TECH-ROD 276

I. **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, or low alloy steels. This electrode is used for overlay cladding to withstand process corrosion. The weld metal is capable of withstanding cryogenic temperatures. Due to high molybdenum content this alloy offers excellent resistance to stress corrosion cracking and pitting and crevice corrosion.

II. **APPROVALS**: Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.11 Class ENiCrMo-4. Approved by Canadian Welding Bureau.

III. **CHEMICAL COMPOSITION**

Carbon	.012
Manganese	.4
Silicon	.14
Iron	5.5
Molybdenum	16.1
Tungsten	3.25
Sulfur	.004
Phosphorus	.012
Chromium	15.5
Nickel	59.1

MECHANICAL PROPERTIES

Tensile Strength	
106,000 PSI	730 MPA
Yield Strength	
78,500 PSI	540 MPA
Elongation	39%
Impact Strength	
@-196˚C	58 ft/lbs
Lateral Expansion	44 Mils

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

AMPERAGES:

3/32”	65-75
1/8”	90-105
5/32”	120-135
3/16”	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16”-10# can**, 5/32”–**10# can**, 1/8”–**10**#** Can**, 3/32–**8# can