SOUDOTAPE NiCrMo4

ESSC SASC Strip electrode

Classifications

ASME II C SFA 5.14	EN ISO 18274
EQNiCrMo-4	B Ni 6276 (NiCr15Mo16Fe6W4)

Characteristics and typical fields of application

SOUDOTAPE NiCrMo4 is a nickel-molybdenum-chromium alloy with tungsten addition strip electrode.
Developped to met extra low carbon alloy N10276 - 2.4819 - (Hastelloy C276) Cr-Mo-W alloyed nickel base 2 layers with RECORD EST 276
Hastelloy C276 is also met with ESSC flux RECORD EST 259. With RECORD EST 259, buffer layer with strip electrode SOUDOTAPE NiCrMo59 is recommended.
SOUDOTAPE NiCrMo4 weld overlay is employed primarily for chemical processes with highly corrosive media, but also for surfacing press tools, punches, etc. which operate at high temperatures. In addition to its exceptional resistance to contaminated mineral acids, chlorine-contaminated media, and chloride containing media, it resists strong oxidisers such as ferric and cupric chlorides and is one of the few materials which will resist wet chlorine gas. Weld-overlay with low heat input and low interpass temperature in order to avoid intermetallic precipitations.

Typical analysis

	C	Si	Mn	Cr	Ni	Mo	W	Fe
wt.-%	0.005	0.05	0.5	16.0	Rem.	15.5	3.3	5.7

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 259	ES A FB 2B
ESW	RECORD EST 276	ES A FB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg

Other sizes and coil weights on request.