



NITHERME-3.5L

CODIFICATION : AWS : SFA 5.5 E7016-C2L
 EN ISO : 2560-B E 49 15-N7 P H5

CHARACTERISTICS AND APPLICATIONS :

A low hydrogen electrode depositing 3.5% Ni weld metal. Specially designed for welding fine-grained steels and nickel steels for service temperatures down to minus 100°C. Typical applications include pressure vessels, piping, valves, tanks, transportation and distribution of liquefied gases, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Ni	S	P
Percent :	0.045	0.8	0.25	3.10	0.020	0.020

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

UTS (MPa)	YS (MPa)	Elongation (L = 5d)%	CVN Impact Strength at minus 100°C (Joules)
525	426	29.0	30

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

APPROVAL: CE

PRECAUTIONS :

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