



MAC NICRO E224Mn

■ **Description & Applications:**

Extruded flux coated MMA electrode manufactured on a closely matching core wire. The chemically basic flux ensures the metallurgical integrity of the fully austenitic weld metal and low residuals of non-metallic impurities. It may be used to weld similarly alloyed base materials such as Inconel 800 and 800H where the higher than normal manganese in the weld will significantly reduce the incidence of solidification cracking on heavily restrained weldments. Proprietary alloys that may be welded include Lloyds T52, Firth Vickers Vicro 8 and Paralloy Cr32W.

■ **Related Specification:**

Mac Nicro E224Mn is not covered by any national specification but is referred to as 20.30.MnNb.

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

C	Mn	Si	S	P	Cr	Ni	Nb	Mo
0.1	4.5	0.3	0.01	0.009	21	32	1.2	0.2

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

As Welded	Min	Typical
Ultimate Tensile Strength	550 N/mm ²	620 N/mm ²
0.2% Proof Stress	220 N/mm ²	410 N/mm ²
Elongation on 4d	30%	35%
Reduction of area		50%
Impact energy +20°C		55 J

■ **Current:**

DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-85	85-120	110-165

■ **Storage:**

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