



MAC STAIN E102Cb

■ **Description & Applications:**

A rutile flux coated 310 fully austenitic electrode stabilised with Niobium which is manufactured on a near matching core wire. The electrode may be used to weld normal 310 stainless steels but is specifically designed for mixed welding involving 310 stainless to lower alloyed stabilised stainless such as AISI 321 or 347 material. The electrodes are all positional and the 3.25mm and 2.50mm diameters may be used for root runs.

■ **Related Specification:**

AWS E310Cb-16

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

C	Mn	Si	Cr	Ni	Nb
0.08	0.48	0.68	26.5	21.0	1.10

■ **Weld Metal Micro Structure:**

Fully austenitic stabilised with Niobium

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

<u>As Welded</u>		<u>Min</u>	<u>Typical</u>
Ultimate Tensile Strength	N/mm ²	560	630
0.2% Proof Stress	N/mm ²		380
Elongation on 4d (AWS)	%	30	30
Elongation on 5d (BS)	%	25	30
Reduction of Area	%		56

■ **Current:**

DC (+) AC (OCV 70amps)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
50-60	70-100	110-140

■ **Storage:**

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