



!!!! 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 MATERIAL SAFETY DATA SHEET (MSDS).

THE MATERIAL SAFETY DATA SHEET (MSDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE MSDS 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 MATERIAL SAFETY DATA SHEET (MSDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE MSDS.

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



CROWN ALLOYS

COMPANY

30105 STEPHENSON HWY.
MADISON HEIGHTS, MI. 48071
(248) 588-3790 • (800) 521-7878

Royal C276-10 & C276-30

Premium Nickel-Chromium-Molybdenum TIG & MIG Wire

Typical Applications:

Royal C276-10 (TIG) and **Royal C276-30 (MIG)** are used primarily to weld Inco® alloy C276 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 C276-10** and **Royal C276-30** display excellent corrosion resistance in many media and are especially resistant to pitting and crevice corrosion, which makes it ideal for cladding of steel. **Royal C276-10** and **Royal C276-30** are also useful for various dissimilar joints involving nickel alloys, stainless steels, and low alloy steels.

Specifications:

AWS A 5.14 Tensile Strength 100,000 PSI
ER NiCrMo-4

Procedure:

Royal C276-10 (Gas Tungsten Arc Welding - TIG): Base metal must be clean. Nickel alloys 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 25% more opening than conventional joint openings to allow for the low penetrating and sluggish nature of the molten nickel. Use DC straight polarity. High purity grades of either argon or helium (or a combination of the two) are used as shielding gas. Arc length must be maintained as short as possible. Prevent agitation & excessive heat from the weld puddle so as to avoid burning out the deoxidizing elements.

Royal C276-30 (Gas Metal Arc Welding - MIG): Use DC reverse polarity. The shielding gas is usually 100% argon, but mixtures of argon & helium can be used depending on the amount of penetration desired. Use a gas flow of 40cfh. Spray transfer normally is used for groove & fillet welds, but globular transfer may be preferred for surfacing (less dilution of base metal into the weld pool). Balance of procedure same as **Royal C276-10**.

Sizes:

GTAW (TIG):	1/16"	3/32"	1/8"
GMAW (MIG):		Volts	Amps
	.035	26-28	120-170
	.045	28-30	170-220
	1/16	30-32	220-290

Spools are available in 2#, 8" and 30# spools.

Inconel® and Monel® are registered trademarks of the INCO Family of Companies.