



MAC NICRO E23718

■ **Description & Applications:**

Fully austenitic heat resisting electrode with a rutile coating made on a high alloy core wire designed to weld 18/37 type alloys. Smooth stable arc, low spatter loss, easy releasing slag and smooth porosity free welds. The electrode is designed to match 18/37 type alloy fully austenitic high alloy resisting steels, which will retain a good mechanical strength up to temperatures of 1050°C to 1100°C. Ideal for use in the heat treatment industries and high temperature process plants such as furnace roller – furnace fittings and headers – heat treatment trays and containers – moulds – hearth plates – retorts – radiant tubes.

■ **Materials to be welded :**

BS 3100 Gr 330C11	ASTM A297 HT & HU
BS 3100 Gr 331C40	DIN 1.4865
BS 4534 Gr 8 & 9	

■ **Related Specification:**

AWS E330H-16

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

C	Mn	P	S	Si	Ni	Cr	Mo
0.45	1.5	0.020	0.015	0.40	38	17.5	0.4

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

As Welded	Typical
Ultimate Tensile Strength	760 N/mm ²
0.2% Proof Stress	510 N/mm ²
Elongation on 4d	12%
Reduction of Area	15%

■ **Current:**

AC/DC DC electrode (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-80	70-120	100-160

■ **Storage:**

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