



## MAC NIL SIL

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■ **Description & Applications :**

Manufactured using a silicon free mild steel core wire and a highly chemically acid type (but non-corrosive) extruded flux coating. Welds with a strong forceful arc leaving a minimum of slag. The minimum silicon in the metal, combined with its overall purity, ensures the weld metal has excellent resistance to both corrosion and erosion by molten zinc at temperatures of 450–500°C. Thus it is suitable for welding and repairing fabricated galvanising containers constructed from high purity iron as defined by BS2858.

■ **Related Specification :**

None Applicable, nearest AWS E6013

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

C	Mn	Si	S	P
0.02	0.2	0.02	0.01	0.01

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

**As Welded**

Ultimate Tensile Strength	450 N/mm <sup>2</sup>
0.2% Proof Stress	370 N/mm <sup>2</sup>
Elongation	30 %
Reduction of Area	60 %

■ **Current :**

AC/DC (+).

■ **Sizes Available and Recommended Amperages :**

2.50mm	3.25mm	4.00mm	5.00mm
60-90	80-140	100-180	200-300

■ **Storage :**

If allowed to become damp the electrodes should be re-dried for one hour at 90°C before use.