Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

NITHERME-2.5 (MOD)

CODIFICATION : AWS : SFA 5.5 E10018-G

CHARACTERISTICS AND APPLICATIONS :

✷ Low hydrogen electrode depositing 2.8%Ni and 0.3%Mo weld metal.
✷ Pleasing operating characteristics. ✷ Weld metal of radiographic quality

Ideally suited for welding grain refined steels 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, petrochemical industries, DMR 249B (AB2) steel, etc. 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	Cr	Ni	Mo	V	P	S	Cu
Percent	:	0.08	0.90	0.30	0.10	2.8	0.30	0.02	0.012	0.010	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	YS (MPa)	Elongation (L= 5d)%	CVN Impact Strength at Bend (3T) minus 50°C (Joules)	
690	620	22.0	70	Satisfactory

DIFFUSIBLE HYDROGEN: Up to 3 ml/100 gms of weld metal by Mercury Method.

CURRENT AND PACKING DATA : DC(+)

Size (mm) Dia x Length	:	5x450	4x450	3.15x450	2.5x350
Current Range (Amps)	:	190-250	110-180	80-120	60-90
Qty.(Pcs./Carton)	:	35	55	75	125

APPROVALS: Indian Navy

PRECAUTIONS :

1. For best impact properties, accomplish minimum heat input by:
   ✷ Using smallest size of electrode possible. ✷ Minimum weaving. ✷ Proper control over inter pass temperatures. ✷ Maximum number of layers. ✷ Welding in down hand position wherever possible.
2. Redry the electrodes at 480°C for three hours for best results.