

Wire:
 EN ISO18274:2004: S Ni 6276 (NiCr15Mo16Fe6W4)
 DIN 1736: SG-NiMo16Cr16W
 AWS 5.14-97: ERNiCrMo-4
 W.Nr.: 2.4886
 Flux:
 DIN EN760:1996: SA-FB 2 AC

BÖHLER
NIBAS C 276-UP/BB 444

SAW wire / flux-combination, nickel base

Description

For SAW wire and flux combination, suitable for welding of similar alloyed Ni base steel grades, e.g. N10276, 2.4819, NiMo16Cr15 W as well as for joining these grades with low alloyed and stainless steels 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. 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. Weld with possibly low heat input and low interpass temperature in order to avoid intermetallic precipitations.

BB 444 is an agglomerated fluoride basic welding flux with high basic slag characteristics.

Typical Composition of Solid Wire and All-weld Metal

	C	Si	Mn	Cr	Mo	Ni	T	Fe
SAW wire wt-%	< 0.012	< 0.10	< 0.5	15.5	16.0	bal.	3.8	< 7
all-weld metal %	< 0.012	0.15	< 0.4	15.0	16.0	bal.	3.3	5.5

Mechanical Properties of All-weld Metal

(*)	u	
yield strength R _e N/mm ² :	420	
tensile strength R _m N/mm ² :	710	
elongation A (L ₀ =5d ₀) %:	40	
impact work ISO-V KV J	+20 °C:	80
	-196 °C:	70

(*) u untreated, as-welded

Operating Data



Redrying of sub arc flux:
 400-450 °C/2 h

ø mm
 2.4

Preheat and interpass temp. as required by the base metal



Base Materials

NiMo16Cr15W (2.4819),
 Alloy C-276, UNS N10276, B575, B626
 joint welds of listed materials with low alloy and stainless steels

Approvals and Certificates

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Same Alloy Filler Metals

SMAW: FOX NIBAS C 276
 GTAW rod: NIBAS C 276-IG
 GMAW solid wire: NIBAS C 276-IG