



NIMOTHERME-1

CODIFICATION : AWS : SFA 5.5 E8016-C3

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen electrode yielding a tough and ductile weld deposit having 1% Ni-0.25% Mo suitable for welding fine-grained and Ni steels for service temperatures down to minus 60°C. Typical applications include storage tanks for liquefied gases, distillers in coke oven batteries and petrochemical industries. Ideal for welding high strength and fine-grained steels subjected to sever dynamic loading and sub-zero temperature service.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Ni	Mo	S	P
Percent	: 0.06	0.90	0.30	0.90	0.25	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	YS	Elongation	CVN Impact Strength
(MPa)	(MPa)	(L= 4d)%	at minus 50°C (Joules)
574	505	27.0	50

CURRENT AND PACKING DATA: DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	210-270	150-190	100-135	80-100
(Amps)					
Qty.(Pcs./Carton)	:	35	55	75	125

PRECAUTIONS:

1. Redry the electrodes as per our standard recommended practice.
2. Restrict the heat input during welding.