



MAC NICRO E227

■ **Description & Applications:**

Mac Nicro E227 is designed to weld both cast and wrought alloys such as carpenter 20Cb-3 and similar materials with increased nickel levels, this higher nickel level improves resistance to stress corrosion cracking in chloride environments and reduces corrosion rates in the presence of sulphuric acids. Mac Nicro E227 may also be used to weld leaner nickel alloys of the 20.29.3 Cu Nb classification. The risk of weld metal microfissuring is eliminated by a relatively low silicon level and a high manganese to silicon ratio plus low sulphur and phosphorus levels.

■ **Related Specification:**

AWS E320LR-15

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

C	Si	Mn	P	S	Cr	Cu	Ni	Mo	Nb
0.03	0.25	2.1	0.012	0.005	20	3.5	35	2.5	0.65

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

As Welded

Ultimate Tensile Strength	650 N/mm ²
0.2% Proof Stress	420 N/mm ²

■ **Current:**

DC (+) or AC (OCV 80)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-90	80-120	130-170

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150° C before use.