

Strip Electrode for Electroslag Overlay Welding

BA-STRIP 276

Classification:EN ISO 18274:
SFA-5.14:**B Ni 6276**
EQNiCrMo-4**Main Application:**

BA-STRIP 276 is a strip electrode for electroslag overlay welding (ESW). Used to obtain Nickel-Chromium-Molybdenum corrosion resistant overlay on mild steel and low alloy steels. The overlay is highly corrosion resistant and exhibits excellent resistance against pitting and crevice corrosion.

Typical analysis and chemical composition acc. to EN ISO 18274 and AWS A5.14:

(Weight Percent)

Strip electrode	Ni	Si	C	Cr	Mn	W	Fe	Co	V	Mo	S	P	Cu total	Others
Typical analysis BA-STRIP 276	58.0	0.03	0.008	15.8	0.4	3.7	5.8	0.09	0.06	15.8	0.004	0.005	0.03	< 0.50
B Ni 6276 acc. to ISO 18274	≥ 50.0	0.08	0.02	14.5 – 16.5	1.0	3.0 – 4.5	4.0 – 7.0	2.5	0.3	15.0 – 17.0	0.015	0.020	0.5	0.5
EQNiCrMo-4 acc. to AWS A5.14	Bal.	0.08	0.02	14.5 – 16.5	1.0	3.0 – 4.5	4.0 – 7.0	2.5	0.35	15.0 – 17.0	0.03	0.04	0.50	0.50

Base Materials:

Mild steels and low alloy steels.

Suitable flux: BF 46

Flux type suitability is strongly dependent on its application. In combination with the strip electrode the most suitable flux should match the requirements of the plate material as closely as possible under the existing welding conditions. Further information can be obtained from the technical flux data sheets.

Package Forms:

Coils or wound spools as standard package forms for strip electrodes.

Dimensions:30 x 0.5 mm, 60 x 0.5 mm; sizes and tolerances acc. to ISO 544 and AWS A5.14.
Other dimensions on request.**Strip Electrode Surface:**

Smooth finish free from surface defects and foreign matter.