



Mac Nicro E218

■ **Description & Applications:**

Extruded flux coated MMA electrode manufactured on a high purity nickel, chromium core wire. Mac Nicro E218 is designed to weld a number of proprietary alloys of the 20Cr, 25Ni, 4.5Mo, Cu types which provide excellent resistance to corrosion by both organic and inorganic acids excluding attack by concentrated nitric acid. Such steels normally used in the form of plate, pipe and tubing include Uddelholm 904L, Sandvik 2RK65, Avesta 254SLX, Uranus B6 and B6M and APV Paralloy 5NLC. Mac Nicro E218 is also suited for welding copper free versions of these steels. Most of these steels are used in the manufacture of plant manufacturing fertilisers and resistance to crevice corrosion and chloride initiated stress corrosion cracking.

■ **Related Specification:**

AWS E385-16

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

C	Mn	P	S	Si	Ni	Cr	Mo	Cu	Nb	N ₂
0.03	2.0	0.018	0.020	0.35	25.0	21.0	4.5	1.8	0.4	0.10

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

As Welded

Ultimate Tensile Strength	630 N/mm ²
0.2% Proof Stress	410 N/mm ²
Elongation	40 %
Reduction of Area	50 %
Hardness	190 HV

■ **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.