

GEMET 3276



IDENTIFICATION : Name printed GEMET 3276

CLASSIFICATION :AWS/SFA 5.11 ENiCrMo5 DIN 1736 EL-NiMo 15Cr15W (2.4887)

CHARACTERISTICS :

Heavy coated, basic type electrode depositing Ni-15 Cr-16 Mo-4W-5Fe weld metal. Carbon and Silicon are controlled to the very low levels so as to minimize carbide and intermediate phase precipitation.

APPLICATIONS :

- Wrought alloys ASTM UNS N 10276
- DIN 2.4819 (Ni Mo16 Cr 15W)
- Haste alloy Alloy C-276(Haynes)
- Inco Alloy C-276
- ASTM A494 CW-12MW
- ASTM A743, A744 CW-12M
- Pumps, valves, pipe work and vessels for use in aggressive environment in chemical process plants, equipment for fuel gas de-sulphurisation.
- Fabrication and repair of hot pressing tools.
- Surfacing of parts subject to abrasion.
- Oxidation and corrosion.
- Drop forge dies, hot trimming dies,
- joining of heating elements.

Redrying Temp : 300°C/2hrs

Hardness :

As welded: 20-24 RC

work hardened: 42-48 RC

ASME IX Qualification :

QW-432 F-No 44, QW-442 P-No 44

RECOMMENDED CURRENT AND PACKING DATA :

C	Mn	Si	S	P	Cr	Mo
0.05-0.12	0.4-0.9	0.2-0.6	0.025 max	0.03 max	2.0-2.50	0.90-1.25

ALL WELD MECHANICAL PROPERTIES PWHT 690°C/1hr:

Ultimate Tensile Strength MPa	0.2% Proof stress MPa	Elongation (%) (L=4D)
620-740	530-620	17-24

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS DC(+)	PACKING/CARTON (KG.)
2.50	350	60-85	2 x 5 = 10
3.15	350	75 - 110	2 x 5 = 10
4.00	350	110 - 150	2 x 5 = 10