



## MAC NICRO E211

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■ **Description & Applications:**

Manual metal arc welding electrode using a solid predominantly alloyed core wire with a concentrically extruded flux coating. Easy to strike electrode with a porosity free weld deposit. A nickel chrome molybdenum electrode for the welding of alloys similar to Hastalloy B type and for joining and overlaying where severe corrosion is encountered, such as valve seats in the chemical industry.

■ **Related Specification:**

AWS E Ni Cr Mo 1

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

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Nb	Mo	Co
0.044	1.20	15.90	<0.01	0.007	0.81	1.61	BAL	21.00	1.75	6.72	<0.05

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

**As Welded**

Ultimate Tensile Strength	800 N/mm <sup>2</sup>
0.2% Proof Stress	580 N/mm <sup>2</sup>
Elongation on 4d	30%
Reduction of Area	35%

■ **Current:**

AC/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 150°C before use.