55 YEARS Since 1968

Estd. 1966
DH sécheron
Complete Welding Support

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_2 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) Dia x Length	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	190-240	140-190	100-130	70-100
Qty.(Pcs./Carton)	35	55	75	125

APPROVALS: BHEL

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.