

Thermanit Nimo C 24

Stick electrode, high-alloyed, stainless, basic

Classifications												
EN ISO 14172						AWS A5.11				Mat. No.		
E Ni 6059 (NiCr23Mo16)						ENiCrMo-13				2.4609		
Characteristics and typical fields of application												
Stainless. High corrosion resistance in reducing and, above all, in oxidizing environments. For joining and surfacing with matching and similar alloys and cast alloys. For welding the cladded side of plates of matching and similar alloys.												
Base materials												
2.4602 – NiCr21Mo14W – Alloy C-22; 2.4605 – NiCr23Mo16AI – Alloy 59; 2.4610 – NiMo16Cr16Ti – Alloy C-4; 2.4819 – NiMo16Cr15W – Alloy C-276												
Typical analysis of all-weld metal (wt%)												
	С	C Si			Mn		Cr		Мо	Ni		Fe
wt-%	< 0.02 0.10		0.10	< 0.5		23	23.0		16.0	Bal.		< 1.5
Structure: Austenite												
Mechanical properties of all-weld metal												
Heat- treatment	Yield strength R _{p0.2}			Tensile strength R_m				Elongation A $(L_0=5d_0)$			Impact work ISO-V KV J	
	MPa			MPa				%			+20 °C	
aw 420				700			30				60	
Creep rupture properties: According to matching/similar high temperature resistant metals up to 800 °C (1472 °F).												
Operating data												
		Polarity: DC(+)			ø (mm 2.5 3.2 4.0		n)		L mm 250 300 350		Amps A 45 – 70 65 – 105 85 – 135	
Welding instruction												
Materials Pre		Prehe	eheating				Postweld heat treatm				nt	
Matching and similar metals		None. Cooling in air. \ with electrodes of thin diameter, low heat inp (stringer beads recom			air. Weldin thin at input commende	ng Heat tre matchir metals, ded) welding anneali (2147 ° resistar		eat tre atchin etals, elding nealir 147 °F sistan	reatment is mostly not necessary for ing precipitation insensitive parent s, if the recommendations for ng are observed. Otherwise solution aling at 1150 °C (2102 °F) to 1175 °C °F) / water to restore full corrosion ance			
Approvals												
TÜV (09272), CE												

All information provided is based upon careful investigation and intensive research. However, we do not assume any liability for correctness and information is subject to change without notice.