

THERMET 35.45.Nb

MMA (SAW)

BASIC MMA ELECTRODE

PRODUCT DESCRIPTION

Thermet 35.45.Nb is a basic coated electrode with some alloy additions in the coating and is made on a high purity NiCr core wire. Recovery is approximately 140% with respect to core wire, 65% with respect to whole electrode.

CLASSIFICATIONS

No relevant national specifications.

ASME IX QUALIFICATION

QW432 F-No --
QW442 A-No --

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Nb	Mo	Ti	Fe
min.	0.40	0.5	1.0	-	-	34	44	0.60	-	0.04	-
max.	0.50	1.5	1.6	0.01	0.01	38	50	1.30	0.25	0.15	bal
Typical	0.45	0.9	1.2	0.005	<0.01	35	47	0.8	0.05	0.07	13

ALL-WELD MECHANICAL PROPERTIES

As welded	Min. *	Typical
Tensile strength (MPa)	450	740
0.2% proof strength (MPa)	245	550
Elongation (%) 4d	3	6
Hardness (HV)	-	270

* Minimum values are for static castings.

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	70	85	110
max. A	95	120	160

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	TH3545NB-25	CONSULT US			
	3.2	300	TH3545NB-32				
	4.0	350	TH3545NB-40				

Redrying: 150 – 250°C/1-2h to restore to as-packed condition. Maximum 350° C, 3 cycles, 10h total

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ⁶	Ni	Cu	F	OES (mg/m ³)
3	6	10	9	<0.2	18	0.5

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.