

ENiCrMo-4 Welding Electrode

For Welding Alloy C-276 and Related Alloys

ENiCrMo-4 is designed for shielded metal arc welding of Alloy C-276 and similar nickel-chromium-molybdenum alloys. The weld metal offers outstanding protection against pitting and crevice corrosion in harsh chemical environments.

It is effective for dissimilar welding with nickel alloys, stainless steels, and low-alloy steels. Smaller diameters allow all-position welding, while larger electrodes excel in groove and fillet applications. Recommended power: DC, electrode positive.

Specification

AWS A5.11 ENiCrMo-4 (UNS W80276)

ASME II, Part C, SFA-5.11, ENiCrMo-4 (UNS W80276)

ASME IX, F-No.43

*DIN 1736 EL-NiMo15Cr15W (2.4887)

*(EN) ISO 14172 – ENi6276 (NiCr15Mo15Fe6W)

Custom specifications available upon request.

For information regarding certifications and industry approvals, please contact our Technical Department.

Limiting Chemical Composition

Element	Ni+Co	C	Mn	Fe	P	S	Si
Content(%)	Remainder	0.02 max	1.0 max	4.0-7.0	0.04 max	0.03 max	0.2 max
Element	Cu	Co	Cr	Mo	V	W	Others
Content(%)	0.50 max	2.5 max	14.5-16.5	15.0-17.0	0.35 max	3.0-4.5	0.50 max

Minimum Mechanical Properties

Property	Value
Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	25

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 12	356 14	356 14	356 14
Current (DC+)	A	40-65	60-90	90-125	125-150