

**DATA SHEET N. 1040**

## DAIKO C276

### SMAW electrode

Description / Alloy type: Basic coated flux electrode FOR NICKEL BASE ALLOY C276

Specifications: **AWS A5.11** **EN ISO 14172**  
ENiCrMo-4 ENi 6276

Applications: It is designed to match the composition and properties of alloy C276. It is also used for surfacing of steel.  
The weld metal has high resistance in a wide range of media and exceptional resistant to pitting and crevice corrosion.  
Applications include pumps, valves, pipework and vessels in chemical process plant, equipment for flue gas desulphurisation and for offshore in oil & gas field.

Materials to be welded: **Matching Alloy 625**  
ASTM/ASME: UNS N10276; A494 CW-12MW (cast).  
DIN: 2.4819  
Proprietary Alloy: Hastelloy C-276; Inco Alloy C-276; Nicrofer 5716hMoW

Composition  
(weight %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Fe	V	Cu	Co
Min	-	-	-	-	-	14.5	50	15	3.0	4.0	-	-	-
Max	0.02	1.0	0.2	0.015	0.02	16.5	-	17	4.5	7.0	0.35	0.50	2.5
Typ	0.02	0.3	0.2	0.010	0.01	15	58	16	4.0	5.0	0.10	0.05	0.05



Welding positions:

Current (DC+): d. 2.5mm **40-65A**; d. 3.2mm **60-90A**; d. 4.0mm **90-125A**; d. 4.8mm **125-150A**;

All-weld proprieties:

As welded	Min	Typical
Tensile strength [MPa]	700	780
0.2% proof stress [MPa]	400	520
Elongation [%]	25	30
Impact Energy -196°C [J]	-	55

Complementary products: MIG, TIG & SAW wire (AWS A5.14 ERNiCrMo-4)  
Cladding strip (AWS A5.14 EQNiCrMo-4)  
ESW Flux; SAW flux.