

Applications

Welding of UNS 10276, overlay cladding of low alloy or carbon steel

Characteristics on Usage

SR-276 provides general corrosion resistance and due to the high molybdenum content, a strong resistance to stress corrosion cracking, pitting and crevice corrosion.

Notes on Usage

- ① Dry the electrodes at 350°C(662°F) for 60 minutes before use.
- ② Keep the current as low as possible and length as short as possible.
- ③ Remove rust, water, oil and paint from the groove.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC+

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Fe	W
0.018	0.15	0.35	0.010	0.001	14.6	59.1	15.8	6.15	3.39

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft · lbs) 0°C (32°F) -196°C (-321 °F)	
746 (108,200)	31	44 (32)	33 (24)

Approval

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	3.2 (1/8)	4.0 (5/32)
Length mm(in)	350 (14)	350 (14)
F	70~115	95~150
V-up/OH	65~110	85~135