



MAC NICRO E203B

■ **Description & Applications:**

Designed on a highly alloyed core wire with a high purity chemically basic flux to facilitate all positional welding including on site applications.

A versatile electrode with superior welding characteristics for welding almost any nickel chrome alloy for service in both cryogenic and high temperature conditions, with the emphasis on the cryogenic side. For joining and overlaying Inconel 600 and 601 type alloys, Incoloy 800 and 800H, involved in temperature up to 540°C and for dissimilar applications such as Incoloy 600 and 800H to carbon or stainless steels, nickel 200 or monel 400 and nimonic 75. Also suitable for welding 3%, 5% nickel semi cryogenic steels and 9% nickel steels for full cryogenic conditions. Used extensively in the nuclear, chemical and petrochemical industries.

■ **Related Specification:**

AWS E Ni Cr Fe-3 (Basic)

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

C	Mn	Fe	P	S	Si	Ti	Ni	Cr	Nb
0.02	7.50	7.00	0.009	0.005	0.62	0.11	65	15	1.50

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

As Welded

Ultimate Tensile Strength	650 N/mm ²
0.2% Proof Stress	390 N/mm ²
Elongation on 4d	40%
Reduction of Area	45%
Impact Energy -196° C	150 J
Hardness as deposited	190 HV

■ **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.