



# CEWELD AA C-276

**TYPE** Rutile flux-cored nickel based welding wire for gas shielded arc welding.(Type 2.4878, C-276)

**APPLICATIONS** AA 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 super austenitic stainless steels, as well as for surfacing and cladding on low alloyed steels.

**PROPERTIES** Due to high molybdenum content this alloy offers excellent resistance to stress & corrosion cracking, pitting and crevice corrosion. High mechanical properties with excellent weldability due to improved wetting compare to solid wire.

**CLASSIFICATION**

AWS	A 5.34: E NiCrMo4T1-4
EN ISO	12153-A: T Ni 6276 (NiCr15Mo15Fe6W4) P M21 2
W.Nr.	2.4887
F-nr	43
FM	5

**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 WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S
0.018	0.16	0.75	15.5	58	16	6	3.5	0.015	0.015

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				-100°C	-196°C	
As Welded	450	750	48	60	55	HRc

**REDRYING** 140°C / 24 hr

**GAS ACC. EN ISO 14175** M21



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AA C-276 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418845