

# Wire and Welding products

**HAYNES**  
Wire Company



## HASTELLOY® C-276 Coated Electrodes

### Product Description:

HASTELLOY® C-276 coated electrodes are used for the shielded metal arc welding of C-276 alloy. The deposited weld metal has excellent corrosion resistance in many media including oxidizing and reducing environments. In addition, the alloy has outstanding resistance to pitting and crevice corrosion. The alloy is a good candidate for dissimilar joining of other nickel-chromium-molybdenum alloys, stainless steels and carbon steels. The electrodes can be used for overlay and cladding of steels as well. The coating is designed for great operability, especially in out-of-position welding.

### Specifications:

AWS A5.11 ENiCrMo-4  
ASME SFA-5.11 ENiCrMo-4  
Kennblatt 0319.05\*

ASME IX F-43  
UNS W80276

\*Specify at time of order

### Weld Deposit Chemistry:

Ni.....Balance  
Mo.....15.0 - 17.0  
Cr.....14.5 - 16.5  
Fe.....4.0 - 7.0  
W.....3.0 - 4.5  
Co.....2.5 max.  
Mn.....1.0 max.

Cu.....0.50 max.  
Other.....0.50 max.  
V.....0.35 max.  
Si.....0.20 max.  
C.....0.02 max.  
S.....0.03 max.  
P.....0.04 max.

### Minimum Mechanical Properties:

Tensile (psi)           100,000  
Mpa                       690  
Elongation (%)           25

### Available Product Forms:

Diameter (in)	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
Length (in)	10	14	14	14
Pkg Wt (lbs)	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7018

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