



## MAC NICRO E221

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■ **Description & Applications:**

High purity nickel chromium core wire, with extruded fully basic flux with low hydrogen levels. Designed for welding nickel, chromium, cobalt, molybdenum based materials that are covered by the UNS No. 617 material code. The weld composition ensures optimum strength and resistance to oxidation between 815°C - 1200°C.

■ **Related Specification:**

AWS E Ni Cr Co Mo 1

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

C	Mn	Si	S	P	Ni	Cr	Co	Mo	Al+Ti	Fe
0.06	0.40	0.80	0.013	0.025	BAL	21	10.8	8.50	0.45	1.8

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

<b>As Welded</b>	<b>Min</b>	<b>Typical</b>
Ultimate Tensile Strength	700 N/mm <sup>2</sup>	780 N/mm <sup>2</sup>
0.2% Proof Stress	400 N/mm <sup>2</sup>	450 N/mm <sup>2</sup>
Elongation on 4d	25%	35%
Impact energy -20°C	60 J	100 J

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-80	70-110	100-150

■ **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.