Inweld HAS C276

AWS A5.11 ENiCrMo-4

Chemical Composition of Inweld HAS C276

C	Mn	Fe	P	S	Si	Cu	Co	Cr	Mo	V	W	Other	Ni
0.02	1.0	4.0-7.0	0.04	0.03	0.2	0.50	2.5	14.5-16.5	15.0-17.0	0.35	3.0-4.5	0.50	Balance

Single values are maximum unless otherwise specified.

Description and Applications

ENiCrMo-4 is typically used for welding metals of a similar composition. It can also be used for dissimilar welding between nickel base alloys and stainless steel including cladding opperations.

These electrodes are also intended for welding low carbon nickel-chromium-molybdenum alloy to steel and other nickel-base alloys. These electrodes are also intended for flat and horizonal position welding.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Average As-Welded Hardness:	
Tensile Strength:	100,000
Yield Strength:	690
Elongation:	25%

Recommended Parameters

SMAW

Wire Diameter	Voltage	Amperage
3/32	24-28	70-85
1/8	26-30	85-110
5/32	28-32	110-140