



MAC NICRO E201

■ **Description & Applications:**

Manual Metal Arc welding electrode using a solid predominantly alloyed core wire with a concentrically extruded flux coating. Easy to use electrode with a porosity free weld deposit. A superior electrode for welding nickel alloys similar to Incoloy 800 and Incoloy DS, and for joining these to stainless and creep resisting Cr Mo steels.

■ **Related Specification:**

AWS E Ni Cr Fe-1

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

C	Si	Mn	P	S	Cr	Cu	Fe	Ni	Nb
0.05	0.48	2.90	<0.01	0.009	16.30	0.05	7.83	67.70	1.83

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

As Welded

Ultimate Tensile Strength	680 N/mm ²
0.2% Proof Stress	510 N/mm ²
Elongation on 4d	35%
Reduction of Area	50%
Impact Energy -190° C	80 J

■ **Current:**

AC (OCV 70 amps Min) DC (+/-)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-80	80-120	100-150

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 180°C before use. If allowed to become wet re-dry at 320°C for one hour.