MAC NICRO E202

Description & Applications:

Manual Metal Arc welding electrode using a solid predominantly alloyed core wire with a concentrically extruded flux coating. A superior electrode for welding nickel alloys similar to Incoloy 800, Incoloy DS, Brightray and similar to stainless steels and Cr Mo creep steels. For welding 3%-5% and 9% nickel steels for semi and full cryogenic applications and for welding high temperature cast alloys such as HK40.

Related Specification:

AWS E Ni Cr Fe-2

Typical All Weld Metal Chemical Analysis %:

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Nb	Mo
0.03	2.50	7.84	<0.01	0.009	0.53	0.06	68.50	18.50	2.19	0.72

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	710 N/mm²
0.2% Proof Stress	430 N/mm²
Elongation on 4d	44%
Reduction of Area	45%
Impact Energy -190° C	100-200 J

Current:

AC (OCV 70 amps Min) DC (±)

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 180°C before use. If allowed to become wet re-dry at 320°C for one hour.