

# CARBOLLOY C 276 B

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

**Approvals** ---

**Typical applications and characteristics** CARBOLLOY 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 CARBOLLOY 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 . CARBOLLOY C-276 B is typically hard faced on: molds, hot-forging dies, hammer saddles, ball mandrels, etc.

**Operating temperature** Room temperature up to 400° C

**Base materials** Main applications: Surfacing of hot working tools as hot forging dies, hot shear blades, punches, swages, dies, press tools, milling rolls and valves, etc.

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

<b>Mechanical properties of all-weld metal</b>	<b>Tensile strength</b>	<b>Yield strength</b>	<b>Elongation</b>	<b>Hardness (HB)</b>	
	<b>R<sub>m</sub> N/mm<sup>2</sup></b>	<b>R<sub>p0,2</sub> N/mm<sup>2</sup></b>	<b>A<sub>5</sub> %</b>	<b>as welded / work-hardened</b>	
( typical values)	780	500	25	ca. 230	ca. 400

<b>Weld metal analysis</b>	<b>C</b>	<b>Cr</b>	<b>Mo</b>	<b>W</b>	<b>Fe</b>	<b>Ni</b>
(typical, wt. %)	0,02	15	16	4,0	5	Bal.

**Current** = +

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

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

**Flux-cored wire equivalent** CARBOLLOY F-C

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./ packet</b>	<b>Pcs./ carton</b>	<b>kg / 1000</b>	<b>kg / packet</b>	<b>kg / carton</b>
4,0 x 350	90 - 140	96	364	52,0	5,0	20,0