

Shielded Metal Arc Welding

NB-2
FAMILIARC

Extra low hydrogen type electrode for all-position welding of 400-490N/mm² high tensile or 2.5% Ni steel for low temperature service

Classification: ASME / AWS A5.5 E8016-C1

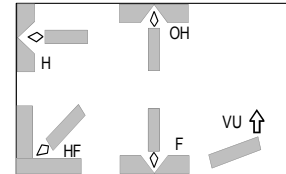
Features : •Suitable for butt and fillet welding

•The weld metal contains about 2.5% Ni

•Better impact values at temperatures down to -60°C

Redrying Conditions: 350~400°Cx1h

Welding Positions:



■ **Typical chemical composition of weld metal (%) (AC)**

	C	Si	Mn	P	S	Ni
Example	0.06	0.45	0.89	0.010	0.006	2.41

■ **Typical mechanical properties of weld metal (AC)**

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)	PWHT (°C×h)
Example	500	610	30	-60°C: 120	-
	480	580	32	-60°C: 130	620x1

■ **Recommended welding parameters**

	2.6mm	3.2mm	4.0mm	5.0mm
F, HF, H	55~85A	90~130A	130~180A	180~240A
VU, OH	50~80A	80~120A	100~170A	-

■ **Polarity**

Example	AC
Guaranty	AC, DC-EP

■ **Approvals**

■ **Packages**

Dia. (mm)	Length (mm)	Weight per pack(kg)	Weight per carton (kg)	Weight per piece (g)
2.6	300	2	20	17
3.2	350	5	20	31
4.0	400	5	20	55
5.0	450	5	20	77