

MMA Electrodes Nickel and Copper alloys

Low-hydrogen MMA electrode suitable for all positional welding; Supranel C276 electrodes are used for welding low carbon Ni-Cr-Mo alloy, for the weld overlay of steels clad with these alloys, and for welding this nickel alloy to steels and to other nickel base alloys. High resistance to corrosion in oxidizing environments to 1100°C.
Efficiency 100%.

Classification

AWS	A5.11: E NiCrMo-4
EN ISO	14172: E Ni 6276

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.02	1	0.20	≤ 0.040	≤ 0.030	15.60	Rem	16	-	5	3.40	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 400	≥ 690	≥ 25	≥ 55	-

Materials

ASTM B574; B575; B619; B622

UNS N10276; HASTELLOY C276

Storage and redrying

Keep dry and avoid condensation.

Re-dry at 300-350 °C for 2 hours, 5 times max

Current condition and welding position

DC +



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	350	50-70	17,7	12,0
3,2	350	75- 95	36,9	25,0
4,0	350	85-120	50,0	42,0