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
<table>
<thead>
<tr>
<th>C</th>
<th>Mn</th>
<th>Fe</th>
<th>P</th>
<th>Si</th>
<th>Cu</th>
<th>Ni</th>
<th>Co</th>
<th>Cr</th>
<th>Mo</th>
<th>V</th>
<th>W</th>
<th>Others</th>
</tr>
</thead>
<tbody>
<tr>
<td>.02</td>
<td>.24</td>
<td>6.02</td>
<td>.012</td>
<td>.006</td>
<td>.09</td>
<td>58.0</td>
<td>.13</td>
<td>15.95</td>
<td>15.5</td>
<td>.02</td>
<td>3.63</td>
<td>&lt;.5</td>
</tr>
</tbody>
</table>

TYPICAL MECHANICAL PROPERTIES
- TENSILE STRENGTH: 105,000 PSI
- YIELD STRENGTH: 79,000 PSI
- ELONGATION IN 2": 39%

RECOMMENDED WELDING PARAMETERS

<table>
<thead>
<tr>
<th>DIAMETER</th>
<th>3/32&quot;</th>
<th>1/8&quot;</th>
<th>5/32&quot;</th>
<th>3/16&quot;</th>
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</thead>
<tbody>
<tr>
<td>PROCESS</td>
<td>SMAW</td>
<td>SMAW</td>
<td>SMAW</td>
<td>SMAW</td>
</tr>
<tr>
<td>VOLTAGE</td>
<td>24-28</td>
<td>26-30</td>
<td>28-32</td>
<td>28-32</td>
</tr>
<tr>
<td>AMPERAGE</td>
<td>70-85</td>
<td>65-100</td>
<td>110-140</td>
<td>120-160</td>
</tr>
<tr>
<td>VERTICAL/OVERHEAD</td>
<td>65-75</td>
<td>65-90</td>
<td>100-120</td>
<td>110-130</td>
</tr>
</tbody>
</table>

STANDARD PACKAGING

12-1-08

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