

Royal C276-20

Shielded Metal Arc Welding
(SMAW) Stick Electrode

Nickel-Chrome-Moly Alloy

DCEP
All Position



"The Royal Line"

CROWN ALLOYS COMPANY

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Premium Nickel-Chromium-Molybdenum Welding Electrode

Typical Applications

Royal C276-20 is used primarily to weld Hastelloy C-276 and other nickel-chromium-molybdenum alloys. These alloys are found in many pollution control, chemical processing, pulp and paper production, and waste treatment applications. **Royal C276-20** displays excellent corrosion resistance in many media and is especially resistant to pitting and crevice corrosion, which makes it ideal for the cladding of many different types of steels. **Royal C276-20** is also useful for various dissimilar joints involving nickel alloys, stainless steels and low alloy steels.

Specifications

AWS A5.11/A5.11M

E NiCrMo-4

- Tensile Strength 100,000 psi (minimum)
- Elongation in 2" 25% (minimum)

Procedure

The base metal must be clean. Nickel alloys can become brittle if any sulfur or lead is absorbed into the weld deposit. These impurities are often found in lubricants, dirt, grease, oil paint, and other processing residues. Use about 30% more opening than conventional joint openings to allow for the low penetrating and sluggish nature of the molten nickel. Use DC reverse polarity (DCEP) while holding the electrode about 20° off vertical for flat position welding. Use a weave type bead but not more than three times the diameter of the electrode. In multipass welding, it is essential that all slag is removed before each bead is deposited.

Sizes, Amps and Part Numbers

Size	Amps	Part Numbers	
		1# Package	5# Package
3/32	40-70	REC276/EN-BP	REC276/EN
1/8	65-100	REC276/EO-BP	REC276/EO
5/32	95-130	REC276/EP-BP	REC276/EP



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.

