Selectarc Ni276

Nickel base Electrode
NiCrMo (C-276) type

Classification

AWS A5.11	:	ENiCrMo-4	ISO 14172	:	E-Ni 6276 (NiCr15Mo15Fe6W4)
UNS	:	W80276	Material N°	:	2.4887

Description & Applications

Basic coated electrode with an alloyed core wire for welding of Nickel-Base alloys (alloy C-276) and other highly corrosion resistant Ni Cr Mo-alloys as well as special stainless steel types. Stable arc, regular drop transfer, easy to watch weld pool, nice aspect of the weld beads. Very resistant in sulphurous acid environment, highly concentrated with chlorides and also in the presence of oxidising solutions (Fe Cl, Cu Cl).

Main applications: Welding of Off-shore components, boilers, containers, piping systems in the chemical and petrochemical industries as well as components of flue gas desulfurizing plants

Base materials

UNS	Alloy	DIN	Material N°
N10276	C-276	NiMo16Cr15W	2.4819
N06455	C-4	NiMo16Cr16Ti	2.4610
N06625	625	NiCr22Mo9Nb	2.4856
N08825	825	NiCr21Mo	2.4858
N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Mo	W	Fe	V	Ni
<0.02	0.2	0.6	16.2	16.0	4.0	5.0	0.15	Rem.

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>450	>720	>30	+20°C >70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	50-70	70-100	90-120

Redrying 2 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks. Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).

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