

MIDALLOY NI-MAX 276 COATED ELECTRODE

CLASSIFICATION

- AWS/SFA 5.11 Class ENiCrMo-4/ASME SFA 5.11 Class ENiCrMo-4 ASME SEC IX, F44

DESCRIPTION

- Midalloy NI-MAX 276 coated electrode is an all-position coated electrode used for joining alloys listed under UNS number N10276 and other nickel-chromium-molybdenum alloys.
- UNS# W80276
- ISO 14172 comparison ENi6276
- These electrodes can also be used in dissimilar applications involving nickel-chromium-molybdenum alloys welded to stainless steels, or low alloy steels, as well as for overlay where a similar composition is required on the clad side.

APPLICATION

- NI-MAX 276 is used in a wide range of severe environments due to excellent corrosion resistance.
- High molybdenum content makes the weld metal especially resistant to pitting and crevice corrosion.
- Applications include pollution control, chemical processing, pulp and paper, and waste treatment.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Mo	V	W	Others
.02	.24	6.02	.012	.006	.09	.20	58.0	.13	15.95	15.5	.02	3.63	<.5

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	105,000 PSI
YIELD STRENGTH	79,000 PSI
ELONGATION IN 2"	39%

RECOMMENDED WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
PROCESS	SMAW	SMAW	SMAW	SMAW
VOLTAGE	24-28	26-30	28-32	28-32
AMPERAGE FLAT	70-85	65-100	110-140	120-160
AMPERAGE VERTICAL/OVERHEAD	65-75	65-90	100-120	110-130

STANDARD PACKAGING

- 3/32" – 8 lb. Can, 48 lb. Carton
- 1/8", 5/32", 3/16" – 10 lb. Can, 60 lb. Carton

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Office and Corporate Warehouse
 630 Axminister Drive
 Fenton, MO 63026 • 636-349-6000 • 800-776-3300
 Fax 636-349-2240

