



MAC NICRO E213B

■ **Description & Applications:**

Manufactured on a predominantly alloyed core wire with a unique lime/rutile extruded flux coating designed to impart excellent weldability for this type of complex alloy in all positional welding situations. Designed for welding nickel alloys such as Inconel 601 and Inconel 800 and 801. It is also suitable for super austenitics with high molybdenum levels such as Avesta 904L and 254 S Mo. Also suited for welding 9% nickel steels subject to cryogenic services. May also be used for welds between nickel chrome molybdenum steels.

■ **Related Specification:**

AWS E Ni Cr Mo 3

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

C	Mn	P	S	Si	Ni	Cr	Nb	Mo	Fe
0.06	0.6	0.011	0.010	0.60	BAL	21	3.50	9.00	1.00

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

As Welded	Min	Typical
Ultimate Tensile Strength	700 N/mm ²	810 N/mm ²
0.2% Proof Stress	520 N/mm ²	
Elongation on 4d	30%	41%
Reduction of Area		40%
Impact Energy -196°C		100 J

■ **Current:**

DC (±) AC (80 amps OCV)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-90	70-110	100-150

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.