

AA C-276

CATEGORY FCAW Flux-Cored

TYPE Rutile flux-cored nickel based welding wire for gas shielded arc welding.

APPLICATIONS AA C-276 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 super austenitic stainless steels, as well as for surfacing and cladding on low alloyed steels.

PROPERTIES Due to high molybdenum content this alloy offers excellent resistance to stress & corrosion cracking, pitting and crevice corrosion. High mechanical properties with excellent weldability due to improved wetting compare to solid wire.

CLASSIFICATION
 AWS A 5.34: E NiCrMo4 T 1-4
 EN ISO 14172: T Ni6276
 DIN: W.Nr. 2.4886

SUITABLE FOR Hasteloy C276, NiCrMo alloys, aggressive media, against pitting and crevice corrosion, dissimilar joint of nickel alloys and stainless steels,

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES % WITH M21

C	Mn	Si	Cr	Ni	Mo	W	Fe	Cu
0.018	0.74	0.16	15,5	57,5	15,9	3.6	6,02	0,06

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (PSi)	R _m (PSi)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				0°C	-100°C	-196°C	
AW	66,600	104,400	48	>66	>58	>52	

AW: as welded

WELDING PARAMETERS / PACKING

Position	Welding Parameters		Packing		
	Voltage (V)	Current (A) (DC+)	Spools	kg/spool	kg/pallet
PF	22-29	120-170	BS-300	15	1080
PA	24-35	160-230	BS-300	15	1080

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC. EN ISO 14175: M21