Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

NITHERME-1.5 (SPL)

CODIFICATION : AWS : SFA 5.5 E8018-C4

CHARACTERISTICS AND APPLICATIONS :

- A low hydrogen electrode depositing 1.5% Ni steel weld metal.
- Pleasing operating characteristics.
- Weld metal of radiographic quality.

Ideal for welding fine grained and Nickel steels for service temperatures down to minus 50°C. Typical applications include storage tanks for liquefied gases like Ammonia, distillers in coke oven batteries and petrochemical industries. Also suitable for welding heavy sections and highly restrained joints subjected to dynamic loading, impact and severe service conditions.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Ni
Percent :	0.080	1.00	0.50	0.018	0.016	1.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 50°C (Joules)
570	480	25.0	40

CURRENT AND PACKING DATA : AC/DC(+)

Size (mm) Dia x Length :	5x450	4x350	3.15x350	2.5x350
Current Range (Amps) :	200-250	140-180	90-120	70-90
Qty.(Pcs./Carton) :	35	55	75	125

PRECAUTIONS : (For best impact results)

1. Rebake the electrodes at 250-300°C.
2. Accomplish minimum heat input during welding by,
   a. Controlling preheat and interpass temperature. b. Using smallest size of electrode possible. c. Minimum weaving.
3. Depositing maximum number of layers, which enable grain refinement.