

UTP 776 Kb

Standards :

Material-No.	: 2.4887
EN ISO 14172	: E Ni 6276 (NiCr15Mo15Fe6W4)
AWS A5.11	: E NiCrMo-4

Basic coated stick electrode for high corrosion resistant NiCrMo alloys (C-276)

Application field

Joint welding of matching base materials, as Material-No.2.4819 (NiMo16Cr15W) and surfacing on low-alloyed steels. It is employed primarily for welding components in plants for chemical processes with highly corrosive media, but also for surfacing press tools, punches etc. which operate at high temperatures.

Properties of the weld metal

In addition to its exceptional resistance to contaminated mineral acids, chlorine-contaminated media, and chloride containing media, it resists strong oxidisers such as ferric and cupric chlorides and is one of the few materials which will resist wet chlorine gas.

Welding properties

The stick electrode can be welded in all positions except vertical-down. Stable arc, easy slag removal.

Mechanical properties of the weld metal

Yield strength $R_{p0,2}$ MPa	Tensile strength R_m MPa	Elongation A %	Impact strength K_v Joule
> 450	> 720	> 30	> 70

Approximate weld metal analysis in %

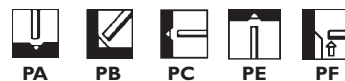
C	Si	Mn	Cr	Mo	Ni	W	Fe
< 0,02	< 0,2	0,6	16,5	16,5	balance	4,0	5,0

Welding instructions

For avoidance of intermetallic precipitation the stick electrode should be welded with lowest possible heat input and minimum interpass temperature. Beam width of the prepared seam approx. 70°, root gap approx. 2 mm. Weld stick electrode with slight tilt and with a short arc. String beads are welded. The interpass temperature of 150° C and a max. weaving width 2,5 x diameter of the stick electrode core wire should not be exceeded. Re-dry the stick electrodes 2 – 3 hours at 250 – 300° C before use and weld them out of a warm stick electrode carrier.

Current type DC (+)

Welding positions



Availability / Current adjustment

Stick electrodes	Ø mm x L	2,5 x 250	3,2 x 300	4,0 x 350
Amperage	A	50 – 70	70 – 100	90 – 130

Approvals

TÜV (No. 05257)