



DAIKOFCW C276P



NICKEL ALLOYS

C276

DESCRIPTION

Rutile all position flux cored wire

Rutile flux cored wire for welding and cladding in all positions thanks to the fast-freezing slag that matches the composition and properties of alloy C276. It is also used for surfacing of steel. The weld metal has high resistance in a wide range of media and exceptional resistant to pitting and crevice corrosion. Applications include pumps, valves, pipework and vessels in chemical process plant, equipment for flue gas desulphurisation and for offshore in oil & gas field. Useful properties from -269°C to above 1000°C are achieved.

SPECIFICATIONS

| | | | |
|----------------|----------------------------|------------------|--------------|
| ISO | - | AWS A5.34 | ENiCrMo4T1-4 |
| DIN | - | Werkstoff Number | - |
| Certifications | - | Shielding | M21 |
| Positions | PA, PB, PC, PD, PE, PF, PG | Current | DC+ |

ASME QUALIFICATIONS

| | |
|--------------|----|
| F-No (QW432) | 43 |
| A-No (QW442) | - |

FERRITE

| |
|---|
| - |
|---|

PREN

| |
|-------|
| 73.74 |
|-------|

HARDNESS

| |
|---|
| - |
|---|

CHEM. COMP. %

DEFAULT

| | |
|----|-------|
| C | 0.015 |
| Mn | 0.6 |
| Ni | 58 |
| Cr | 15 |
| P | 0.007 |
| S | 0.004 |
| Mo | 16 |
| Si | 0.2 |
| Cu | 0.03 |
| Fe | 5.3 |
| W | 3.6 |

MECHANICAL PROPERTIES

| | MIN | VARIANT |
|---|-----|--------------|
| Tensile strength R _m MPa | - | 690 |
| Yield strength R _{p0.2} MPa | - | 400 |
| Elongation A (L ₀ =5d ₀) % | - | 25 |
| Impact Charpy ISO-V | - | 47J @ -196°C |
| Impact Charpy ISO-V | - | - |

WELDING PARAMETERS

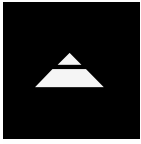
| | 1.2 mm | 1.6 mm |
|----------------|-------------|-------------|
| Ampere | 130A - 280A | 200A - 350A |
| Voltage | 22V - 30V | 28V - 32V |
| Packaging | Ø 1,2÷1,6mm | Ø 1,2÷1,6mm |
| Packaging Type | BS300 spool | BS300 spool |

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.





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APPLICATION

The deposited weld replicates the composition of parent alloy C276, comprising Ni-15%Cr-16%Mo-4%W-5%Fe. Precise control over C and Si levels is implemented to minimize carbide and intermetallic phase precipitates. While cast versions may have higher carbon and silicon content, repair welds typically undergo solution treatment for optimum corrosion resistance. Alloy C276 exhibits high resistance to corrosion in a broad range of acids and salts under oxidizing and reducing conditions, including hydrochloric and hydrofluoric acids, hypochlorites, chlorides, wet chlorine gas, sulphuric, phosphoric, and various organic acids. Noteworthy is its exceptional resistance to crevice corrosion, pitting in seawater (surpassing alloy 62), and chloride-induced stress corrosion cracking. With excellent properties extending to below -196°C, Alloy C276 finds applications in welding 5-9%Ni cryogenic installations. Its versatile use includes pumps, valves, pipework, and vessels in aggressive chemical plant environments, as well as equipment for flue gas desulphurization and critical offshore oil and gas production equipment. Importantly, preheating is unnecessary, and it is advisable to keep the interpass temperature below 100°C, with a restricted heat input to 1.5 kJ/mm.

ALLOY TYPE

Alloy C276 is a Ni-15%Cr-16%Mo-4%W-5%Fe nickel base alloy.

MICROSTRUCTURE

In the as-welded condition the weld metal consists of austenite with some carbides.

MATERIALS

EN W.Nr.: 2.4819 (NiMo16Cr15W), 2.4883 (G-NiMo16Cr).

ASTM: A494 CW-12MW, A743/A744 CW-12M.

UNS: N10276.

PROPRIETARY: Hastelloy® Alloy C-276 (Haynes International Inc), Inconel® Alloy C-276 (Special Metals), Nicrofer 5716hMoW (VDM).

