

E Alloy C-276

CATEGORY SMAW Stick Electrodes

TYPE Nickel based electrode (SMAW)

APPLICATIONS Ceweld E 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 on DC+.

CLASSIFICATION

| | |
|------------|----------------------|
| AWS | A 5.11: E NiCrMo-4 |
| EN ISO | 14172: E Ni 6276 |
| DIN: W.Nr. | 2.4887 |
| DIN | 1736: EL-NiMo15Cr15W |

SUITABLE FOR Hasteloy C-276, NiCrMo alloys, agressive media, against pitting and crevice corrosion, dissimilar joint of nickel alloys and stainless steels,

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

| C | Mn | Si | S | Ni | Mo | Fe | W | Cr | P |
|-------|------|------|-------|-------|-------|------|------|-------|-------|
| 0.012 | 0.40 | 0.14 | 0.004 | 59.10 | 16.10 | 5.50 | 3.25 | 15.50 | 0.012 |

MECHANICAL PROPERTIES (TYPICAL)

| Heat Treatment | Tensile strenght | | Yield strenght | | Enlongation (%) |
|----------------|------------------|-------|----------------|-------|-----------------|
| | (PSI) | (MPa) | (PSI) | (MPa) | |
| AW | 106,000 | 730 | 78,500 | 540 | 39 |

AW: as welded

WELDING PARAMETERS / PACKING

| Welding Parameters | | | Packing | |
|--------------------|-------------|-----------------|----------|-------------|
| D (mm) | Length (mm) | Current DC+ (A) | kg / can | kg / 6 pack |
| 2.4 | 229 | 40-65 | 2.27 | 13.62 |
| 3.2 | 356 | 60-90 | 2.27 | 13.62 |
| 4.0 | 356 | 90-125 | 2.27 | 13.62 |