NIBAZ 65

TOP FEATURES

- Stable arc; the slag is easy to remove
- Very low hydrogen content- max.4ml/100g weld metal
- Weld metal recovery: RE =113%.

CLASSIFICATION

AWS A5.5	E8018-G H4
EN ISO 2560-A	E 50 6 Mn1Ni B 42 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All position, except vertical down

APPROVALS

LR	BV	DNV	TÜV	CE
+	+	+	+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni
0.06	1.6	0.3	≤0.020	≤0.015	0.75

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

Required	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -60°C
AWS A5.5	AW	≥460	≥550	≥19	not specified
AWS A5.5	PWHT 620°C/1h	≥460	≥550	≥19	not specified
EN ISO 2560-A	AW	≥500	560-720	≥18	≥47
EN ISO 2560-A	PWHT 620°C/1h	≥500	560-720	≥18	≥47
Typical values	AW	≥500	600-720	≥22	≥47
Typical values	PWHT 620°C/1h	≥460	550-720	≥22	≥47

*AW: As-welded; PWHT: Postweld Heat Treatment

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
2.5 x 350	65-90
3.2 x 450	130-150
4.0 x 450	160-190
5.0 x 450	200-250

PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Electrodes/pack	Net weight/pack (kg)	Item number
2.5 x 350	CBOX	176	4.0	W000288561
3.2 x 450	CBOX	118	5.5	W000380829
4.0 x 450	CBOX	81	5.5	W000288564
5.0 x 450	CBOX	53	5.5	W000288565

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.