



Manufacturers of Custom Welding Lines for Resale
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