



## NITHERME-2.5L

**CODIFICATION :** AWS : SFA 5.5 E7018-C1L

### CHARACTERISTICS AND APPLICATIONS :

A low hydrogen electrode yielding low carbon, 2.5% Ni in the weld deposit. It is ideally suited for welding fine-grained steels and Ni steels especially for service temperatures down to minus 73°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	P	S	Ni
Percent :	0.04	0.80	0.30	0.018	0.018	2.40

### 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)
520	410	26.0	35

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

Size (mm)	:	5 x 450	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range (Amps)	:	210-270	150-190	100-135	80-100
Qty.(Pcs./Carton)	:	35	55	75	125

### PRECAUTIONS:

1. 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.