MAC STAIN E101 CF

Description & Applications:

Manufactured on a matching alloyed core wire with a high rutile based flux coating. The electrode has a stable but soft arc and fluid slag ensures short arc characteristics used for all positional pipework welding which ensures weld metal integrity and smooth weld beads. It is not recommended for contact welding as slag is fluid and the soft arc does not lend itself to long arc lengths. The electrode is designed for welding controlled carbon 18% Cr, 10% Ni stainless steels, particularly pipework operating between 400-815◦C, such applications arise in the petrochemical industries.

Related Specification:

AWS E308H-16

Typical All Weld Metal Chemical Analysis %:

C	Mn	Si	S	P	Cr	Ni	Mo
0.063	1.3	0.37	0.009	0.023	19.5	9.94	0.08

Typical All Weld Metal Mechanical Properties:

As Welded

Ultimate Tensile Strength	610 N/mm2
0.2% Proof Stress	435 N/mm2
Elongation on 4d	45 %
Reduction of Area	48 %
Hardness HV40	190 HV
Elongation on 5d	43 %
CVN Toughness +20◦C	80 Joules

Current:

DC (+/-) AC (OCV 70) Min

Sizes Available and Recommended Amperages:

2.50mm	3.25mm	4.00mm	5.00mm
60-90	70-120	100-160	130-210

Storage:

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

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