



### Characteristics and scope of application

- Filler metal for Alloy C276 and other corrosion resistant alloys
- Suitable for Sulphur 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 <sub>p0.2</sub>	R <sub>m</sub>	A <sub>5</sub>	ISO-V	
as welded	450 MPa	750 MPa	35%	100 J	

### Welding instructions

Polarity	Shielding gas acc. to DIN EN ISO 14175
DC / +	I1, I3, Z (ArHeHC-30/2/~0.1)
DC / -	I1, I3, R1 (max. 5% H <sub>2</sub> )
Low heat input required. Stringer bead technique recommended. Reducing shielding gases are preferable for welding of corrosion resistant alloys.	
Base materials	
2.4819 - NiMo16Cr15Fe6W4 - Alloy C276 – UNS N10276	
2.4610 – NiMo16Cr16Ti – Alloy C4 – UNS N06455	
1.4583 – X10CrNiMoNb18-12	

### Packaging (tolerances acc. to DIN EN ISO 544)

Approvals on request

Diameter (mm)		Kg
1.6 / 2.0 / 2.4 / 3.2	X 1000 mm	5 / 10
0.8 / 1.0 / 1.2	BS 300 spool	15
1.6 / 2.4 / 3.2	K 415 / K 435 spool	25

