



MAC NICRO E220Nb

■ **Description & Applications:**

Manufactured using a nickel based, chrome alloyed, iron free core wire. The alloy design necessitates the use of a chemically basic flux with a high coating ratio. The electrode is best suited to downhand and HV welding, while the smaller diameter may be used positionally.

Easy to strike electrode producing porosity free deposit and good slag detachability.

Suitable for welding materials as below:

INCO IN-657, IN-671, IN-560

ASTM A560 Grade 50Cr-50Ni-Cb

PARALLOY N50W

DURALOY 50/50Cb

DIN 2.4678, 2.4680, 2.4813

■ **Related Specification:**

This electrode can not be cross-related to any existing specification and is thus compositionally coded 50.50Nb. Proposed AWS E Ni Cr 4.

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

C	Mn	Si	S	P	Ni	Cr	Nb	Fe
0.08	1.09	0.44	0.005	0.007	BAL	49.49	1.71	1.05

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

As Welded

Ultimate Tensile Strength 960 N/mm²

0.2% Proof Stress 700 N/mm²

Elongation on 4d 4%

Hardness 340 HV

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm 3.25mm 4.00mm

70-80 100-150 180-250

■ **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.