

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

12-1-08

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such products at any time without notice.

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

