32	3/16
Length	mm	229	356	356	356
	in	12	14	14	14
Current (DC+)	A	40-65	60-90	90-125	125-150

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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