



## NIMOTEN

LOW ALLOY STEEL (Nimoten Series)



Ni-Cr-Mo Welding Electrode for high tensile low alloy steel welding.

**CLASSIFICATION :** EN ISO 18275-A

AWS A/SFA 5.5

**APPROVALS :**

E 55 4 Z B 32 H5

E 9018-M

ABS

### KEY FEATURES :

- Basic coated iron powder electrode
- Ni-Cr-Mo type weld metal
- Resistant to cracking
- Exhibit good toughness at subzero temperatures
- Weld metal is of X-ray quality
- All position capability
- Suitable for high tensile, low alloy steels

### WELDING POSITION :



AC (70 OCV)/DCEP

### TYPICAL APPLICATIONS :

- Pressure vessels, Boilers
- Machinery parts, Rolling stocks
- High tensile weather proof steels
- Penstocks, Pipelines
- Suitable for joining NAXTRA 60 steels

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>
Typical	0.06	1.1	0.4	0.1	1.5
Specification	0.10 max	0.60 - 1.25	0.8 max	0.15 max	1.40-1.80
	<b>Mo</b>	<b>V</b>	<b>S</b>	<b>P</b>	
Typical	0.2	0.02	0.02	0.02	
Specification	0.35 max	0.05 max	0.03 max	0.03 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>YS at 0.2% offset, MPa</b>	<b>EL%</b>	<b>CVN Impact at -51°C, J</b>
Typical	As Welded	650	590	26	54
Specification		620 min	540 - 620	24 min	35-75

Diffusible H2 Content: <5 ml/100 gm

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Approx. Pcs/Carton</b>	<b>Carton/Box</b>	<b>Approx. wt. of 1000 pcs, Kg.</b>
2.5 x 350	60-90	254	4	20
3.15 x 450	100-130	117	4	43
4.0 x 450	140-180	76	4	65
5.0 x 450	190-250	47	4	106