

NIMAX B2L

HIGH MOLYBDENUM NICKEL BASE MMA ELECTRODE TO MATCH ALLOY B-2

PRODUCT DESCRIPTION

MMA electrode made on pure nickel core wire with a special basic flux coating to give low levels of impurities.
 Sizes above 3.2mm are not suitable for positional welding.
 Recovery is about 130% with respect to core wire, 65% with respect to whole electrode.

SPECIFICATIONS

AWS A5.11M ENiMo-7
 BS EN ISO 14172 E Ni1066

ASME IX QUALIFICATION

QW432 F-No 44

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Mo	W	Cu	Fe	Co	V
min.	--	--	--	--	--	0.3	64.5	26	--	--	1.0	--	--
max.	0.02	1.75	0.2	0.015	0.02	1.0	bal	30	1.0	0.50	2.0	1.0	0.4
Typical	0.018	1.3	0.1	0.005	0.01	0.7	68	28	0.1	0.01	1.5	0.04	0.1

ALL-WELD MECHANICAL PROPERTIES

As welded		Min.	Typical
Tensile strength [MPa]		760	775
0.2% proof strength [MPa]		400	525
Elongation [%]	4d	25	31
	5d	22	30
Reduction of area [%]		--	25
Hardness [HV]		--	260

ASTM A494 castings require elongation >6% (N-12MV) or >20% (N-7M) after solution treatment.

OPERATING PARAMETERS, DC +VE

Diameter (mm)	2.5	3.2	4.0
min. A	70	90	130
max. A	115	155	210

PACKAGING DATA

Diameter (mm)	2.5	3.2	4.0
Length (mm)	300	350	350
kg/carton	12.6	15.0	14.1
Pieces/carton	447	300	183

STORAGE

3 hermetically sealed ring-pull metal tins per carton, with unlimited shelf life.

Direct use from tin is satisfactory for longer than a working shift of 8h.

Excessive exposure of electrodes to humid conditions will cause some moisture pick-up and increase the risk of porosity.

For electrodes that have been exposed:

Redry 250 – 300°C/1-2h to restore to as-packed condition. Maximum 350°C, 3 cycles, 10h total.

Storage of redried electrodes at 50 – 200°C in holding oven or heated quiver: no limit, but maximum 6 weeks recommended.
 Recommended ambient storage conditions for opened tins (using plastic lid): < 60% RH, > 18°C.

FUME DATA

Fume composition, wt % typical

Fe	Mn	Ni	Cr	Mo	Cu	F	OES [mg/m ³]
1	2	10	0.2	15	0.2	16	5