

NIMOTEN PLUS

CLASSIFICATIONS

AWS A/SFA 5.5 E10016G

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

6.3	5.0	4.0	3.2	2.5
260-310	190-250	140-180	100-140	60-90

IDENTIFICATION: Name Printed

WELDING POSITIONS

F, H, V-up, OH

CHARACTERISTICS

A low-hydrogen, electrode for welding of High tensile, low-alloy steels. Weld metal is Ni-Cr-Mo type and exhibits good toughness at sub-zero temperatures. It gives excellent arc stability, arc smoothness and very easy slag removal. Weld metal is of X-Ray quality.

REDRYING CONDITIONS

300°C for 1 hour (Optionally also available in vacuum-packed condition)

TYPICAL APPLICATIONS

Penstocks, Pressure vessels, Boilers, Pipelines, machinery parts. Suitable for joining N-A-XTRA 60 steels.

WELD METAL CHEMISTRY, (%)

C - 0.09 max.	S - 0.030 max.	Diffusible H ₂
Ni - 1.40-1.80	Mn - 0.80-1.25	Content <5ml/100gm
P - 0.030 max.	Cr - 0.15 max.	of weld metal
Si - 0.25-0.60	Mo - 0.35 max.	

PACKING DATA

Dia., mm	6.3	5.0	4.0	3.2	2.5
Length, mm	450	450	450	450	350
Pcs per carton, Nos	34	53	86	125	278
Cartons / box	4	4	4	4	4
Pcs per box, Nos	136	212	344	500	1112
Approx. Wt. of 1000 pcs,kg	147	94	58	40	18

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.
	MPa	MPa	(L=4xd)
PWHT at 620°C for 1 hr	690-780	600-650	16-24



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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