

# NYLOID 2

The first choice  
for welding 9% Ni steel





# NYLOID 2: since more than 50 years the first choice for LNG



Nyloid 2 is specially designed for welding 9% Ni steel. It has excellent weld impact toughness at -196°C and reliable strength. It also meets the CTOD, lateral expansion and shear fraction requirements at -196°C. This electrode has outstanding project track records **for over 50 years** and has been continuously optimized to follow the increased industrial and engineering requirements for LNG storage tanks.

Nyloid 2 is also very suitable for economical welding of 3.5% and 5% Ni steels.

## Features and benefits:

- Recovery of approximately 150% providing high deposition rates
- Specially developed for welding 9% Ni Steel
- Linear expansion coefficient equivalent to that of 9% Ni Steel
- Excellent CTOD at -196°C (> 0.5 mm)
- Excellent impact toughness at -196 °C
- Reliable 0.2% Proof strength
- **Suitable for AC as well as DC+ (DCEP)**
- **Welding with AC current helps to combat arc blow**

### CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

C	Mn	Si	Cr	Ni	Mo	Nb	Fe	W
0.05	3	0.4	13	bal.	6.0	1.5	6	1.5

### APPROVALS

GL	TÜV
5680	+

### MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Condition	0.2% Proof strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact ISO-V(J)	
				+20°C	-196°C
Required: AWS A5.11 ISO 14172 Typical values	not required min. 350	min. 620 min. 620	min. 20 min. 32	not required not required	
AW	475	725	40	100	90

## Welding positions\*

(ISO/ASME)



\* For overhead welding please consult Nyloid 4 datasheet

# NYLOID 2: key advantages



We know that productivity and welding quality are both important.

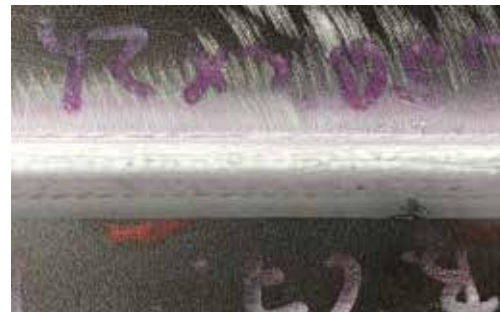
Nyloid 2 success in the market is mainly driven by:

- Reliable mechanical properties
- High quality of weld metal deposited
- Highest deposition rate in the industry

In addition Sahara Ready Pack (SRP®) ensuring the best product integrity, eliminates the need of re-drying before use, reduces wastes on site and simplify welding control operations.

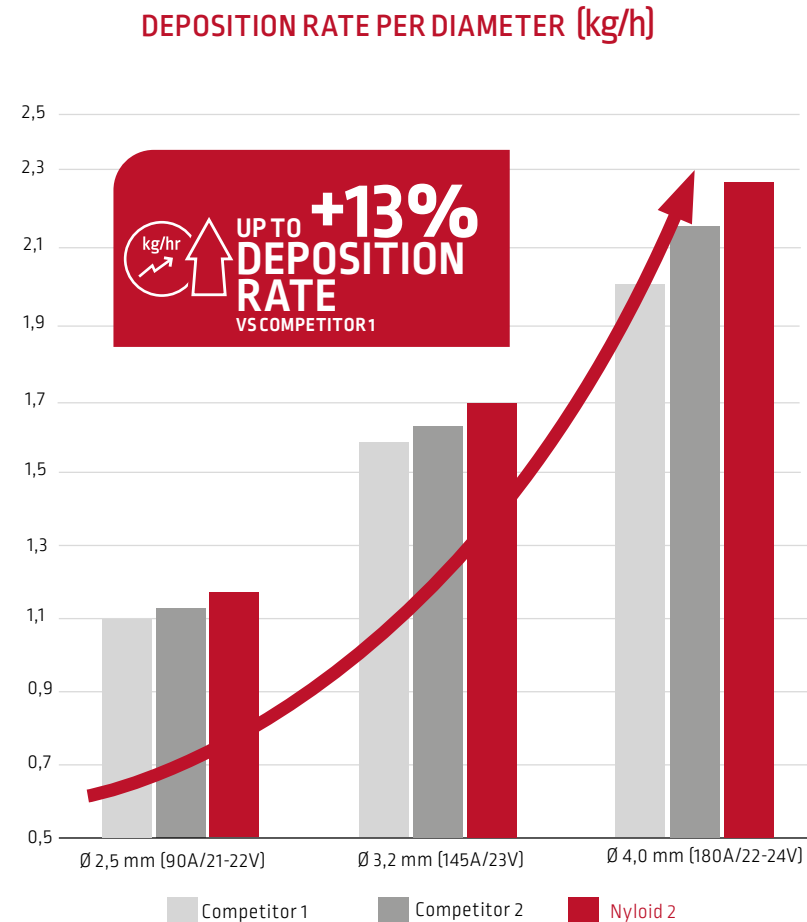


Weld bead profile [2G/PC]



Dye - penetrant examination image [2G/PC]

Nyloid 2 produces excellent weld bead with smooth surface and porosity free.



Based on typical kg of weld metal deposited per project, time and labour savings are significant!

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