



MAC NICRO E217

■ **Description & Applications:**

MMA electrode manufactured on a pure nickel core wire with a chemically neutral, alloy bearing, high purity, concentrically extruded flux coating. Metal recovery is 140% with respect to the size of the core wire. Designed for welding Ni Cr Mo base materials such as ASTM B574, B575 and UNS N06455 to itself as well and steel and related cladding operations.

■ **Related Specification:**

AWS E Ni Cr Mo 7

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

C	Mn	P	S	Si	Ni	Cr	Mo	Fe
0.009	0.9	0.020	0.015	0.15	BAL	16.20	15.58	1.80

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

As Welded

Ultimate Tensile Strength	750 N/mm ²
0.2% Proof Stress	470 N/mm ²
Elongation	43 %
Reduction of Area	50 %

■ **Current:**

DC (+) or AC (Min OCV 70)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-90	80-110	130-160

■ **Storage:**

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