

HAS C276

MIG (GMAW)

SOLID WIRES FOR MIG

PRODUCT DESCRIPTION

Solid wire for MIG welding.

CLASSIFICATIONS

AWS A5.14M ERNiCrMo-4
 ISO 18274 S Ni 6276
 UNS N10276

ASME IX QUALIFICATION

QW432 F-No 43

CHEMICAL COMPOSITION (WIRE WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Fe	V	Cu	Co
min.	--	--	--	--	--	14.5	bal	15.0	3.0	4.0	--	--	--
max.	0.02	1.0	0.08	0.015	0.020	16.5	--	17.0	4.5	7.0	0.3	0.50	2.50
Typical	0.005	0.5	0.05	0.005	0.01	16	58	16	3.5	6	0.2	0.05	0.50

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded	Min.	TIG	SAW
Tensile strength (MPa)	700	740	710
0.2% proof strength (MPa)	400	500	470
Elongation (%) 4d	--	46	38
5d	30	43	36
Reduction of area [%]	--	50	48

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon or Ar-He	Pulsed	1.2	160A, 28V (mean)

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
0.9	1	S200	MHASC276MD09
0.9	12.5	S300	MHASC276-09
1.0	15	S300	MHASC276-10
1.2	15	S300	MHASC276-12
1.6	15	S300	MHASC276-16

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m ³)
14	3	10	28	11	1	1.8