



# DAIKOSTRIP C276

SAW - ESW

NICKEL ALLOYS

C276

## PRODUCT DESCRIPTION

**It is a welding strip designed to deposit alloy C276 in combination with DAIKOSTRIP 59.**

It is employed primarily 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.

## SPECIFICATIONS

AWS A5.14	EQNiCrMo-4
EN ISO	-
DIN	-
Approvals	-
Shielding	DAIKOFLUX 940, 944, 942AS

## ASME IX QUALIFICATION

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

## FERRITE

-

## PREN

73

## HARDNESS

-

## Typical

	C	Mn	Si	Cr	Ni	Mo	Fe	W
DAIKOSTRIP C276	0.002	0.5	0.02	15.4	58	15.6	5.5	3.8

## Typical weld metal analysis of strip/flux combination (weight%)

Electroslag strip cladding with DAIKOFLEX 944 on 0.2% C-steel.

	C	Mn	Si	Cr	Ni	Mo	Fe	W
1st Layer DAIKOSTRIP 59	0.019	0.2	0.4	19.2	Bal.	14.1	12.1	-
2nd Layer DAIKOSTRIP C276	0.011	0.31	0.11	16.3	Bal.	16.9	6.1	2.95