GWELD
SEAL OF TRUST

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/mm²)	YS (N/mm²)	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)

0.8	12.5
1	12.5
1.2	12.5
1.6	12.5