



Tech-Rod 276

Description: Tech-Rod 276 is used for welding materials of similar composition. This low carbon, nickel-chromium-molybdenum filler metal can also be used for dissimilar welding between nickel base alloys and stainless steels, as well as for surfacing and cladding.

Due to high molybdenum content, this alloy offers excellent resistance to stress corrosion cracking and pitting and crevice corrosion.

Specifications & Approvals:

AWS A5.11:2010 ENiCrMo-4 UNS W80276 ASME QSC-395 CWB

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Other
.01	.6	.1	6	15.9	16.1	Rem		3.8	.003	.010			

Typical Mechanical Properties

Tensile Strength	106,000 PSI	730 MPa
Yield Strength	78,500 PSI	540 MPa
Elongation	39%	

Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb