



MAC STAIN E102 EHC

■ **Description & Applications:**

Manufactured on a high purity, fully alloyed core wire with a chemically basic flux coating. The purity of the weld deposit is further enhanced by incorporating with the flux ultra-fine metal alloys in the same ratio as they are present in the core wire, this ensures low levels of residuals; tin (Sn<0.01) and lead (Pb<0.01). Recovery is approximately 120% in respect to core wire. This electrode is designed to weld similar alloyed castings that are covered by the following specifications; BS 3100 and BS 1504 grade 310C40, BS 4534 grade 6, ASTM A297 HK, A351 and A608 HK 40. DIN 1.4848 and 1.4847. Proprietary alloys include Paramount H20, Thermoalloy 47 and Cronite HR6.

■ **Related Specification:**

AWS E310H – 15

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

C	Mn	Si	Cr	Ni	Mo	Cu	P	S
0.40	1.8	0.4	26	21	0.1	0.01	0.01	0.01

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

As Welded

0.2% Proof Stress	570 N/mm ²
Ultimate Tensile Strength	760 N/mm ²
Elongation	21%
Reduction of Area	26%
Hardness	225-235 Brinell
Charpy Vee Notch +20°C	70 Joules

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-95	75-125	100-160	135-215

■ **Storage:**

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