

NYLOID 2

TOP FEATURES

- 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

TYPICAL APPLICATIONS

- LNG storage tanks

CLASSIFICATION

AWS A5.11 ENiCrMo-6
EN ISO 14172-A E Ni 6620

CURRENT TYPE

DC+/AC

WELDING POSITIONS

All position, except vertical down

APPROVALS

BV	DNV
+	+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	W
Min.	not specified	2.0	not specified	12.0	55.0	5.0	0.5	not specified	1.0
Max.	0.10	4.0	1.0	17.0	not specified	9.0	2.0	10.0	2.0
Typical	0.05	3	0.4	13	bal.	6.0	1.5	6	1.5

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded	AWS A5.11	ISO 14172	Typical
Tensile strength (MPa)	min. 620	min. 620	725
0.2% Proof strength (MPa)	not specified	min. 350	475
Elongation (%)	20	32	40
Impact ISO-V (J)	+20 °C	not specified	100
	-196 °C	not specified	90

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	70-100
3.2 x 350	85-145
4.0 x 350	140-190

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	Pack	90	2.3	542721-1
3.2 x 350	Pack	54	2.3	542738-1
4.0 x 350	Pack	35	2.3	542745-1

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.