

NYLOID® 2

MMA (SMAW)

NI-BASE ELECTRODE

PRODUCT DESCRIPTION

Basic high recovery all position electrode for welding low temperature steels
 Recovery of approximately 150%, providing high deposition rates
 Especially developed for welding 9% Ni steel
 Linear expansion coefficient equivalent to that of 9% Ni steel
 Excellent impact toughness at -196°C, reliable 0.2%-Yield strength
 Weldable on AC as well as DC+ polarity

CLASSIFICATIONS

AWS A5.11 ENiCrMo-6
 ISO 14172 E Ni 6620 (NiCr14Mo7Fe)
 APPROVALS TÜV, GL

ASME IX QUALIFICATION

QW432 F-No 43
 QW442 A-No -

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G



PH/5Gu

CURRENT TYPE

AC / DC +

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	W
min.	--	2.0	--	12.0	55.0	5.0	0.5	--	1.0
max.	0.10	4.0	1.0	17.0	--	9.0	2.0	10.0	2.0
Typical	0.05	3	0.4	13	bal.	6.0	1.5	6	1.5

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.11	ISO 14172	Typical
Tensile strength (MPa)	min. 620	min. 620	725
0.2% proof strength (MPa)	--	min. 350	475
Elongation (%)	20	32	40
Impact ISO-V(U) +20°C	--	--	100
-196°C	--	--	90

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	70	85	140
max. A	100	145	190

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	carton	pack	carton
SRP	2.5	350	542721	62	496	1.7	13.6
	3.2	350	542738	50	400	2.2	17.6
	4.0	350	542745	27	216	1.8	14.4