

CARBOLOY C 276 B

International standards	Material No.	2.4887
	DIN 1736	E NiMo-15Cr15W
	AWS A5.11	E NiCrMo-4
	DIN 8555	E 23-UM-250-CKNPTZ

Approvals ---

Characteristics CARBOLOY C-276 B is a lime coated, high alloyed nickel based electrode for welding NiMoCr-alloys such as alloy C 276. The resulting deposit is resistant to oxidation and reduction corrosion. Overlays of CARBOLOY C-276 B are extraordinarily tough and harden with impact stress and high temperatures to about 400 HB without deforming the deposit. When welding thicker overlays, the lower layers should be welded with Carbo 29/9.

Typical applications CARBOLOY C-276 B is typically hard faced on: hot working tools as hot forging dies, hot shear blades, punches, swages, hammer saddles, dies, press tools, milling rolls and valves,

Welding instructions To achieve a crack-free overlay, the base material should be preheated to 300 – 400°C, depending on the alloy

Operating temperature Room temperature up to 400° C

Base materials	2.4819	NiMo16Cr15W	Alloy C-276
	2.4610	NiMo16Cr16Ti	Alloy C-4
	2.4856	NiCr22Mo9Nb	Alloy 625
	2.4858	NiCr21Mo	Alloy 825
	1.4529	X1NiCrMoCuN25 20 6	Alloy 254SMo

Mechanical properties of all-weld metal	Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %	Hardness (HB) as welded / work-hardened	
	(typical values)	>720	>450	>30	ca. 230 ca. 400

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	Mo	W	Fe	Ni
	<0,02	0,2	0,6	16	16	4	5	Base

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 300 °C +/- 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 300	50 - 70	233	932	17,2	4,0	16,0
3,2 x 350	70 - 100	152	608	33,0	5,0	20,0
4,0 x 350	90 - 140	96	364	52,0	5,0	20,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.