Thermanit NiMo 100

Stick electrode, low-alloyed, basic

Classifications

EN ISO 18275-A	AWS A5.5	AWS A5.5M
E 62 4 Mn1NiMo B 4 2 H5	E10018-D2	E6918-D2

Characteristics and typical fields of application

Basic covered MnNiMo alloyed electrode.

Very low H_2-content ≤ 5 ml/100 g; extremely high resistance to cracking and high toughness at temperatures as low as –40 °C (–40 °F).

For creep resistant steels and cast steel grades, valves and oil tools according to sour gas specification; postweld heat treatment: stress relieving according to parent metal.

Base materials

GS-30CrMoV64,

Steels acc. ASTM A 487-4Q; AISI 4130

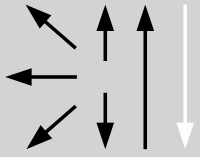
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Mo	Ni
wt-%	0.1	0.3	1.9	0.4	0.9

Mechanical properties of all-weld metal

Heat-treatment	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	–20 °C	–40 °C
sr	600	690	18	100	50	47

Operating data



Polarity:	Redrying:	ø (mm)	L mm	Amps A
DC (+)	300 – 350 °C / 2 h	3.2	350	100 – 150
	(572 – 662 °F)	4.0	450	140 – 200
		5.0	450	180 – 250