



MAC STAIN E101

■ **Description & Applications:**

High quality rutile type, niobium stabilised stainless steel electrode for welding and overlaying 19% Cr, 9% Ni austenitic stainless steels subject to temperatures up to 600°C. Ideal for use on pressure vessels, food and process plant, domestic stainless steel equipment etc. Steels for which the electrode is recommended are as follows :

AISI Type 321 (EN58 B and C) titanium stabilised

AISI Type 347 (EN58 F and G) niobium stabilised

AISI Type 302 (EN58 A) unstabilised

AISI Type 304 (EN58 E) unstabilised

■ **Related Specification:**

AWS E347-16

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

C	Mn	Si	S	P	Cr	Ni	Nb
0.03	1.2	0.60	0.017	0.023	19.9	9.4	0.8

■ **Weld Metal Micro-Structure:**

Austenite with 3-10% ferrite.

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

As Welded

Ultimate Tensile Strength	650 N/mm ²
Elongation on 4d	30-35 %
Reduction of area	40-50 %
Hardness	160-180 Brinell

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
25-35	30-45	45-70	70-110	110-140	140-180	180-210

■ **Storage:**

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