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INCO-WELD® C-276 Welding Electrode

Ni-Cr-Mo Welding Electrode

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INCO-WELD C-276 Welding Electrode is used for shielded-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 media and is especially resistant to pitting and crevice corrosion. INCO-WELD C-276 Welding Electrode is useful for various dissimilar joints involving nickel alloys, stainless steels, and low-alloy steels.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.11 ENiCrMo-4 (UNS W80276)

ASME II, Part C, SFA-5.11, ENiCrMo-4 (UNS W80276)

ASME IX, F-No.43

*DIN 1736 EL-NiMo15Cr15W (2.4887)

*(EN) ISO 14172 – ENi6276 (NiCr15Mo15Fe6W)

*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 Chemical Composition

Ni+Co	Remainder	Cu	0.50 max.
C	0.02 max.	Co	2.5 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	0.2 max.	Others	0.50 max.

Minimum Mechanical Properties

Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	25

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 12	356 14	356 14	356 14
Current (DC+)	A	40-65	60-90	90-125	125-150