

# NIMOTEN

## CLASSIFICATIONS

**AWS A/SFA 5.5** E9018-M

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

A low-hydrogen, iron-powder 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.

## TYPICAL APPLICATIONS

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

## APPROVALS

**ABS** E 9018-M

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

5.0	4.0	2.5
190-250	140-180	60-90

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour  
(Optionally)

### WELD METAL CHEMISTRY, (%)

C - 0.09 max.	S - 0.030 max.	Diffusible H <sub>2</sub>
Ni - 1.40 - 1.80	Mn - 0.80-1.25	Content <5 ml/100gm
P - 0.030 max.	Cr - 0.15 max.	of weld metal
Si - 0.25 - 0.60	Mo - 0.35 max.	V - 0.05 max

### PACKING DATA

Dia., mm	5.0	4.0	2.5
Length, mm	450	450	350
Pcs per carton, Nos	47	76	254
Cartons / box	4	4	4
Pcs per box, Nos	188	304	1016
Approx. Wt. of 1000 pcs,kg	106	65	20

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS	YS	% Elong.	CVN Impacts, J
As-welded	MPa 625-700	MPa 550-620	(L= 4xd) 24-30	-51°C 35-75



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