



MAC NICRO E215

■ **Description & Applications:**

Highly alloyed versatile nickel based electrode specially formulated to withstand elevated temperatures coupled with resistance to corrosion and thermal shock. Smooth arc, low spatter loss and good slag detachability. The weld metal possesses excellent resistance to corrosion. Work hardens under impact and is fully machinable. For welding Hastalloy C, and due to excellent heat resistance and ability to work harden under impact, the electrodes are 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.

■ **Related Specification:**

AWS E Ni Cr Mo 5

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

C	Mn	Fe	P	S	Si	Ni	Cr	Mo	W	V
0.080	0.14	5.00	0.010	0.006	0.62	BAL	15	16.50	3.93	0.02

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

As Welded

Ultimate Tensile Strength	750 N/mm ²
0.2% Proof Stress	500 N/mm ²
Elongation	25% HV230

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
70-110	100-130	130-160

■ **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.