

## Alloy C-276

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Nickel based filler metal for welding similar NiCrMo alloys.

**APPLICATIONS** 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.

**CLASSIFICATION**

AWS	A 5.14: ER NiCrMo-4
EN ISO	18274: S Ni 6276 (NiCr15Mo16Fe6W4)
DIN: W.Nr.	2.4886
DIN	1736: EL-NiMo16Cr16W

**SUITABLE FOR** N10276, W.Nr: 2.4819, NiMo16Cr15W, alloy C4

**APPROVALS** CE approved

**WELDING POSITIONS:**



**ALL WELD METAL ANALYSIS % (TYPICAL)**

C	Ni	Cr	Mo	W	V	Fe	Si
<0.01	Rem	16	16	3,5	0,2	6	<0.1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-60°C	
AW	>470	>740	>32	>100			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A) DC+	spool type	kg / spool	kg / pallet
0.8	16-26	80-180	S-300 / drum	15 / 150	1080 / 600
1.0	16-29	100-250	S-300 / drum	15 / 150	1080 / 600
1.2	18-29	125-290	S-300 / drum	15 / 150	1080 / 600
1.6	21-32	160-330	S-300	15	1080

**REDRYING TEMPERATURE** not required

**GAS ACC EN ISO 14175:** I1, (argon+He (70/30))