



MAC STAIN E100H

■ **Description & Applications:**

A manual metal arc electrode manufactured on an austenitic core wire with a fully chemically extruded basic flux. The electrodes are suited for all positional welding and have great resistance to porosity, even for site welding. Mac Stain E100H is intended for welding 316 stainless steels, used for elevated strength and oxidation resistance for typical applications arising in the power generator industry. Such steels and E316H-15 electrodes have a controlled carbon content of 0.04 to 0.08%

■ **Related Specification:**

AWS E316H-15

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

| | | | | | | | | |
|------|-----|-----|-------|-------|------|------|------|-----|
| C | Mn | Si | S | P | Cr | Ni | Mo | FN |
| 0.06 | 1.3 | 0.4 | 0.011 | 0.020 | 18.0 | 12.0 | 2.50 | 5.0 |

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

| <u>As Welded</u> | | <u>Min</u> | <u>Typical</u> |
|---------------------------|-------------------|------------|----------------|
| Ultimate Tensile Strength | N/mm ² | 550 | 580 |
| 0.2% Proof Stress | N/mm ² | 350 | 460 |
| Elongation on 4d | % | 30 | 36 |
| Reduction of Area | % | | 52 |

■ **Current:**

DC (+) only

■ **Sizes Available and Recommended Amperages:**

| | | | | | |
|--------|--------|--------|--------|---------|---------|
| 1.50mm | 2.00mm | 2.50mm | 3.25mm | 4.00mm | 5.00mm |
| 25-35 | 30-45 | 60-90 | 75-120 | 100-155 | 130-210 |

■ **Storage:**

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