



# NIMOTEN PLUS 535 A

LOW ALLOY STEEL (Nimoten Series)

### ALLOY BASIS

Ni, Cr, Mo

### KEY FEATURES:

- Basic coated electrode
- Low alloy type weld metal
- Machinable with carbide tools
- High weld metal recovery
- Special application for joining and overlay work in steel mills and forging industry
- Radiographic weld deposit
- Three layer hardness over 320 BHN


### TYPICAL APPLICATIONS:

- For repair of large hot working dies
- All types of forging dies
- Crack repair in Ni-Cr hot working dies
- High tensile steel machinery parts
- Repair of case hardening steel part after removing the hard zones
- Suitable for repair of H11, H13 and DB-6 type die block material
- Parts of earth moving equipment
- Steam turbine rotors in service upto 538°C

### MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	Hardness, 3 Layer HRC, Typical
After Tempering	35

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
3.15 x 450	100-130	 AC (70 OCV) / DCEP  <b>REDRYING CONDITION:</b> 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
		