

NITHERME-3.5L (SPL)

CODIFICATION : AWS : SFA 5.5 E7018-C2L

CHARACTERISTICS AND APPLICATIONS :

Low hydrogen iron powder electrode depositing 3.5% Ni in weld metal. Easy to operate in all conventional welding positions. Radiographic quality welds possesses excellent toughness even at sub-zero temperatures down to minus 101°C. Ideal suited for welding fine-grained and Nickel steels. Typical applications include pressure vessels, piping, valves, and tanks used for storage, transportation, and distribution of liquefied gases.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	P	S	Ni
Percent :	0.045	0.80	0.25	0.020	0.020	3.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL : (PWHT : 605°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L= 4d)%	CVN Impact Strength at minus 101°C (Joules)
525	426	29.0	50

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 5x450	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 190-240	140-190	100-130	70-100
Qty. (Pcs./Carton)	: 35	55	75	125

PRECAUTIONS :

- For best impact properties, accomplish minimum heat input by:
 - * Using smallest size of electrode possible.
 - * Minimum weaving.
 - * Proper control over interpass temperatures.
 - * Maximum number of layers.
 - * Welding in down hand position wherever possible.
- For best results, redry the electrodes at 250-300°C for one hour.