



MAC NICRO E225Nb

■ **Description & Applications:**

Extruded flux coated MMA electrode manufactured on a nickel, chromium alloyed core wire. The chemically basic, medium alloyed flux coating provides a metal recovery of some 137% with respect to the core wire but still permits positional welding characteristics. The electrode is designed to weld cast alloys such as Paralloy H46M, Lloyds T75 MA, T80 and ET 45. The design emphasis of these materials and the matching electrode is to ensure optimum resistance to carbonisation and oxidation and temperature up to 1150°C typical hardness HV 260/280.

■ **Related Specification:**

Mac Nicro E225Nb (35.45.Nb) is not covered by any national specification. Therefore the composition coding and manufacturing control are in accordance with BS2926.

Additional information :

Fully austenitic microstructure reinforced with primary eutectic and secondary precipitated carbides.

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

C	Mn	Si	S	P	Cr	Ni	Nb	Mo	Ti
0.44	0.9	1.2	0.011	0.011	36.0	48.0	0.90	0.10	0.02

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

<u>As Welded</u>	<u>Min</u>	<u>Typical</u>
Ultimate Tensile Strength	450 N/mm ²	740 N/mm ²
0.2% Proof Stress	220 N/mm ²	560 N/mm ²
Elongation on 4d	3%	6%

■ **Current:**

DC (+) only

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-85	77-120	110-160

■ **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.