

## INCO-WELD® C-276 Filler Metal

**INCO-WELD C-276 Filler Metal** is used for gas-tungsten-arc and gas-metal-arc welding of INCONEL alloy C-276 and other nickel-chromium-molybdenum alloys. It is also used for surfacing of steel. The weld metal has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion.

Dissimilar-welding applications include welding INCONEL alloy C-276 to other nickel alloys, to stainless steels, and to low-alloy steels. Submerged arc welding can be done with INCOFLUX NT120 Submerged Arc Flux and for welding 9% Ni steels INCOFLUX 9 is preferred.

### Specifications

AWS A5.14 ERNiCrMo-4 (UNS N10276)

ASME II, Part C, SFA-5.14, ERNiCrMo-4 (UNS N10276)

ASME IX, F-No.43

WERKSTOFF Nr.2.4886

\*BS 2901 NA48

\*DIN 1736 SG-NiMo16Cr16W

\*(EN) ISO 18274 – SNi6276 (NiCr15Mo16Fe6W4)

\*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

Canadian Welding Bureau

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

| Limiting<br>Chemical<br>Composition | Ni+Co ..... Remainder |                        | Cu..... 0.50 max.  |
|-------------------------------------|-----------------------|------------------------|--------------------|
|                                     | C..... 0.02 max.      |                        | Co ..... 2.50 max. |
| Mn ..... 1.0 max.                   |                       | Cr ..... 14.5-16.5     |                    |
| Fe..... 4.0-7.0                     |                       | Mo ..... 15.0-17.0     |                    |
| P ..... 0.04 max.                   |                       | V ..... 0.35 max.      |                    |
| S ..... 0.03 max.                   |                       | W ..... 3.0-4.5        |                    |
| Si ..... 0.08 max.                  |                       | Others ..... 0.50 max. |                    |

| Minimum<br>Mechanical<br>Properties | Tensile Strength, psi | 100,000 |
|-------------------------------------|-----------------------|---------|
|                                     | MPa                   | 690     |
| Elongation, (4d) %                  | 30                    |         |

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

### Available Product Forms

| mm<br>in | 0.8<br>0.030 | 0.9<br>0.035 | 1.0<br>0.040 | 1.14<br>0.045 | 1.2<br>0.047 | 1.6<br>0.062 | 2.4<br>0.093 | 3.2<br>0.125 |
|----------|--------------|--------------|--------------|---------------|--------------|--------------|--------------|--------------|
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39in.)