

# HASTELLOY® C-276 Coated Electrodes

## Product Description:

HASTELLOY® C-276 coated electrodes are used for the shielded metal arc welding of C-276 alloy. The deposited weld metal has excellent corrosion resistance in many media including oxidizing and reducing environments. In addition, the alloy has outstanding resistance to pitting and crevice corrosion. The alloy is a good candidate for dissimilar joining of other nickel-chromium-molybdenum alloys, stainless steels and carbon steels. The electrodes can be used for overlay and cladding of steels as well. The coating is developed for great operability in all positions, especially out-of-position welding.

## Specifications:

AWS A 5.11 ENiCrMo-4      ASME IX F-43  
ASME SFA 5.11 ENiCrMo-4    UNS W80276  
Kennblatt 0319.05  
\*Specify at time of order

## Composition:

<b>Nickel:</b>	Balance	<b>Copper:</b>	0.50 max.
<b>Molybdenum:</b>	15.0-17.0	<b>Other:</b>	0.50 max.
<b>Chromium:</b>	14.5-16.5	<b>Vanadium:</b>	0.35 max.
<b>Iron:</b>	4.0-7.0	<b>Silicon:</b>	0.20 max.
<b>Tungsten:</b>	3.0-4.5	<b>Carbon:</b>	0.02 max.
<b>Cobalt:</b>	2.5 max.	<b>Sulfur:</b>	0.03 max.
<b>Manganese:</b>	1.0 max.	<b>Phosphorus:</b>	0.04 max.

## Minimum Mechanical Properties:

<b>Tensile (psi)</b>	100,000
<b>Mpa</b>	690
<b>Elongation (%)</b>	25

## Available Product Forms and Sizes:

<b>Diameter in</b>	0.093	0.125	0.156	0.187
<b>Diameter mm</b>	2.40	3.20	4.00	4.70
<b>Length in</b>	10	14	14	14
<b>Length mm</b>	254	355.6	355.6	355.6
<b>Package Weight lbs.</b>	5	10	10	10
<b>Current (A) DCEP</b>	40-70	70-100	80-140	120-150