



NITHERME-2.5

CODIFICATION : AWS : SFA 5.5 E8016-C1

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen DC(+) electrode yielding 2.5% Ni in the weld deposit, ideally suited for welding fine-grained steels and Ni steels especially for service temperatures down to minus 60°C. The weld metal possesses strength combined with excellent sub-zero temperature notch toughness. Typical applications include storage tanks, pressure vessels, containers and piping for liquefied gases like propane and butane.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Ni	S	P
Percent :	0.06	0.80	0.30	2.40	0.018	0.018

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 60°C (Joules)
569	495	24.0	50

CURRENT AND PACKING DATA: DC(+)

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

PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Restrict the heat input to a minimum during welding to achieve better properties.

Note: Low carbon version Nitherme-2.5L conforming to AWS : E7018-C1L is also available.