



MAC NICRO E207

■ **Description & Applications:**

Manufactured using a high purity nickel based copper alloyed core wire with a chemically basic flux coating, containing extra deoxidants to eliminate from the weld metal gases such as nitrogen. Designed to be used with conventional welding techniques, the strong arc encourages full penetration while the basic slag and deoxidation system ensures the metallurgical integrity of the deposited weld metal. For welding wrought and cast alloys of similar composition such as:- BS NA13 & NA1. ASTM/UNS N°4400, N°4405 & M35-1 DIN 2.4360, 2.4361, 2.4365.

Proprietary alloys include:- Inco, Monel 400, Monel R405, VDM NICORROS & NICORROS 5. Used to special advantage on site fabrication work when joint geometry and/or weather conditions make the use of inert gas welding processes impractical.

■ **Related Specification**

AWS E NiCu7

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

C	Mn	Si	S	P	Ni	Al +Ti	Cu	Fe
0.002	3.50	0.50	0.002	0.009	67.00	0.72	26.00	0.60

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

As Welded

		Min	Typical
Ultimate Tensile Strength	N/mm ²	480	510
0.2% Proof Stress	N/mm ²		260
Elongation on 4d	%	30	41
Reduction of Area	%		55
Impact energy -50°C	Joules		110

■ **Current:**

DC (+) Only.

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-80	70-120	90-150	120-190

■ **Storage:**

Electrodes should be stored in dry conditions. Should the electrodes become damp, re-dry for one hour at 150°C before use.