

NIMOTEN PLUS 535 A

LOW ALLOY STEEL (Nimoten Series)

ALLOY BASIS

Ni, Cr, Mo

KEY FEATURES:

- Basic coated electrode
- Low alloy type weld metal
- Machinable with carbide tools
- High weld metal recovery
- Special application for joining and overlay work in steel mills and forging industry
- Radiographic weld deposit
- Three layer hardness over 320 BHN

APPROVALS: -

TYPICAL APPLICATIONS:

- For repair of large hot working dies
- All types of forging dies
- Crack repair in Ni-Cr hot working dies
- High tensile steel machinery parts
- Repair of case hardening steel part after removing the hard zones
- Suitable for repair of H11, H13 and DB-6 type die block material
- Parts of earth moving equipment
- Steam turbine rotors in service upto 538°C

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.08	1.4	0.2

Hardness, 3 Layer: 32-39 HRc

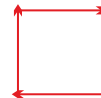
PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
3.15 x 450	100-140
4.0 x 450	140-180
5.0 x 450	190-230
6.3 x 450	260-320



AC (70 OCV) / DCEP

All Positions, except vertical Downwards



REDRYING CONDITION:
250-300°C for minimum 1 hr.

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kgs each. Also available in vacuum packing