

NYLOID® 4

MMA (SMAW)

NI-BASE ELECTRODE

PRODUCT DESCRIPTION

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

CLASSIFICATIONS

AWS A5.11	ENiCrMo-6
ISO 14172	E Ni 6620 (NiCr14Mo7Fe)
APPROVALS	DNV, GL, BV pending

ASME IX QUALIFICATION

QW432	F-No 43
QW442	A-No -

WELDING POSITIONS (ISO/ASME)



CURRENT TYPE

AC / DC +

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	W
min.	--	2.0	--	12.0	55.0	5.0	0.5	--	1.0
max.	0.10	4.0	1.0	17.0	--	9.0	2.0	10.0	2.0
Typical	0.05	3	0.4	13	bal.	6.0	1.5	6	1.5

ALL-WELD MECHANICAL PROPERTIES

As welded	AWS A5.11	ISO 14172	Typical
Tensile strength (MPa)	min. 620	min. 620	770
0.2% proof strength (MPa)	--	min. 350	490
Elongation (%)	20	32	33
Impact ISO-V(J) +20°C	--	--	100
-196°C	--	--	85

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	50	70	110
max. A	70	110	140

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				pack	carton	pack	carton
SRP	2.5	300	542763	69	690	1.3	13.0
	3.2	300	542770	36	360	1.1	11.0
	4.0	350	542777	30	240	1.7	13.6