

NIMOTEN PLUS 535 A

CLASSIFICATIONS

AWS A/SFA 5.5 E12016G

IDENTIFICATION: Name Printed

CHARACTERISTICS

A medium heavy coated hydrogen controlled electrode depositing low alloy weld metal. Developed specially for joining and overlay work for the steel mills and forging industry. The electrode gives smooth arc. Less spatter and easily detachable slag. Three layered weld deposited over hardness of 320 BHN approx. The electrode gives radiographic quality welds and can be used in all positions.

TYPICAL APPLICATIONS

• For repair of large hot working dies. • Forging dies for all types of die machinery parts made of high tensile steel and parts of earth moving equipment. • Repair of case hardening steel parts after removing the hard zones, for repairing cracks in Ni-Cr hot working dies. Steam turbine rotors in service up to 538°C.

WELD METAL CHEMISTRY, (%)

C - 0.07-0.12	Cr - 2.40-2.80	S - 0.03max
Mn - 1.20-1.70	Ni - 1.80-2.40	P - 0.03 max
Si - 0.15-0.25	Mo - 1.00-1.50	V - 0.1-0.2

Diffusible H₂ content <5 ml / 100gm of weld metal

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elongation (L = 4xd)	Hardness BHN
As-welded	1000-1190	870-1040	16 min	300-360

CURRENT CONDITIONS: AC (70V) / DC (+)

6.3	5.0	4.0
260-320	190-230	140-180

WELDING POSITIONS

F, H, V-up, & OH

REDRYING CONDITIONS

300°C for 1 hour

PACKING DATA

Dia., mm	6.3	5.0	4.0
Length, mm	450	450	450
Pcs per carton, Nos	34	53	83
Cartons / box	4	4	4
Pcs per box, Nos	136	212	332
Approx. Wt. of 1000 pcs,kg	147	94	60



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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