



Characteristics and scope of application

- Filler metal for Alloy C276 and other corrosion resistant alloys
- Applicable in Sulfur and Chlorine containing media up to 400°C
- Recommended for cladding and dissimilar welds of wrought and cast material grades in the chemical and petrochemical industry.

Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6276 (NiMo16Cr15Fe6W4)	ERNiCrMo-4	2.4886

Typical chemical composition of filler metal

	C	Cr	Mo	Ni	Fe	W	Mn
Mass %	<0.01	16	16	Bal.	5.0	4.0	0.5

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	R _{p0.2}	R _m	A ₅	ISO-V	
as welded	450 MPa	750 MPa	35%	100 J	

Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H ₂)
Low heat input required. Stringer bead technique recommended. Reducing shielding gases are preferable for welding of corrosion resistant alloys.	
Base materials	
2.4819 - NiMo16CSG-AH5Fe6W4 - Alloy C276 – UNS N10276	
2.4610 – NiMo16CSG-AH6Ti – Alloy C4 – UNS N06455	
1.4583 – X10CrNiMoNb18-12	

Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	x 36 in	11 / 22
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25