Technical data sheet 011121MBA	Cored welding wire # GAMMA V 276	Welding Alloys

CLASSIFICATION

AWS A 5.34 / AWS A 5.34M: ENiCrMo4T1-4 / TNi6276-14
EN ISO 12153: T Ni 6276 (NiCr15Mo15Fe6W4) P M21 1

DESCRIPTION

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

APPLICATIONS

GAMMA V 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 and for joining superaustenitic stainless steels

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	0.6	0.1	16	16	4.0	5.0	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
690	400	25	-196°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
740	500	30	-196°C: 60

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15% < CO_2 ≤ 25%)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+	130 – 220	24 - 32	12 - 25	10 - 20

WELDING POSITIONS

All positions

PACKAGING

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

Other packaging and other diameters: please consult us