

# MIG/MAG solid wires-TIG rods Nickel and Copper alloys

NIFIL C276 is an S Ni 6276 / ER NiCrMo-4 type solid MIG welding wire, supplied precision layer wound, depositing NiCr15Mo15Fe6W4 weld metal. Suitable for use with inert shielding gases.

NIFIL C276 is used for welding of CrMoW alloyed nickel alloys, matching with Alloy C276. Depending on the corrosion requirements also applicable foe welding of C22 and C4. The Ni-CrMoW weld metal offers good corrosion resistance in wide range of aggressive organic and inorganic acid media. Also suitable for dissimilar welds and overlays on other high nickel and ferrous alloys, including duplex stainless steels.

NIFIL C276 is used for welding plate, pipework, vessels and tanks where general corrosion and stress corrosion cracking resistance in chemical and petrochemical plant, offshore gas and oil equipment and fuel gas desulphurisation plant.

Classif	Classification					
EN ISO	18274: S Ni 6276 (NiCr15Mo16Fe6W4)					
AWS	A5.14: ER NiCrMo-4					

## **Chemical analysis (Typical values in %)**

	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Fe	Co	V	W
0.0	005	0.5	0.05	0.02	0.005	16	58	16	0.05	6	<1.0	0.2	3.5

### **All-weld metal Mechanical Properties**

Heat Treatment		Yield Strength	Tensile Strength	Elongation		
		(MPa)	(MPa)	A5 (%)		
	As Welded	> 500	> 740	> 43		

Gas test: 30 % He + 2 % H2 + 0,05 % CO2, rest Ar

**Shielding Gas -** EN ISO 14175 : I1, I3

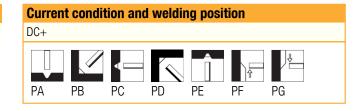
#### **Materials**

Alloy C276; UNS N10276; ASTM B575; B626

NiMo16Cr15W (2.4819)

#### **Storage**

Keep dry and avoid condensation.



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