



NIMOTEN PLUS 535B

HARD FACING (High Temperature Oxidation - Impact - Abrasion)



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
- All position capability
- Special application for joining & 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.

PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRC
As Welded	38-42

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	180-220	5	4	20

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