

Solid Wire Electrode for Submerged Arc Welding

BA-WIRE 276

Classification: EN ISO 18274 – S Ni 6276
SFA-5.14 – ERNiCrMo-4

Typical analysis and chemical composition acc. to EN ISO 18274 and AWS A5.14: (Weight Percent)

Wire electrode	Ni	Si	C	Cr	Mn	W	Fe	Co	V	Mo	S	P	Cu total
Typical analysis BA-WIRE 276	58.0	0.03	0.008	15.8	0.4	3.7	5.8	0.09	0.06	15.7	0.004	0.005	0.03
S 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
ERNiCrMo-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

Application:

BA-WIRE 276 welding wire has been developed for welding INCONEL alloy C-276 and other nickel-chromium molybdenum alloys, cladding steel, welding carbon steel to nickel base alloys and stainless steels to nickel alloys. The weld metal is highly corrosion resistant and exhibits excellent resistance against pitting and crevice corrosion as well as high strength and toughness. Very good mechanical properties down to –196 °C.

Base Materials:

- INCONEL alloy C-276, ASTM B 574, B 575, B 619, B 622 and B 628 having UNS number N10276.
- 5 to 9 % Ni steels for cryogenic service.

Suitable fluxes: BF 38, WP 380

Flux type suitability is strongly dependent on its application. In combination with the wire 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, spools, drums and spiders as standard package forms for SAW-wire electrodes, different package forms on request.

Diameter:

1.2 – 2.0 mm; sizes and tolerances acc. to ISO 544 and AWS A5.14.

Wire electrode surface:

Smooth finish free from surface defects and foreign matter.