MAC NICRO E228

Description & Applications:

Extruded flux coated manual metal arc electrode that produces a precipitation hardening nickel based alloy with controlled levels of chromium, molybdenum, niobium and iron. Materials to be welded are similarly alloyed based materials where high resistance to oxidation is needed combined with good creep strength e.g. SAE-AMS 5589 5590 5596 5597 5662 5663 5664.

Related Specification:

AWS E Ni Fe Cr2 (Nearest) and AMS 5732.

Cross Related Specification :

Alloy 718 W No. 2.4668 UNS 07718 AFNOR NC19FeNb

Typical All Weld Metal Chemical Analysis %:

C	Mn	Fe	P	S	Cu	Ni	Cr	Nb	Mo	Ti & Al
0.05	0.50	11.0	0.007	0.008	0.3	BAL	19.10	5.40	2.80	0.90

Typical All Weld Metal Mechanical Properties:

As Welded

Weld Metal Hardness (as deposited)	HV 220-240
Weld Metal Hardness (post age hardening)	HV 390-420

Current:

AC (OCV 70 amps) DC (+)

Sizes Available and Recommended Amperages:

2.50mm	3.25mm	4.00mm	5.00mm
60-100	90-120	110-170	140-180

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 350°C for one hour.

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