

## INCO-WELD® C-276 Welding Electrode

**INCO-WELD C-276 Welding Electrode** is used for shielded-metal-arc welding of INCONEL alloy C-276 and other nickel-chromium-molybdenum alloys. It is also used for surfacing of steel. The weld metal has excellent corrosion resistance in many media and is especially resistant to pitting and crevice corrosion. INCO-WELD C-276 Welding Electrode is useful for various dissimilar joints involving nickel alloys, stainless steels, and low-alloy steels.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

### Specifications

AWS A5.11 ENiCrMo-4 (UNS W80276)

ASME II, Part C, SFA-5.11, ENiCrMo-4 (UNS W80276)

ASME IX, F-No.43

\*DIN 1736 EL-NiMo15Cr15W (2.4887)

\*(EN) ISO 14172 - ENi6276 (NiCr15Mo15Fe6W)

\*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications

please refer your inquiry to the Technical Department prior to order placement.

### Approvals

Canadian Welding Bureau

Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition	Ni+Co ..... Remainder		Cu ..... 0.50 max.
	C ..... 0.02 max.		Co ..... 2.5 max.
Mn ..... 1.0 max.		Cr ..... 14.5-16.5	
Fe..... 4.0-7.0		Mo ..... 15.0-17.0	
P ..... 0.04 max.		V.....0.35 max.	
S ..... 0.03 max.		W ..... 3.0-4.5	
Si ..... 0.2 max.		Others ..... 0.50 max.	

Minimum Mechanical Properties	Tensile Strength, psi	100,000
	MPa	690
Elongation, (4d) %	25	

**Available Product Forms** – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 12	356 14	356 14	356 14
Current (DC+)	A	40-65	60-90	90-125	125-150