



MAC STAIN E100 ELC

■ **Description & Applications:**

High quality rutile low carbon stainless steel electrode depositing weld metal of the 19% Cr, 12% Ni, 3% Mo type for corrosion resistance. Suitable for use in all positions except vertical down, high acid resistance. Extra low carbon. Wide usage in textile, pulp and paper, rayon and chemical industries. May be used for overlaying carbon and low alloy steels to provide corrosion and acid resistance. Suitable for general service at temperatures up to 500°C and for acid resistance up to 350°C. The electrode is suitable for welding steels of AISI 316L, 316 and 317 types

■ **Related Specification:**

AWS E316L-17

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

C	Mn	Si	Cr	Ni	Mo
0.03	1.1	0.64	18.4	12.4	2.8

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

As Welded

0.2% Proof Stress	370 N/mm ²
Ultimate Tensile Strength	620 N/mm ²
Elongation on 4d	30 – 45 %
Reduction of Area	40 - 45%
Hardness	150 – 160 Brinell
Charpy Vee Notch +20°C	85 Joules
Charpy Vee Notch -196°C	48 Joules

■ **Current:**

AC/DC

■ **Sizes Available and Recommended Amperages:**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm
25-35	30-45	45-70	70-110	110-140	140-180

■ **Storage:**

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