

# TASETO Welding Materials

Ni-Base Alloy Electrodes

For Flux Cored Arc Welding

## GFWHsC276

Applicable Specification  
AWS A5.34 TNi6276-04

### ● Applications and Characteristics

TASETO GFWHsC276 is used for welding of nickel alloy C (UNS N10002), nickel alloy C-276 (UNS N10276) to steel, and nickel alloy clad steel. It is also applicable for overlay welding.

As GFWHsC276 has high PRE value and good resistivity for pitting corrosion, it can be applicable to welding of UNS S31254 class austenitic super stainless steel.

### ● Notes on Usage

\* To minimize crater crack, fill craters with filler metal and remove crater crack with grinder.

### ● Chemical Composition of All Weld Metal(%)

	C	Mn	Fe	P	S	Si	Cu
Typical	0.014	0.32	6.18	0.011	0.002	0.12	0.04

  

	Ni	Co	Cr	Mo	V	W
Typical	Rem	1.18	15.84	16.12	0.03	3.65

### ● Mechanical Properties of All Weld Metal

	0.2% Proof Stress (MPa)	Tensile Strength (MPa)	4D Elongation (%)	Absorbed Energy (2mmVE <sub>0</sub> , J)
Typical	520	727	31	71

### ● Corrosion Resistance of All Weld Metal

	(Corrosion loss: g/m <sup>2</sup> ·h)	
	30% hydrochloric acid (40°C × 1h)	30% sulfuric acid (40°C × 1h)
Typical	0.21	0.21

### ● Sizes Available and Recommended Welding Conditions

Size (mm)	Flat			Horizontal		
	Current (A)	Voltage (V)	Speed (mm/min)	Current (A)	Voltage (V)	Speed (mm/min)
1.2	160~190	26~31	250~350	130~160	25~28	300~400