

Nickel Base Alloy SMAW Electrodes

GNI 276

AWS A5.11 ENiCrMo-4
ISO 14172-E Ni 6276
JIS Z 3224 E Ni 6276

Product Features:

- Low hydrogen type nickel base electrode for DC+ only.
- Easy slag removal, good bead appearance and low spatters.
- Due to high Mo content which offer excellent corrosion resistance in many aggressive media and is especially resistant to stress cracking, pitting and crevice corrosion.

Applications:

- Used for welding of Hastelloy C-276 and other nickel-chromium-molybdenum alloys and stainless steels as well as for surfacing and cladding.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Cr	Mo	W	Fe
0.018	0.08	0.32	59.61	15.10	15.70	3.53	5.66

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
512	740	35

Size (mm) & recommended welding parameters (A)

Diameter	2.6/300	3.2/350	4.0/350
Flat position	65~85	80~110	95~150

Note:

1. 300 ~ 350°C x 1hr baking prior to use.
2. During welding, low welding current is recommended in order to avoid covered flux burn.
3. Proper cleaning of welding area before welding and complete removal of spatter after welding.
4. Inter-pass temperature shall keep below 150 °C.

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved


GOODWELD
www.goodweld.com.tw