



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
6023
C276 Tig

INTERNATIONAL CLASSIFICATIONS

Aws 5.14 ERNiCrMo-4

EN ISO 18274: S Ni6276 (NiCr15Mo15Fe6W4)

FEATURES & APPLICATIONS

6023 is used for gas tungsten arc welding of C-276 alloy. It is also excellent for overlay or cladding of steels when enhanced corrosion resistance is required. Dissimilar welding applications include other nickel-chromium-molybdenum alloys and stainless steels. Because of its high molybdenum content it offers excellent resistance to stress corrosion cracking, pitting and crevice corrosion.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Cr	Mo	V	W	Co
0.02	0.51	5.45	0.007	0.003	0.03	0.05	57.44	0.31	15.9	16.25	0.18	3.4	0.36

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	105,000 PSI (724 MPa)
Yield Strength	81,000 PSI (559 MPa)
Elongation	40%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC- (100% Argon gas should be used to minimize burn-off of the tungsten electrode)

Welding Techniques: Insure welding surface is free of contamination.

Recommended Amperage Settings:

Diameter Inches (mm)	Volts	Amps
1/16 (1.6)	9-12	35-60
3/32 (2.5)	9-13	50-150
1/8 (3.2)	10-13	75-200