



NIMOTEN PLUS 535

LOW ALLOY STEEL (Nimoten Series)



Low alloy steel Welding Electrode for application in steel mills and forging industries.

KEY FEATURES :

- Basic type medium-heavy coating
- Low alloy type weld metal
- Tensile strength over 950 Mpa
- Radiographic weld deposit
- All position capability
- Special application for joining and overlay work in steel mills and forging industry

WELDING POSITION :



AC (90 OCV)/DCEP

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 538°C
- Case hardening steel parts repair after removing hard zone

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni
Typical	0.08	1.4	0.2	2.8	2.1
Range	0.07-0.09	1.20-1.70	0.15-0.25	2.5-3.0	1.8-2.2
	Mo	V	S	P	
Typical	1.2	0.1	0.02	0.02	
Range	1.0-1.5	0.1-0.2	0.03 max	0.03 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	As Welded	735	625	19
Range		690-780	600-650	16-24

Hardness, 3 Layer: 260-330 BHN

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
3.15 x 450	100-130	127	4	39
4.0 x 450	140-180	86	4	58
5.0 x 450	190-230	53	4	94
6.3 x 450	260-320	34	4	147