

Classifications

AWS A5.14 / SFA-5.14

EN ISO 18274

ERNiCrMo-4

S Ni 6276 (NiCr15Mo16Fe6W4)

Characteristics and typical fields of application

Thermanit Nimo C 276 is a solid wire for submerged arc welding; High corrosion resistant Nickel base alloy (NiCrMo). Especially used for Cryogenic (-196°C) application in LNG tanks 9%Nickel steel.

Recommended SAW flux:

Marathon 104

Marathon 504

Base materials

1.5662 X8Ni9, 1.5680 X12Ni5 and 2.4819 NiMo16Cr15W
joint welds of listed materials with low-alloyed and stainless steels.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	Fe
wt.-%	0.01	0.05	0.50	15.5	Bal.	16.0	3.8	6.0

Operating data

Dimension mm

1.6

2.4

Suggested heat input is max. 1.5 kJ/mm and interpass temperature max. 100°C.

Approvals

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