

## NITHERME-3.5

**CODIFICATION :**                      AWS    :    SFA 5.5 E8016-C2

### CHARACTERISTICS AND APPLICATIONS :

A unique low hydrogen type electrode yielding 3.5% Ni in the weld deposits. Specially designed for welding fine-grained steels and nickel steels for service temperatures down to minus 80°C. Typical applications include pressure vessels, piping systems, valves and tanks used for liquefied propane, butane, ethane, acetylene, CO<sub>2</sub> and even liquefied ethylene.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	Ni	S	P
Percent	: 0.06	0.80	0.30	3.2	0.020	0.020

### 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 73°C (Joules)
564	505	23.0	42

### CURRENT AND PACKING DATA : DC(+)

Size (mm)	:	5x350	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

**APPROVALS:** BHEL

### PRECAUTIONS :

1. Redry the electrodes as per our standard recommended practice.
2. Restrict the heat input to a minimum during welding to achieve better properties.