




CEWELD E Alloy C-276

TYPE	Stick electrode for welding NiCrMo alloys such as Hastelloy C-276. (Type Ni 6276, E NiCrMo-4)																
APPLICATIONS	CEWELD® E Alloy 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 stainless steels, as well as for surfacing and cladding on low alloyed steels. Applications include pumps, valves, pipelines and tanks in chemical processing plants, flue gas desulphurization plants and in the offshore oil and gas industry. The simple slag removal reduces the cleaning effort after welding to a minimum.																
PROPERTIES	Thanks to its high molybdenum content, CEWELD® E Alloy C-276 offers excellent resistance to stress corrosion cracking, pitting and crevice corrosion. It also has high mechanical properties with excellent weldability with DC+. The easy slag removal reduces the cleaning effort after welding to a minimum.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.11: E NiCrMo-4</td> </tr> <tr> <td>EN ISO</td> <td>14172: E Ni 6276</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> <tr> <td>W.Nr.</td> <td>2.4887</td> </tr> </table>	AWS	A 5.11: E NiCrMo-4	EN ISO	14172: E Ni 6276	F-nr	43	FM	6	W.Nr.	2.4887						
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SUITABLE FOR	Alloy 276, Ni 6276 (NiCr15Mo16Fe6W4). 2.4886, 2.4887 M.No: 1.5680, 1.5682, 2.4819, 2.4883 NiMo16Cr15W, X12Ni5 / 12Ni19, X8Ni9, G-NiMo16Cr Alloy C4, Hastelloy C276, A494CW-12MW, A743 / A744CW-12M																
APPROVALS	No Approvals Found																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> <th>W</th> </tr> </thead> <tbody> <tr> <td>0.01</td> <td>0.1</td> <td>0.8</td> <td>15.5</td> <td>60</td> <td>16</td> <td>5.5</td> <td>3.2</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Fe	W	0.01	0.1	0.8	15.5	60	16	5.5	3.2
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>500</td> <td>760</td> <td>29</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /	500	760	29								
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REDRYING TEMPERATURE	300°C / 2 hr																
GAS ACCORDING EN 14175																	



CEWELD E Alloy C-276

E ALLOY C-276 2,4 X 229MM	Type	KG/unit	EANCode
	Can	2,27	8720663420466
E ALLOY C-276 3,2 X 356MM	Type	KG/unit	EANCode
	Can	2,27	8720663420473
E ALLOY C-276 4,0 X 356MM	Type	KG/unit	EANCode
	Can	2,27	8720663420480