

NYLOID 4

TOP FEATURES

- Basic high recovery all position electrode for welding low temperature steels
- Especially developed for performing in the PE/4G position (High resistance to porosity)
- 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 (NiCr14Mo7Fe)

CURRENT TYPE

DC+/AC

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	770
0.2% Proof strength (MPa)	not specified	min. 350	490
Elongation (%)	20	32	33
Impact ISO-V (J) +20 °C	not specified	not specified	100
-196 °C	not specified	not specified	85

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	50-70
3.2 x 300	70-110
4.0 x 350	110-140

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	SRP	69	1.3	542763-1
3.2 x 300	SRP	36	1.1	542770-1
4.0 x 350	SRP	30	1.6	542777-1

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.