



## MAC NICRO E200

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■ **Description & Applications:**

Manual Metal Arc electrode with a chemically basic flux coating. A superior electrode for joining and overlaying nickel and nickel alloys such as Inco 200 and 201; or nickel and nickel alloys to carbon steels especially where carbon migration is susceptible during high temperature service conditions. For operations such as evaporators, condensers, treatment of certain dry gases, chlorinating plants and for service involved in the treatment of organochlorine products. This electrode will cover a wide range of applications but is particularly suitable for site welding when TIG welding cannot be used.

■ **Related Specification:**

AWS E Ni-1

■ **Typical All Weld Metal Chemical Analysis %:**

C	Si	Mn	P	S	Cr	Cu	Fe	Ni	Al	Ti
0.023	0.66	0.74	<0.01	0.001	0.11	0.09	0.52	93.3	0.28	4.19

■ **Typical All Weld Metal Mechanical Properties:**

**As Welded**

Ultimate Tensile Strength	510 N/mm <sup>2</sup>
0.2% Proof Stress	300 N/mm <sup>2</sup>
Elongation on 4d	23%
Reduction of Area	32%
Impact Energy -40° C	140 J

■ **Current:**

DC (+) only.

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
50-70	90-110	120-140

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150° C before use.