



## NIMOTEN PLUS

LOW ALLOY STEEL (Nimoten Series)



Ni-Cr-Mo Welding Electrode For High Strength Joining Application

**CLASSIFICATION : AWS A/SFA 5.5**

E 10016-G

### KEY FEATURES :

- Basic coated electrode
- Ni-Cr-Mo type weld metal
- High tensile strength upto 780 MPa
- Weld metal is of X-ray quality
- All position capability
- Suitable for high tensile, low alloy steels

**WELDING POSITION :**



AC (70 OCV) / DCEP

### TYPICAL APPLICATIONS :

- Welding of high tensile steels
- Pressure vessels, Boilers
- Machinery parts
- Penstocks, Pipelines
- Suitable for joining NAXTRA 60 steels

**REDRYING CONDITION : 250-300°C for minimum 1 hr. (Also available in vacuum packed condition)**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr
Typical	0.06	0.7	0.3	0.8
Specification	0.10 max	0.60-1.10	0.20-0.50	0.70-1.20
	Ni	Mo	S	P
Typical	2.3	0.7	0.015	0.02
Specification	2.20-2.80	0.60-0.90	0.03 max	0.03 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	PWHT: 620°C for 1 hr.	735	625	19
Specification		690-780	600-650	16-24

**Diffusible H<sub>2</sub> 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.
2.5 x 350	60-90	278	4	18
3.15 x 450	100-140	125	4	40
4.0 x 450	140-180	86	4	58
5.0 x 450	190-250	53	4	94
6.3 x 450	260-310	34	4	147