



# CEWELD E Alloy C-276

**TYPE** Stick electrode for welding NiCrMo alloys such as Hastelloy C-276. (Type Ni 6276, E NiCrMo-4)

**APPLICATIONS** **CEWELD® E Alloy C-276** is used for welding materials of similar composition. This low carbon Nickel-Chromium-Molybdenum filler metal can also be used for dissimilar welding between nickel base alloys and stainless steels, as well as for surfacing and cladding on low alloyed steels. Applications include pumps, valves, pipelines and tanks in chemical processing plants, flue gas desulphurization plants and in the offshore oil and gas industry. The simple slag removal reduces the cleaning effort after welding to a minimum.

**PROPERTIES** Thanks to its high molybdenum content, **CEWELD® E Alloy C-276** offers excellent resistance to stress corrosion cracking, pitting and crevice corrosion. It also has high mechanical properties with excellent weldability with DC+. The easy slag removal reduces the cleaning effort after welding to a minimum.

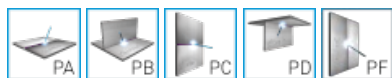
**CLASSIFICATION**

AWS	A 5.11: E NiCrMo-4
EN ISO	14172: E Ni 6276
W.Nr.	2.4887
F-nr	43
FM	6

**SUITABLE FOR** **Alloy 276, Ni 6276 (NiCr15Mo16Fe6W4). 2.4886, 2.4887**  
**M.No:** 1.5680, 1.5682, 2.4819, 2.4883  
 NiMo16Cr15W, X12Ni5 / 12Ni19, X8Ni9, G-NiMo16Cr  
 Alloy C4, Hastelloy C276, A494CW-12MW, A743 / A744CW-12M

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Fe	W
0.01	0.1	0.8	15.5	60	16	5.5	3.2

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	500	760	29	HRc

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E Alloy C-276

E ALLOY C-276 2,4 X 229MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663420466
E ALLOY C-276 3,2 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663420473
E ALLOY C-276 4,0 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663420480