



NIMOTEN PLUS 535 A

LOW ALLOY STEEL (Nimoten Series)



Hardfacing Electrode for Application in Steel Mills and Forging Industries

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

WELDING POSITION :



AC (90 OCV) / DCEP

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

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

PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRC
As Welded	32-39

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Carton/Box	Net wt./Box, Kg.
3.15 x 450	100-140	5	4	20
4.0 x 450	140-180	5	4	20
5.0 x 450	190-230	5	4	20
6.3 x 450	260-320	5	4	20

Physical Properties: With increase in number of squares, property improves