



# NIMOTEN PLUS 535

LOW ALLOY STEEL (Nimoten Series)

### KEY FEATURES:

- Basic type medium-heavy coating
- Low alloy type weld metal
- Tensile strength over 950 MPa
- Radiographic weld deposit
- All position capability
- Special application for joining and overlay work in steel mills and forging industry

### TYPICAL APPLICATIONS:

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

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



C	Mn	Si	Ni	V
0.08	1.4	0.2	2.1	1.2

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%
Typical	As Welded	735	625	19
Specification		690 min	600 min	16 min

Hardness, 3 Layer: 260-330 BHN

### PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 3.15 x 450 4.0 x 450 5.0 x 450	<b>Amperage, A</b> 100-130 140-180 190-230	 <b>AC (70 OCV) / DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  
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Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing