



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, Typical
As Welded	42

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	100-140	 AC (70 OCV)/DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.
4.0 x 450	140-180	
5.0 x 450	190-230	
6.3 x 450	260-320	

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

Machinability	Abrasion Resistance	Impact Resistance	Corrosion Resistance
			

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