



Manufacturers of Custom Welding Lines for Resale  
[www.selectrode.com](http://www.selectrode.com)

# SELECTRODE 1116 Acid Resistant C276 Electrode

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 ENiCrMo-4  
DIN 1736: EL NiMo15Cr15W

EN ISO 14172 ENi6276  
NiCr15Mo15Fe6W4

## FEATURES & APPLICATIONS

- Excellent all position joining of corrosion resistant nickel base alloys
- Deposits are highly resistant to sulfuric acid environments
- Widely accepted throughout the chemical industry

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** Grey

C	Mn	Fe	P	S	Si	Cu	Cr	Mo	V	W	Ni
.02	.9	4.9	.04	.02	.19	.45	16.2	17	.33	4.4	Bal

## TYPICAL MECHANICAL PROPERTIES

### Undiluted Weld Metal

Tensile Strength  
Yield Strength  
Elongation

### Maximum Value Up to:

110,000 PSI (760 MPa)  
65,000 PSI (460 MPa)  
34%

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.2)	5/32 (4.0)
Minimum Amperage	50	80	90
110	75	110	130

**Welding Techniques:** Use as low an amperage as possible, a short arc gap, and a stringer bead technique is preferred.

**Welding Positions:** Flat, vertical up, horizontal, overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	10" (250)	.35 oz (10g)	42 (92)	45 (100)	65
1/8 (3.2)	14" (350)	.76 oz (21g)	23 (51)	22 (49)	90
5/32 (4.0)	14" (350)	106 oz (31g)	17 (37)	20 (45)	105

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

	3/32 (2.5)	1/8 (3.2)	5/32 (4.0)
Length (mm)	10" (250)	14" (350)	14" (350)
Electrodes / lb	24	13	9
Electrodes / kg	53	29	20