

NICROMIG C-276

MIG/MAG Wires [GMAW]

Nickel alloys

CLASSIFICATION: EN ISO 18274-A : S Ni6276 (NiCr15Mo16Fe6W4) DIN 1736 : EL NiMo16Cr16W AWS A-5.14 : ER NiCrMo-4 W.Nr. : 2.4886	APPROVALS:	APPLICATION: Power generation industry Hardfacing and repairing Petrochemical and chemical industry
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- Wire for joining Alloy C276 and nickel alloys of similar chemical composition.
- Very low carbon chromium, nickel and molybdenum based filler metal can also be used to join dissimilar nickel based alloys, stainless steels and hardfacing low alloy steel linings.
- Due to its high molybdenum content, this alloy offers high resistance to stress, pitting and crevice corrosion.

Application

Welding of dedicated materials. Pollution control chimney liners, ducts, dampers, scrubbers, gas heaters, fans and fan housings. Flue gas desulfurization installations. Chemical processing components such as heat exchangers, reaction vessels, evaporators and transfer piping. Sour gas tanks. Production of pulp and paper (fermenters and bleachers). Waste disposal. Pharmaceutical and food equipment. Sulfuric acid reactors. Equipment for the processing of organic chlorides. Equipment for processes using halide or acid catalysts.

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Fe	W
0,006	0,04	0,50	16,00	58,00	16,00	5,80	3,60

Typical mechanical properties

Yield strength Re [N/mm²]	>410
Tensile strength Rm [N/mm²]	>720
Elongation A5 [%]	>27
Impact energy Kv [J]	>100 J (20°C) /
Additional description	Austenitic microstructure with carbides. The interstitch temperature should not exceed 100 [°C]. The amount of heat input not more than 1.5 [kJ/mm].
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

∅	Welding current [A]	Weight of packet [kg]
0,8	80-180	15,0
1,0	100-250	15,0
1,2	125-290	15,0

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