MAC NICRO E222Mn

Description & Applications:

Extruded flux coated MMA electrode manufactured on a nearly matching core wire. The chemically basic flux, with a moisture resistant coating, gives a sound porosity free deposit with a recovery rate of approximately 120% with respect to the core wire. The electrode is designed to match the composition of Paralloy CR39W and Lloyds Termalloy T57 and the deposited weld metal will be free from any micro-cracking. This alloy was developed from 800 type alloys with increased chromium and nickel contents and exhibits improved carburisation and oxidation resistance. It is used at temperatures up to 1100°C and is resistant to severe thermal shock and fatigue. Welding applications include centrifugal cast pyrolysis coils, reformer tubes, return bends and tees for the petrochemical industry.

Related Specification:

Mac Nicro E222Mn is not covered by any national specification but is referred to as 25.35.Nb.

Typical All Weld Metal Chemical Analysis %:

C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Pb	Sn
0.08	3.4	0.3	0.010	0.01	26	35	0.4	1.0	0.2	0.002	0.005

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	750 N/mm²
0.2% Proof Stress	560 N/mm²
Elongation on 4d	15%
Reduction of area	15%

Current:

AC/DC (+)

Sizes Available and Recommended Amperages:

2.50mm	3.25mm	4.00mm
60-90	70-120	100-150

Storage:

If allowed to become damp the electrodes should be re-dried for one hour at 250°C before use.