

SMT-276

Conformances

AWS A5.14/ ASME SFA5.14 ERNiCrMo-4
 JIS Z3334 SNi6276 (NiCr15Mo16Fe6W4)
 EN ISO 18274 S Ni 6276
 ABS AWS A5.14 ERNiCrMo-4

Applications

- LNG and LPG storage plant, Boilers of the thermal power station
- Aggressive environments in chemical process plants

Features

- Good corrosion-resistant
- No preheat is required
- Interpass temperature should preferably be kept below 100°C and input restricted to 1.5KJ/Min

Welding Position

Current

GMAW: DC+(Pulse)
 GTAW: DC-

Shielding Gas

Ar, Ar + He

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.6lbs)	5kg (11lbs)
1.0 (0.040)	✓	
1.2 (0.045)	✓	
1.4 (0.052)	✓	
1.6 (1/16)	✓	
2.0 (5/64)		✓
2.4 (3/32)		✓
3.2 (1/8)		✓

Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	W
0.01	0.05	0.5	0.003	0.01	15.0	57.0	16.0	4.0

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
-	750 (109,000)	33.0		

Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC+	
Ar, Ar + He	160	28
	2.4mm (3/32 in) DC-	
Ar	110	12