NICHROMA

TOP FEATURES

- The general purpose electrode for repair welding
- Suitable for hobby and professional applications
- Easy slag release and smooth bead appearance
- Also applicable for joining steels difficult to weld
- Weldable on AC and DC+ polarity.

CLASSIFICATION

AWS A5.4	E308LMo-16
EN ISO 3581-A	E 20 10 3 R 3 2

CURRENT TYPE

DC+/AC

APPROVALS

BV	DNV	TÜV	DB
+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	Cr	Ni	Mo	FN
Min.	not specified	0.5	not specified	18.0	8.0	2.0	not specified
Max.	0.10	2.5	not specified	21.0	11.0	3.0	not specified
Typical	0.025	0.8	1.0	20.0	9.5	2.3	20

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As welded		AWS A5.4	ISO 3581-A	Typical
Tensile strength	**(MPa)**	min. 520	min. 620	720
0.2% Proof strength	**(MPa)**	not specified	min. 520	500
Elongation (%)		35	20	30
Impact ISO-V (J)	**+20°C**	not specified	not specified	70
	-20°C	not specified	not specified	60

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	40-75
3.2 x 350	60-110
4.0 x 350	80-150

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	Pack	105	2.1	534467-1
3.2 x 350	Pack	135	4.5	534658-1
4.0 x 350	Pack	92	4.5	534764-1

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.