

Nickel Base Alloy MIG•TIG Wire / Rod

GTN276 / GMN276

AWS A5.14 ERNiCrMo-4
ISO 18274-S Ni 6276
JIS Z 3334 S Ni6276

Product Features:

- The weld metal contains high Mo content which has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion, stress-corrosion cracking and oxidizing in atmospheres up to 1,900°F. Nickel alloy bare wire is used for GTAW and GMAW.

Applications:

- Used for gas-tungsten-arc welding of INCONEL alloy C-276 and other nickel-chromium-molybdenum alloys. It is also used for cladding steel.

Shielding gas:

- Ar + 0.5~2.0%O₂ (GMAW)
- 100% Ar (GTAW)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	W	Fe
0.004	0.01	0.21	0.003	0.001	59.4	15.58	16.57	3.38	4.81

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
726	51

MIG wire size (mm) & recommended welding parameters (A)

Diameter	0.9/1.0	1.2	1.6
Current range	70~180	100~220	180~280

TIG rod size diameter/length

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	1000	1000	1000	100

Note:

Recommend pulse or spray arc (low current) for RT examination purpose.

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