

DESCRIPTION

Executive C-276 is a nickel-chromium-molybdenum alloy designed for welding alloy C-276 and other similar alloys using MIG, TIG and SAW welding processes. The weld metal has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion.

Executive C-276 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand. Use Executive 57/15/16 where flux cored wire is suited to the application.

APPLICATIONS & FEATURES

Executive C-276 is a versatile filler metal that is used for surfacing steel as well as joining C-276 material to itself and to other molybdenum bearing nickel alloys, stainless steels and low alloys steels.

Executive C-276 can also be used to weld ASTM B574, B575, B19, B622, and B628 materials.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	W	Co	Cr	V	Mo
0.01	0.50	5.7	0.004	0.001	0.05	0.02	58.1	3.7	<0.01	15.7	<0.01	15.9

Tensile Strength: 100,000 PSI Min **Yield Strength:** **Elongation:** 30%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar
	.045"	19-22	75-160		75% Ar / 25% He
	- Spray .045"	30-32	190-250		90% He / 7.5% Ar / 2.5% CO ₂
	- Pulse .045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.062"	28-32	250-280		NiCr-W Flux
	.093"	28-33	275-350		
	.125"	29-34	350-450		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	
	60-lb Acro Pak	

CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCrMo-4**

