



MAC STAIN E101Mo

■ **Description & Applications:**

High quality lime rutile low silica stainless steel welding electrode for welding 19% Cr, 9% Ni 3% Mo stainless steels. The electrode has good strike and restrike characteristics and is suitable in all positions. Designed for welding hardenable high strength ferritics such as armour plate and ferritic materials in Q and T condition containing 0.4°C and alloyed with Ni Cr Mo & V steels for which the electrode is recommended for welding ferritics on a maintenance basis as follows:

Formally designated respectively

| | | |
|----------------|--------|-------|
| BS970 part 1 - | 709M40 | EN19 |
| | 817M40 | EN24 |
| | 826M40 | EN26 |
| | 897M39 | EN40C |

■ **Related Specification:**

AWS E308Mo-17

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

| | | | | | | | | |
|-------|-----|------|-------|-------|------|------|------|------|
| C | Mn | Si | S | P | Cr | Ni | Mo | Cu |
| <0.08 | 1.0 | 0.48 | 0.024 | 0.026 | 19.6 | 10.1 | 2.69 | 0.55 |

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

As Welded

| | | Minimum | Typical |
|---------------------------|-------------------|----------------|----------------|
| Ultimate Tensile Strength | N/mm ² | 620 | 780 |
| 0.2% Proof Stress | N/mm ² | - | > 540 |
| Elongation on 4d | % | - | > 45 |
| Reduction of Area | % | - | > 40 |
| Impact energy - 0°C | Joules | - | 45 |

■ **Current:**

DC+/- AC (OCV 70) MIN

■ **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.