

Nimrod® AKS

TOP FEATURES

- All-positional INCONEL type MMA electrode.
- Optimised for DC+ welding in all positions including pipework in the ASME 5G/6G positions.
- Recovery is about 110%

TYPICAL APPLICATIONS

- Furnace equipment and petrochemical plants
- Cryogenic vessels and pipework

CLASSIFICATION

AWS A5.11	ENiCrFe-2
EN ISO 14172-A	E Ni 6133

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

CHEMICAL COMPOSITION (WEIGHT %), WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Nb	Fe	Mo	Cu	Co *	Ta *
Min.	not specified	1.0	not specified	not specified	not specified	13.0	62	1.5	not specified	1.0	not specified	not specified	not specified
Max.	0.10	3.5	0.75	0.015	0.02	17.0	bal.	3.0	12.0	2.5	0.50	0.12	0.30
Typical	0.05	2.8	0.5	0.01	0.01	16	69	2	8	1.5	0.05	0.05	0.05

* Co and Ta maximums only when specified at time of order.

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

As-welded	Min.	Typical
Tensile strength (MPa)	550	700
0.2% Proof strength (MPa)	360	420
Elongation (%) 4d	30	42
5d	27	39
Reduction of area (%)	not specified	50
Impact ISO-V (J) -196 °C	not specified	110
Hardness (HV)	not specified	200/215

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 300	60-80
3.2 x 300	70-110
4.0 x 350	100-155

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 300	CAN	210	3.7	NIMAKS-25-1
3.2 x 300	CAN	140	4.1	NIMAKS-32-1
4.0 x 350	CAN	97	5.0	NIMAKS-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.