



MAC NICRO E222Nb

■ **Description & Applications:**

Manual metal arc electrode manufactured on a predominantly alloyed core wire with a concentrically extruded chemically basic flux coating. Easy to strike electrode producing porosity free deposit and good slag detachability.

Mac Nicro E222Nb is designed for welding the following materials.

	<u>Matching Alloys</u>	<u>Nb-Free Alloys</u>
ASTM	A297 'HP40Cb'	HP or HP40
DIN	1.4852	1.4852
DIN	1.4853 (Wrought)	
Lake & Elliot Paramount	H39W	H39
Lloyds (Burton) Thermally	T64	T63
Duraloy 64		Cronite HR33

Also suitable for high carbon 18Cr-37Ni-Nb alloys such as DIN 1.4849

■ **Related Specification:**

25.35 H Nb B

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

C	Mn	Si	S	P	Cr	Ni	Nb	Mo	Ti
0.40	1.5	0.50	0.01	0.015	26	35	1.2	0.2	0.05

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

<u>As Welded</u>	<u>Typical</u>
Ultimate Tensile Strength	740 N/mm ²
0.2% Proof Stress	550 N/mm ²
Elongation on 4d	15%
Reduction of area	15%
H.V. 20	245

■ **Current:**

DC (+) only

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-80	70-110	90-150

■ **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.