

CEWELD Alloy C-276

TYPE Filler metal for welding similar NiCrMo C276 alloys.

APPLICATIONS CEWELD® 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: ERNiCrMo-4 |
| EN ISO | 18274: S Ni 6276 (NiCr15Mo16Fe6W4) |
| W.Nr. | 2.4887 |
| F-nr | 43 |
| FM | 6 |

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

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

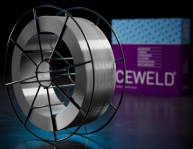
| C | Si | Mn | P | S | Cr | Ni | Mo | V | Fe | W | Co | Cu |
|------|------|-----|------|------|------|----|----|-----|----|-----|----|-----|
| 0.01 | 0.07 | 0.4 | 0.02 | 0.01 | 15.5 | 70 | 16 | 0.2 | 5 | 3.5 | 1 | 0.2 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0.2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| | | | | RT | -196°C | |
| As Welded | 470 | 740 | 32 | 100 | 60 | HRc |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD Alloy C-276

ALLOY C-276 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663420091 |

ALLOY C-276 0,9MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663420077 |

ALLOY C-276 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663420084 |

ALLOY C-276 1,14MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663420107 |

ALLOY C-276 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663420114 |

ALLOY C-276 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663420121 |
| BS-300 | 13,6 | 8720663420138 |