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Perth	08 9258 2600	08 9358 6206

PRODUCT DATA SHEET

INCO C-276 Welding Filler Metal UNS N10276

Nickel Alloy Welding Consumable

Chemical Composition (deposited weld metal)

Element	%	Element	%
Nickel	Remainder (~60)	Carbon	0.02 max
Chromium	14.5 – 16.5	Copper	0.50 max
Molybdenum	15.0 – 17.0	Manganese	1.0 max
Iron	4.0 – 7.0	Phosphorus	0.04 max
Tungsten	3.0 – 4.5	Silicon	0.08 max
Cobalt	2.50 max	Sulphur	0.03 max
		Vanadium	0.35 max

Inco Filler Metal G276 is used for gas tungsten arc and gas metal arc welding of Inco alloy C-276 and other nickel chromium molybdenum alloys. It is also used for surfacing of steel.

The weld metal has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion.

Dissimilar welding applications include welding alloy G-276 to other nickel alloys, to stainless steel and low alloy steels.

Welding consumables are also available for the gas metal arc and submerged arc processes.

Typical Mechanical Properties (All Weld Metal, As Welded)

Tensile Strength	Elongation
MPa	%
690	–

Sizes and Welding Parameters

Diameter, mm	0.6	0.8	1.2	1.6
Wire feed, m/min	14 - 18	11.5 – 15.2	6.4 – 9.0	3.2 – 5.7
Voltage	26 - 32	26 - 32	26 - 32	27 – 33
Current, amps	175 - 240	180 - 245	225 - 330	250 – 345

Availability: MIG: 0.8 to 1.6 mm on spools weighing from 0.7 to 15 kg
TIG: 0.8 to 3.2 mm, 914 mm long in 4.54 kg packs and 1000 mm long in 5 kg packs
SAW: 1.6 to 3.2 mm in 12.5 to 30 kg spools and coils

Specifications

AWS A5.14 ENiCrMo-4

DIN 1736 SG-NiCr23Al
Werkstoffe Nr 2.4886

ASME SFA-5.14 ENiCrMo-4
ASME F44