



NIMOTEN

CLASSIFICATIONS

AWS A/SFA 5.5 E 9018-M

COATING TYPE: Basic DEPOSITION EFF., %: ~110

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

APPROVALS

ABS E 9018-M

CURRENT CONDITIONS: AC, DC (+)

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

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.

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

TYPICAL APPLICATIONS

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

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

WELD METAL CHEMISTRY, wt%		
C - 0.09 max.	S - 0.030 max.	Diffusible H
Ni - 1.40-1.80	Mn - 0.80-1.25	Content ml/100gm
P - 0.030 max.	Cr - 0.15 max.	<5
Si - 0.25 - 0.60	Mo - 0.35 max.	

PACKING DATA				
Dia.,mm	5.0	4.0	3.2	3.2
Length,mm	450	450	450	350
Wt. per carton, kgs	5.25	5.25	5.25	5.25
Cartons/ box	4	4	4	4
Wt. per box, kgs	21	21	21	21