MIG NI276

Classification

AWS A5.14 : ERNiCrMo-4 ISO 18274 : S Ni 6276 (NiMo16Cr15Fe6W4)

Description & Applications

Solid wire for GMAW of alloys with similar composition like alloys C-276 and others and other highly corrosion resistant Ni-Cr-Mo alloys as well as special stainless steels. Very resistant in sulphurous acid environment, highly concentrated with chlorides and also in the presence of oxidizing solutions (FeCl, CuCl).

Main applications: Chemical industry, piping systems, equipment of de-pollution

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe	W	Co	V	Ni
Min				14.5	15.0				4.0	3.0			50.0
Max	0.02	0.08	1.0	16.5	17.0	0.50	0.04	0.03	7.0	4.5	2.5	0.35	
Type	0.010	0.05	0.45	16.0	16.0	0.01	0.007	0.003	6.0	3.5	0.03	0.04	>50.0

All Weld Metal Mechanical Properties

	$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)	
Min	-	-	-	-	-
Max					
Type	480	780	35	+20°C	100

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8 1.0 1.2 1.6	70 - 180 80 - 220 150 - 320 220 - 380	18 - 26 18 - 28 22 - 32 24 - 34	ISO 14175: I1 (100% Ar) I3 (Ar+10-30%He) Z (Ar+He+H+CO_2) 15-20 l/min