GEN C276 Welding Wire and Rod

GEN C276 is used for welding nickel-chromium-molybdenum to itself, stainless, carbon and low alloy steels. It may also be used for cladding of low alloy or carbon steel to provide general corrosion resistance. GEN C276 provides excellent resistance to both oxidizing and reducing atmosphere.

CONFORMANCES

AWS A5.14	:	ERNiCrMo-4
ASME SFA-5.14	:	ERNiCrMo-4
ISO 18274	:	SNi 6276

AWS CHEMICAL COMPOSITION *(TYPICAL)*

%C	%Cr	%Ni	%Mo	%W	%Fe	%Mn
0.02 max	14.5 – 16.5	rem.	15.0 – 17.0	3.0 – 4.5	4.0 – 7.0	1.0 max
0.005	*15.8*	*58.3*	*15.9*	*3.5*	*5.7*	*0.5*
%Si	**%P**	**%S**	**%Cu**	**%Co**	**%V**	**Total Others**
0.08 max	0.04 max	0.03 max	0.50 max	2.5 max	0.35 max	0.50 max
0.05	*0.005*	*0.001*	*0.1*	*0.2*	*0.03*	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	80,000 psi
Tensile Strength	:	105,000 psi
Elongation	:	36 %

TYPICAL WELDING PARAMETERS*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16”	1.6 mm	14 – 18	90 – 130	100% Ar
	3/32”	2.4 mm	15 – 20	120 – 175	100% Ar
	1/8”	3.2 mm	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035”	0.9 mm	26 – 29	150 – 200	75% Ar – 25% He
	.045”	1.1 mm	28 – 32	180 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093”	2.4 mm	28 – 31	300 – 350	
	.125”	3.2 mm	29 – 33	300 – 350	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED

BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.