GWELD
SEAL OF TRUST

GEMET 3276N

IDENTIFICATION
Gemet 3276N, ENiCrMo4

CLASSIFICATION
AWS/SFA 5.11: ENiCrMo4,
DIN 1736 EL-NiMo 15Cr15W (2.4887)

DESCRIPTION
Heavy coated ,basic type electrode depositing Ni-15 Cr-16 Mo-4W-5Fe weld metal. Carbon and Silicon are controlled to the very low levels so as to minimize carbide and intermediate phase precipitation. The weld deposit is highly corrosion resistant, scale resistant and work hardening.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Fe	S	P	W	Cu	Co	Cr	Mo	V	Ni
0.02 max	1 max	0.2 max	4.0 - 7.0	0.03 max	0.04 max	3.0 - 4.0	0.5 max	2.5 max	14.5 - 16.5	15.0 - 17.0	0.35 max	remainder 58 typical

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	PS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 - 790 min	450 – 600	25 - 35	-50°C	50 - 100

TYPICAL APPLICATIONS

- Wrought alloys ASTM UNS N 10276
- DIN 2.4819 (Ni Mo16 Cr 15W)
- Haste alloy Alloy C-276(Haynes)
- Inco Alloy C-276
- ASTM A494 CW-12MW
- ASTM A743, A744 CW-12M
- Pumps, valves, pipework and vessels for use in aggressive environment in chemical process plants, equipment for fuel gas de-sulphurisation.
- Suitable for wear resisting cladding on working surfaces of hot working tools subject to thermal load, such as forging jaws, forging dies, forging saddles, plugs, hot cutting tools, hot trimming tools, roll mandrils, hot moulding plugs.

REDRYING TEMP : 300ºC / 2 hrs

ASME IX QUALIFICATION : QW-432 F-No 44, QW-442 P-No 44

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	60 - 85	2	2 x 5 = 10
3.15 / 3.20	350	75 - 110	2	2 x 5 = 10
4	350	110 - 150	2	2 x 5 = 10