


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA GAMMA 276-E	
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CLASSIFICATION

ASME II C SFA 5.11 / AWS A 5.11: ENiCrMo-4
EN ISO 14172: E-Ni6276 (NiCr15Mo15Fe6W4)
Material number: 2.4887

DESCRIPTION

- Basic coated electrode giving a fully austenitic NiCrMoW deposit
- Highly resistant to corrosion in reducing (chlorine environment) and oxidising media
- Exceptional resistant to hot cracking
- Service temperatures from -196°C to 900°C
- Complements Welding Alloys cored wire GAMMA 276

APPLICATIONS

- Wide range of application including joints between mild or low alloyed steels and nickel alloys, hardfacing on wrought alloys, and hardfacing or repair of hot working tooling

Base materials

UNS	Alloy	DIN	Material N°
N10276	C-276	NiMo16Cr15W	2.4819
N06455	C-4	NiMo16Cr16Ti	2.4610
N06625	625	NiCr22Mo9Nb	2.4856
N08825	825	NiCr21Mo	2.4858
N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Mo	W	Fe	V	Ni
<0.02	0.20	0.60	16.5	16.0	4.00	5.00	0.15	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A5 [%]	CVN [J]
>720	>450	>30	+20°C: >100

OPERATING CONDITIONS

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350
Current [A]	50-70	70-100	90-120
= +	70 V		

Re-drying :2 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks.

Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2G, 2F, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350
Weight/box [kg]	4	5	5

Other packaging and other sizes: 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.