



NIMOTEN PLUS

LOW ALLOY STEEL (Nimoten Series)

AWS A/SFA 5.5 **E10016-G**

CLASSIFICATION:

EN ISO 18275-A
E62ZZ BT32 H5

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

APPROVALS: CE

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 %:


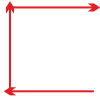
C	Mn	Si	Cr	Ni	Mo
0.06	0.7	0.3	1.0	2.5	0.8

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 min	600 min	16 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		
6.3 x 450	260-310		
		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