

# LNT NiCroMo 60/16

## CLASSIFICATION

AWS A5.14/A5.14M - ERNiCrMo-4  
ISO 18274 - S Ni 6276 (NiCr15Mo16Fe6W4)

## GENERAL DESCRIPTION

**Solid rod for welding CrMoW-alloyed nickel alloys (e.g. Alloy C276)**  
**Depending on the corrosion requirements also applicable for welding C-22 and C-4**  
**Extreme resistance to corrosion environments containing sulphuric acid and chlorides**  
**Applicable for surfacing in high temperature applications (up to 1200°C)**

## SHIELDING GASES (ACC. ISO 14175)

11 Inert gas Ar (100%)  
13 Inert gas Ar+ 0.5-95% He

## CHEMICAL COMPOSITION (W%) TYPICAL WIRE

C	Mn	Si	Ni	Cr	Mo	W	Fe
0.006	0.5	0.04	58	16	16	3.6	5.8

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J) +20°C
Typical values	11	AW	410	720	27	100

## MATERIALS TO BE WELDED

Ni-alloy grades	DIN/EN	Mat. Nr.	ASTM/AISI	UNS
<b>Ni Base high CrMo steel for high corrosion environments</b>				
	NiMo 16Cr15W	2.4819	C-276	N10276
	NiCr21Mo14W	2.4602	C-22	N06022
	NiMo 16Cr16Ti	2.4610	C-4	N06455

- LNT/LNM NiCroMo 60/16 is developed for welding C-276 material
- Can also be applied for welding C-22 and C-4, depending on the corrosion requirements

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	1.6	2.0	2.4	3.2	
Unit : 10 kg tube	X	X	X	X	Note : Cut length = 1000 mm
Other sizes and packaging on request					

LNT NiCroMo 60/16; rev. EN 22