

PRODUCT DATA SHEET

Metrode Nimrod 200Ti



Nimrod 200Ti is an all-positional pure nickel MMA electrode with special carbonate-fluoride-rutile flux system on matching core wire. Smaller diameters offer excellent all-positional operability. Recovery is about 100% with respect to core wire, 65% with respect to the whole electrode. These consumables give low carbon pure nickel with the addition of titanium for refinement and de-oxidation. They are used for joining pure nickel to itself, for buffer layers, and for cladding joint faces and flanges. The solid wire is also useful for welding cast iron to give soft low strength deposit.

Applications

Applications include tanks and vessels, process pipework and heat exchangers, in chemical plant for salt production, chlorination and evaporation of caustic soda. Also used for handling corrosive alkalis and halides.

Storage and Re-baking

Hermetically sealed ring-pull metal tin with unlimited shelf life. Direct use from tin is satisfactory for longer than a working shift of 8 hr. 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:

Re-dry at 200–250°C/1-2 hr to restore to as-packed condition. Maximum 350°C, 3 cycles, 10 hr total.

Storage of re-dried 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.

Materials to be Welded		
ASTM-ASME	DIN	BS
UNS N02200	2.4066	NA11
UNS N02201	2.4068	NA12
	2.4061	
Proprietary Alloys		
Nickel 200 and 201 (Special Metals)		
Nickel 99.6 and 99.2 (VDM)		

Classifications		
AWS	A5.11	ENi-1
EN	14172	ENi2061 (NiTi3)

Typical Chemical Analysis (All weld metal)			
% Carbon	0,1 max	% Titanium	1,0 - 4,0
% Manganese	0,75 max	% Aluminium	1,0 max
% Silicon	1,2 max	% Iron	0,7 max
% Sulphur	0,015 max	% Copper	0,2 max
% Phosphorous	0,02 max	% Niobium	0,5 max
% Nickel	92,0 min		

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Typical Mechanical Properties (All weld metal in the as welded condition)

0,2% Proof Stress	295 MPa
Tensile Strength	450 MPa
% Elongation on 4d	22
% Elongation on 5d	20
% Reduction of Area	40
Impact Energy at -30°C	160 J
Hardness	160 HV

Packing Data and Operating Current (DC+)

Diameter (mm)	Electrode Length (mm)	Current (A)	Pack Mass (kg)	Item Number
2,5	300	60 - 80	4,1	W077732
3,2	350	70 - 110	4,5	W077733
4,0	350	90 - 145	5,0	W077734

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