

## TECHNICAL DATA SHEET

 **Starweld 676**

**DC +**

### NICKEL ALLOY

#### Description :

Extremely versatile high alloy core Inconel® type electrode for welding nickel alloys, stainless steels and steels difficult to weld together or as dissimilar assemblies.

#### Characteristics :

- **Exceptional mechanical properties**
- Excellent corrosion resistance
- Maximum resistance to hot cracking
- Excellent all-positions weldability
- Conforms to AWS A5.11: ENiCrFe-3

#### Mechanical properties :

- Polarity DC +
- Tensile strength : 100 000 psi (689 MPa)
- Yield strength : 70 000 psi (483 MPa)
- Elongation : 40 - 42 %

#### Mode d'emploi :

Remove any trace of oil, grease and dirt from the surface. Gouge a U-groove on heavy sections with the **Starweld 512B** electrode. Weld at low amperage using the smallest diameter to limit heat input and minimum weaving. Remove slag between each pass. Always strike the arc on a deposited bead, and never on the base metal. Preheating is generally only required for heavy or restrained parts and high alloy steels.

+ **Diameter**  
+ **Amperage**

2.5 mm  
75 A

3.2 mm  
100 A

4.0 mm  
145 A

#### Applications :

Thick parts, dissimilar steels, high-carbon steels, refractory steels, furnaces, valves, chemical, nuclear and petrochemical industries, etc.

**Also available in TIG rods : Starweld T676  
and in MIG wire : Starweld M2676**

**1 800 361 9097**

 **Starweld**