



# exocor™

## Nickel BARE WIRE DATA SHEET executive C276

### DESCRIPTION

**Executive C276** is a nickel-chromium-molybdenum welding wire that is used for GMAW, GTAW and SAW welding of ASTM B574, B575, B19, B622 and B628, having UNS number N10276.

The combination of nickel and chromium provides the resistance to oxidizing conditions and the combination of nickel and molybdenum provides resistance to reducing conditions. The increased level of molybdenum provides excellent resistance to stress corrosion cracking, pitting, and crevice corrosion in most applications.

Executive C-276 is a versatile filler metal that is used for welding of dissimilar joints between nickel-chromium-molybdenum alloys, stainless, carbon and low alloy steels. It is also used for overlay cladding of low alloy or carbon steel to provide general corrosion resistance and is available in larger spool sizes for metal spray. Use Executive 57/15/16 for all position FCAW applications.

### TYPICAL CHEMICAL VALUES

C	Mn	Fe	Si	S	P	Cu	Ni	V	W	Cr	Mo	TOE
0.010	0.55	5.50	0.04	0.01	0.01	0.50	Bal	0.10	3.65	15.50	16.10	0.50

### WELDING PARAMETERS

PROCESS	SIZE	VOLTS	AMPS	SPEED OF WELDING / GAS FLOW	SHIELDING GAS / FLUX
SAW	.062	26 - 29	250 - 320	15 - 17 IPM	Record NiCrW
	.093	28 - 31	300 - 350	15 - 17 IPM	Record NiCrW
	.125	29 - 33	300 - 350	15 - 17 IPM	Record NiCrW
GMAW	.035	26 - 29	150 - 190	30 - 50 CFH	75% Argon+25% Helium
	.045	28 - 32	180 - 220	30 - 50 CFH	or
	.062	29 - 33	210 - 250	30 - 50 CFH	50% Argon + 50% Helium
GTAW	.093	15 - 20	120 - 175	30 - 40 CFH	100% Argon

### MECHANICAL PROPERTIES

Tensile Strength:	105,000 PSI	720 MPA
Yield Strength:	81,000 PSI	560 MPA
Elongation:	40%	
Impact Strength at -196°C:	60 ft lbs	
Lateral Expansion:	40 Mills	

### CLASSIFICATION

Wire chemistry has been optimized for best performance and conforms to **AWS/SFA 5.14, Class ERNiCrMo-4**, ISO 18274, Class SNI6276.