MAC NICRO E212

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. Designed for welding a range of nickel, chrome, molybdenum steels and also joining these to ferritic steels and for welding the clad side of steel joints (clad with Ni Cr Mo material).

Related Specification:

AWS ENiCrMo2

Typical All Weld Metal Chemical Analysis %:

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Mo	Co	W
0.044	0.63	13.30	<0.01	0.009	1.19	0.03	BAL	21.20	8.31	0.75	0.61

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	720 N/mm²
0.2% Proof Stress	550 N/mm²
Elongation on 4d	25%
Impact Energy -100° C	100 Joules

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.