

ASME II C SFA 5.14 : EQ NiCrMo-4  
 EN ISO 18274 : BNi 6276  
 (NiMo16Cr15Fe6W4)

## DESCRIPTION

- SOUDOTAPE NiCrMo 4 is a welding strip especially designed to deposit alloy C276 in combination with a strip NiCrMo 59.
- SOUDOTAPE NiCrMo 4 is to be used in combination with Record EST 259.

## SUITABLE FOR

- It is employed primarily for chemical processes with highly corrosive media, but also for surfacing press tools, punches, etc. which operate at high temperatures. In addition to its exceptional resistance to contaminated mineral acids, chlorine-contaminated media, and chloride containing media, it resists strong oxidisers such as ferric and cupric chlorides and is one of the few materials which will resist wet chlorine gas. Weld with possibly low heat input and low interpass temperature in order to avoid intermetallic precipitations.

## TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Electroslag strip cladding with Record EST 259 on 0.2% C-steel.

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Fe	W
1 <sup>st</sup> strip: SOUDOTAPE NiCrMo 59		0.005	0.2	0.04	22.7	Bal.	15.5	0.7	-
1 <sup>st</sup> Layer	EST 259	0.019	0.2	0.4	19.2	Bal.	14.1	12.1	-
2 <sup>nd</sup> strip: SOUDOTAPE NiCrMo 4		0.005	0.5	0.03	16.0	Bal.	15.8	5.5	3.5
2 <sup>nd</sup> Layer	EST 259	0.01	0.2	0.3	15.3	Bal.	14.8	9.7	2.71
2 <sup>nd</sup> Layer (with EST276 1 <sup>st</sup> layer)	EST 276	0.011	0.31	0.11	16.3	Bal.	16.9	6.1	2.95

## AVAILABLE STRIP SIZES

- Standard : 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

## PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other packing on request.

**Note** : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.