



MAC STAIN E101H

■ **Description & Applications:**

A rutile flux coated 347 stainless steel all positional electrode with a controlled carbon content 0.04 to 0.08 and controlled ferrite level of 3% to 7%, manufactured on a low carbon 308L stainless steel core wire. Designed for welding 347 and 321H stainless steels subjected to elevated temperatures service such applications occurring mainly in the power generating industry. This electrode is all positional and the 2.50mm and 3.25mm diameters are ideally suitable for root runs in pipework.

■ **Related Specification:**

AWS E347H-16

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

C	Mn	Si	S	P	Cr	Ni	Nb	FN
0.07	1.40	0.50	0.011	0.021	18.9	10.50	0.70	4.0

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

<u>As Welded</u>		<u>Min</u>	<u>Typical</u>
Ultimate Tensile Strength	N/mm ²	560	660
0.2% Proof Stress	N/mm ²	350	490
Elongation on 4d	%	30	40
Elongation on 5d	%	25	36
Reduction of Area	%		54

■ **Current:**

DC (+) AC (OCV 70)

■ **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.