# 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

## CLASSIFICATION

| | |
|---|---|
| AWS A5.11 | ENiCrMo-6 |
| EN ISO 14172-A | E Ni 6620 (NiCr14Mo7Fe) |

## CURRENT TYPE

DC+/AC

## TYPICAL APPLICATIONS

- LNG storage tanks

## APPROVALS

| BV | DNV |
|---|---|
| + | + |

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL 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 |

## PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|---|---|---|---|---|
| 2.5 x 300 | VPMD | 105 | 2.0 | 542763-2 |
| 3.2 x 300 | VPMD | 58 | 1.8 | 542770-2 |

## 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.