

# NIMOTEN PLUS 535 B

**HARD FACING (High Temperature Oxidation - Impact - Abrasion)**

## ALLOY BASIS

C, Cr, Ni, Mo, Mn

## KEY FEATURES:

- Basic coated electrode
- Low alloy type weld metal
- Machinable with carbide tools
- High weld metal recovery
- All position capability
- Special application for joining & overlay work in steel mills and forging industry



## TYPICAL APPLICATIONS:

- Filling die impressions in forging dies
- Automotive parts
- Certain grades of armour steel
- Ni-Cr-Mo steels in chemical plants
- Crack repair in Ni-Cr hot working dies
- High tensile steel machinery parts
- Parts of earth moving equipment
- Steam turbine rotors at 538OC
- Case hardening steel parts repair after removing hard zone





## MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Hardness, 3 Layer HRC
As Welded	38-42

## PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
3.15 x 450	100-140	 <b>AC (70 OCV)/DCEP</b> <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
4.0 x 350	140-180		
5.0 x 450	180-220		

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

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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