Inweld HAS C276

AWS A5.14 ERNiCrMo-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

Inweld HAS C276 is a welding wire that is used for GTAW and GMAW processes of nickel alloys with chromium and molybdenum, similar to base metals of a similar chemical composition as UNS 10276. This grade is also used for welding nickel alloys to dissimilar base metals such as stainless steel or low alloy steels. Inweld HAS C276 is also used for overlay cladding of low alloy or carbon steel to provide general corrosion resistance and due to the high moly content, it has strong resistance to stress corrosion cracking, pitting and crevice corrosion.

Procedure

Typical Weld Metal Properties

	AWS Spec (ksi)
Tensile Strength:	100,000
Yield Strength:	690
Elongation:	25%

Recommended Parameters

GMAW

Wire Diameter	Voltage	Amperage
0.035	26-29	150-190
0.045	28-32	180-220
1/16	29-33	200-250

GTAW

Wire Diameter	Voltage	Amperage
0.035	12-15	60-90
0.045	13-16	80-110
1/16	14-18	90-130
3/32	15-20	120-175
1/8	15-20	150-220