



NIMOTEN

LOW ALLOY STEEL (Nimoten Series)

AWS A/SFA 5.5 **E9018-M**

CLASSIFICATION:

EN ISO 18275-A
E 55 4 Z B 32 H5

KEY FEATURES:

- Basic coated iron powder electrode
- Ni-Cr-Mo type weld metal
- Resistant to cracking
- Exhibit good toughness at subzero temperatures
- Weld metal is of X-ray quality
- All position capability
- Suitable for high tensile, low alloy steels

APPROVALS: CE

TYPICAL APPLICATIONS:

- Pressure vessels, Boilers
- Machinery parts, Rolling stocks
- High tensile weather proof steels
- Penstocks, Pipelines
- Suitable for joining NAXTRA 60 steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


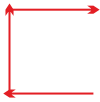
C	Mn	Si	Ni	Cr	Mo
0.06	1.0	0.4	1.5	0.03	0.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	650	590	26	54
Specification		620 min	540 - 620	24 min	47 min

Diffusible H2 Content: <5 ml/100 gm

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	60-90	 AC (70 OCV) / DCEP All Positions, except vertical Down 
3.15 x 450	100-130	
4.0 x 450	140-180	
5.0 x 450	190-250	
		REDRYING CONDITION: 250-300°C for minimum 1 hr.

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