

TECH-ROD® 276

Nickel ■ AWS ENiCrMo-4

KEY FEATURES

- Due to high molybdenum content, this alloy offers excellent resistance to stress corrosion cracking and pitting and crevice corrosion
- Q2 Lot® - certificates showing actual deposit composition available online
- This low carbon, nickel-chromium-molybdenum tungsten alloy can also be used for dissimilar welding between nickel base alloys and stainless steels, as well as for surfacing and cladding

CONFORMANCES

AWS A5.11/A5.11M: 2010 ENiCrMo-4
ASME SFA-A5.11 ENiCrMo-4
UNS W80276

TYPICAL APPLICATIONS

- Used for welding materials of similar composition

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32 (2.4)	12 (305)	EL276093632	
1/8 (3.2)	14 (355)		EL276125634
5/32 (4.0)	14 (355)		EL276156634
3/16 (4.8)	14 (355)		EL276187634

MECHANICAL PROPERTIES - As Required per AWS A5.11/A5.11M:2010

	Tensile Strength Mpa (ksi)	Elongation %
Requirements AWS A5.11/A5.11M:2010	690 (100 min)	25 min
Typical Performance Tech-Rod® 276	750 (108)	46

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.11/A5.11M: 2010

	%C	%Mn	%Fe	%P	%S	%Si	%Cu
Requirements AWS ENiCrMo-4	0.02 max	1.0 max	4.0 - 7.0	0.04 max	0.03 max	0.2 max	0.50 max
Typical Performance⁽²⁾ Tech-Rod® 276	0.02	0.7	5.7	0.02	0.001	0.1	0.01
	%Ni	%Co	%Cr	%Mo	%V	%W	%Other
Requirements AWS ENiCrMo-4	Remainder	2.5 max	14.5 - 16.5	15.0 - 17.0	0.35 max	3.0 - 4.5	0.50 max
Typical Performance⁽²⁾ Tech-Rod® 276	58.6	0.10	15.6	15.5	0.04	3.9	<0.50

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage Flat	Amperage Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	100-120
3/16 (4.8)	14 (355)	120-160	110-130

⁽¹⁾Typical all wire chemistry. ⁽²⁾See test results disclaimer on pg. 13.

Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com