



Alloy C276 Welding Electrodes

CLASSIFICATIONS: AWS A5.11/ASME SFA 5.11 Class ENiCrMo-4 UNS W80276

DESCRIPTION: Alloy C276 welding electrodes are used for SMAW welding of alloy C276 and other Ni-Cr-Mo alloys, as well as dissimilar materials of nickel base alloys, steels and stainless steels. The high Mo content offers strong resistance to stress corrosion cracking, pitting and crevice corrosion.

TYPICAL DEPOSIT CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Co	V	W	Others
.02	15.5	58.6	15.5	.70	.01	.02	.01	5.7	.01	.10	.04	3.9	<.50

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength	108,000 psi (750 MPa)
Elongation	46%

TYPICAL OPERATING PARAMETERS:

Diameter (in/mm)	Amperage	
	Flat	Vertical & Overhead
3/32" (2.4mm)	70-85	65-75
1/8" (3.2mm)	85-110	80-90
5/32" (4.0mm)	110-140	110-120
3/16" (4.8mm)	120-160	110-130

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.