

DESCRIPTION

Executive C-276 AP FC is a nickel-chromium-molybdenum gas shielded FCAW wire that can be used for welding in all positions using 100% CO₂ or Argon/ CO₂ mixtures such as 75/25. It is the flux cored equivalent to Executive C-276 and has complimentary chemistry to Alloy C-276 (NiCrMo-4) providing ease of welding and increased deposition rates associated with flux cored wire.

The weld puddle for Executive C-276 AP FC is more fluid than other forms of this alloy and the weld exhibits excellent slag release, superior bead appearance and offers great out of position welding results. The high alloy content of C-276 AP FC produces high strength weld material with excellent corrosion resistance, particularly pitting and crevice corrosion.

APPLICATIONS & FEATURES

Executive C-276 AP FC is a versatile filler metal that is used for surfacing steel as well as joining C-276 material to itself and to other molybdenum bearing nickel alloys, stainless steels and low alloys steels. Executive C-276 AP FC can also be used to weld ASTM B574, B575, B19, B622, and B628 materials.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Si	Cr	Ni	Mo	W	Fe	P	S
0.02	0.40	0.20	15.4	Bal	15.6	3.8	5.0	0.01	0.001
Tensile Strength:		106,000 PSI min			Yield Strength: 68,000 PSI min			Elongation: 42%	
Charpy Impact:		31 ft-lb at -320°F (-196°C)					Lateral Expansion: 30 Mils		

TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Shielding Gas
.045"	25-26	140-210	290-400 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂
.062"	26-27	180-260	190-275 IPM	1/2"	100% CO ₂ or 75% Ar / 25% CO ₂

STANDARD PACKAGING

Spools 25-lb wire baskets

CLASSIFICATION

AWS/SFA A5.34, Class ENiCrMo4T1-1/4

