



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

AWS	A 5.11: E NiCrMo-4
EN ISO	14172: E Ni 6276
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 WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W
0.01	0.1	0.8	15.5	60	16	5.5	3.2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	500	760	29	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E Alloy C-276

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