

**Technical data sheet**

011121MBA

**Cored welding wire  
GAMMA 276****CLASSIFICATION**

AWS A5.34 / AWS A5.34M: ENiCrMo4T0-4 / TNi6276-04  
 EN ISO 12153: T Ni6276 (NiCr15Mo15Fe6W4) B M21 3

**DESCRIPTION**

- Special flux cored nickel base wire for gas shielded arc welding
- Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal
- Meets the NiCrMo-4 requirements
- Together with enhanced productivity, GAMMA 276 offers many other advantages compared to solid wires: improved weldability, almost no spatter, better arc stability, improved wetting properties, better bead appearance and shape, and use of classical M21 gas mixtures

**APPLICATIONS**

GAMMA 276 is suitable for welding and cladding nickel-based alloys such as alloy 276 or similar materials. It is also used for dissimilar welding of nickel-based alloys to each other, to alloyed steels or to stainless steels and for joining 5 % or 9 % nickel steel.

**Examples:**

Alloy	UNS	EN Designation	Material Number
276	N10276	NiMo16Cr15W	2.4819
5% Ni steel		X12Ni5 / 12Ni19	1.5680
9% Ni steel	K81340	X8Ni9	1.5662

Cast materials: A494CW-12MW, A743 / A744CW-12M, Material Number 2.4883 / G-NiMo16Cr

**TYPICAL ALL-WELD METAL ANALYSIS [%]**

C	Mn	Si	Cr	Mo	W	Fe	Ni
0.015	0.4	0.2	16	16	4.0	5.0	Bal.

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
690	400	25	-196°C: 47

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
740	500	30	-196°C: 60

**SHIELDING GAS**

EN ISO 14175: M21 (Ar + 15 - 25% CO<sub>2</sub>)

**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+	130 - 250	24 - 32	12 - 25	10 - 20
1.6	DC+	150 - 300	24 - 32	12 - 25	10 - 20

**WELDING POSITIONS**

Flat, Horizontal

**PACKAGING**

Diameter	1.2 mm	1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M: BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.