

## Ni-base solid wire

### Classification

AWS A5.14/A5.14M :ERNiCrMo-4  
 ISO 18274 :S Ni 6276 (NiCr15Mo16Fe6W4)

### General Description

**Solid wire for welding CrMoW-alloyed nickel alloys (e.g. Alloy C276)**

**Depending on the corrosion requirements also applicable for welding C-22 and C-4**

**Extreme resistance to corrosion environments containing sulphuric acid and chlorides**

**Applicable for surfacing in high temperature applications (up to 1200°C)**

### Shielding gas (acc. EN)

GMAW I1 Inert gas Ar 100%  
 I3 Inert gas Ar + > 0-95% He

### Chemical composition (w%), typical, all weld metal

C	Mn	Si	Cr	Ni	Mo	Fe	W
0.006	0.5	0.04	15.5	57.8	16.0	5.8	3.6

### Mechanical properties, all weld metal

	Process	Shielding gas	Condition	0.2% Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (ISO), J +20°C
Typical values	GTAW	I1	AW	410	720	27	100
after welding	GMAW	I1	AW	400	700	25	90
	W						

### Materials to be welded

Material grades such as:	DIN/EN	W.Nr.	ASTM/ACI	UNS
Ni Base high CrMo steel for high corrosion environments	NiMo 16Cr15W	2.4819	C-276	N10276
	NiCr21Mo14W	2.4602	C-22	N06022
	NiMo16Cr16Ti	2.4610	C-4	N06455

It is developed for welding C-276 material

Can also be applied for welding C-22 and C-4, depending on the corrosion requirements

### Packaging, available sizes and identification

Process	Unit:	Sizes, mm					
		1.0	1.2	1.6	2.0	2.4	3.2
GTAW	2kg tube			X	X	X	X
GMAW	15 kg spool B301	X	X				

Other sizes and packaging on request

Identification

Imprint: Nichrofer®C-276

Tip colour:

Nichrofer®C-276 : rev.EN 20