MAC NICRO E214

Description & Applications:

Manual Metal Arc welding electrode using a solid predominantly alloyed core wire with a concentrically extruded flux coating. Easy strike electrode with a porosity free weld deposit.
A superior electrode with exceptional welding characteristics for joining and overlaying heat and corrosion resistant wrought and cast nickel chrome alloys such as Hastelloy C276 and Hastelloy C where a low carbon content, coupled with improved alloying in the weld is required.

Related Specification:

AWS E NiCrMo4.

Typical All Weld Metal Chemical Analysis %:

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Mo	Co	W	V
0.022	0.18	2.18	<0.01	0.006	0.46	0.01	BAL	16.20	15.50	<0.05	3.69	0.15

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	740 N/mm²
0.2% Proof Stress	550 N/mm²
Elongation on 4d	25%

Current:

AC (Min. 70 OCV) 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.