

# GM 3276

**NI BASE ALLOY TYPE C-276.**

**IDENTIFICATION**

GM 3276, ERNiCrMo4

**CLASSIFICATION**

AWS/SFA 5.14 ERNiCrMo4  
DIN 8555 SG-NiMo16Cr16W (2.4886)

**DESCRIPTION**

Filler wire of corrosion resistant and non-scaling material used for TIG welding.

**CHEMICAL ANALYSIS (RANGE) %**

C	Si	S	P	Mn	Cu	Cr	Mo	W	Fe	V	Co	Ni
0.02 max	0.08 max	0.02 max	0.04 max	1 max	0.5 max	14.5 - 16.5	15.0 - 17.0	3.0 - 4.5	4.0 - 7.0	0.3 max	2.5 max	Remainder

**MECHANICAL PROPERTIES (RANGE)**

TS (N/mm <sup>2</sup> )	YS (N/mm <sup>2</sup> )	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 min	450 - 550	36 - 42	20°C	90 - 140

**TYPICAL APPLICATIONS**

- For joining parent metals of the same nature and for surfacing of low-alloy steels. Excellent resistant against sulphuric acid that occur with high chloride concentrations.
- NiMo16Cr15W, 2.4819, N10276
- ASTM B-574 and B-575
- For cladding steel with Ni-Cr-Mo weld metal.

**SHIELDING GAS :** Pure Argon

**HARDNESS (BRINELL) :** 250 - 270

**AFTER WORK HARDENING :** 350 - 400

**AFTER HARDENING(900°C / 2 HOURS) :** 360 - 400

**HIGH TEMPERATURE PROPERTIES:**

Resistance to oxidation in air upto 1150°C, in sulphur dioxide upto 800°C.

**PACKING PARAMETERS**

Size (mm)	Weight / Spool (kg)
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0.8	12.5
1	12.5
1.2	12.5
1.6	12.5