



MAC NICRO E215 HR

■ **Description & Applications:**

Manual Metal Arc welding electrode manufactured on a pure nickel core wire with a concentrically extruded flux with a chemically semi basic coating, containing both alloying elements and deoxidants. Metal recovery is 160% with respect to its core wire. For welding Hastalloy C, due to excellent heat resistance and the ability to work harden under impact, the electrode is recommended for use in the drop forging industry for protection of dies. Widely used in the chemical industry where high resistance to corrosion is required, particularly for applications involving wet chlorine gas and other strongly oxidising media. The electrode also finds wide usage in the fabrication of furnace and heat treatment equipment. Suitable for welding such materials as Hastalloy C and ASTM B3341 and B366 UNS No. 10002. Also suitable for welding NiCrMo alloys to stainless. Welding the clad side (NiCrMo). Clad steels to both austenitic and ferritic materials. Ideal for build-ups.

■ **Related Specification:**

AWS E Ni Cr Mo 5

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

C	Mn	Si	S	P	Cr	Ni	Mo	V	W	Fe	Co
0.01	0.6	0.5	0.01	0.015	15.5	58	16	0.1	4	5	0.2

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

As Welded

Ultimate Tensile Strength	620 N/mm ²
0.2% Proof Stress	490 N/mm ²

■ **Current:**

AC (Min. 70 OCV) DC (±)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
70-110	110-140	150-200	200-250

■ **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.

Other Data :

By batch selection, E Ni Cr Mo-4 (Hastalloy C276)
C 0.02 Max can be met