# 1NIMO.B

## TOP FEATURES

- MMA electrode with a basic flux coating on high purity mild steel core wire
- Moisture resistant coating provides very low weld metal hydrogen levels.
- Recovery is about 120%

## TYPICAL APPLICATIONS

- Feedwater piping systems
- Headers, manifolds and fittings in power stations

## CLASSIFICATION

| | |
|---|---|
| AWS A5.5 | E9018-G |
| EN ISO 18275-A | E 55 4 1NiMo B 3 2 H5 |
| E 55 4 1NiMo B 3 2 H5 | |

## CURRENT TYPE

DC+/AC

## WELDING POSITIONS

All position, except vertical down

## APPROVALS

| TÜV |
|---|
| + |

## CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

| | C | Mn | Si | S | P | Cr | Ni | Mo | Cu | V |
|---|---|---|---|---|---|---|---|---|---|---|
| Min. | 0.05 | 1.0 | not specified | not specified | not specified | not specified | 0.8 | 0.20 | not specified | not specified |
| Max. | 0.12 | 1.4 | 0.5 | 0.020 | 0.025 | 0.3 | 1.2 | 0.50 | 0.10 | 0.03 |
| Typical | 0.07 | 1.2 | 0.3 | 0.01 | 0.01 | 0.1 | 1.0 | 0.4 | 0.05 | 0.01 |

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| Properties after PWHT | | Min. | Typical ( 590-620°C /1-2h) | | | |
|---|---|---|---|---|---|---|
| | | | 20°C | 250°C | 350°C | 450°C |
| Tensile strength | (MPa) | 620 | 744 | 650 | 640 | 545 |
| 0.2% Proof strength | (MPa) | 550 | 677 | 505 | 445 | 432 |
| Elongation (%) | 4d | 17 | 25 | 22 | 28 | 24 |
| | 5d | not specified | 22 | - | - | - |
| Reduction of area (%) | | not specified | 65 | 57 | 69 | 73 |
| Impact ISO-V (J) | 0°C | not specified | 130 | - | - | - |

## OUTPUT RANGE

| Diameter x Length (mm) | Current range (A) |
|---|---|
| 3.2 x 350 | 80-140 |
| 4.0 x 450 | 100-180 |

## PACKAGING AND AVAILABLE SIZES

| Diameter x Length (mm) | Packaging | Electrodes/pack | Net weight/pack (kg) | Item number |
|---|---|---|---|---|
| 3.2 x 350 | CAN | 112 | 4.2 | 1NIMOB-32-1 |
| 4.0 x 450 | CAN | 78 | 5.5 | 1NIMOB-40-1 |

## 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.