

NIMAX C

HIGH RECOVERY ALLOY C ELECTRODE PRIMARILY USED FOR SURFACING

PRODUCT DESCRIPTION

MMA electrode with special metal powder rutile- basic flux coating on high conductivity pure nickel core wire. Recovery is about 150% with respect to core wire, 65% with respect to whole electrode.

SPECIFICATIONS

AWS A5.13M
BS EN 14700

ENiCrMo-5A
E Ni2

ASME IX QUALIFICATION

QW432 F-No 71

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Fe	V	Cu	Co
Typical	0.05	0.8	0.7	0.01	0.02	16	56	16.5	3.6	5.5	0.1	0.05	0.05

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical	Typical
Tensile strength (MPa)	495	680
0.2% proof strength (MPa)	275	540
Elongation 4d (%)	4	10-25
Hardness (HV)	--	240

Work hardens to about 450HV.

* Minimum properties are for ASTM A494 CW-12MW castings which are solution treated at 1120°C + WQ.

OPERATING PARAMETERS, DC +VE

Diameter (mm)	5.0
min. A	160
max. A	260

PACKAGING DATA

Diameter (mm)	5.0*
Length (mm)	450
kg/carton	18.0
Pieces/carton	102

STORAGE

3 hermetically sealed ring-pull metal tins per carton, with unlimited shelf life. Direct use from tin is satisfactory for longer than a working shift of 8h. Excessive exposure of electrodes to humid conditions will cause some moisture pick-up and increase the risk of porosity.

For electrodes that have been exposed:

Redry 200–250°C/1-2h to restore to as-packed condition. Maximum 350°C, 3 cycles, 10h total.

Storage: of redried electrodes at 50 – 200°C in holding oven or heated quiver: no limit, but maximum 6 weeks recommended. Recommended ambient storage conditions for opened tins (using plastic lid): < 60% RH, > 18°C.

FUME DATA

Fume composition, wt % typical:

Fe	Mn	Ni	Cr	Mo	Cu	F	OES (mg/m ³)
1	4	10	5	5	0.2	16	1