

NIMROD C276KS

MMA (SMAW)

ALL-POSITIONAL PIPE WELDING MMA ELECTRODE FOR ALLOY C276

PRODUCT DESCRIPTION

MMA electrode with special basic flux coating on matching nickel-chromium-molybdenum core wire to provide clean and homogeneous weld metal. Nimrod C276KS has exceptional operability, optimised for DC+ welding in all positions including fixed pipework qualified in the ASME 6G (inclined overhead) position.

Recovery is about 110% with respect to core wire, 65% with respect to whole electrode.

CLASSIFICATIONS

AWS A5.11M ENiCrMo-4
ISO 14172 E Ni 6276

ASME IX QUALIFICATION

QW432 F-No 43

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Fe	V	Cu	Co
min.	--	--	--	--	--	14.5	50.0	15.0	3.0	4.0	--	--	--
max.	0.02	1.0	0.2	0.015	0.02	16.5	--	17.0	4.5	7.0	0.35	0.50	2.5
Typical	0.02	0.3	0.20	0.01	0.01	15.0	58.0	16.0	4.0	5.0	0.1	0.05	0.05

ALL-WELD MECHANICAL PROPERTIES

As welded	Min.	Typical
Tensile strength [MPa]	700	780
0.2% proof strength [MPa]	400	520
Elongation [%] 4d	25	30
5d	25	28
Impact ISO-V[J] -50°C	--	65
-196°C	--	55
Hardness* [HV]	--	240

* Work hardens to about 450HV.

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	60	75	100
max. A	80	110	155

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	NIMC276KS-25	260	780	4.5	13.5
	3.2	300	NIMC276KS-32	155	465	4.5	13.5
	4.0	350	NIMC276KS-40	103	309	5.3	15.9

Redrying: 250 – 300°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total.

FUME DATA (WT % TYPICAL)

Fe	Mn	Ni	Cr	Mo	Cu	F	OES (mg/m³)
1	4	10	5	5	0.2	16	1