



## MAC STAIN E102L Mo-15

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■ **Description & Applications:**

Fully austenitic stainless steel electrode with a rutile coating designed to weld 25/20 chromium, nickel heat-resisting steels. The weld deposit provides good heat resistance up to 1400°C in air, up to approx. 650°C in oxidising sulphurous atmospheres. The electrodes are also suitable for welding stainless to carbon or low alloy steels and recommended for foundry heat treatment to carbon or low alloy steels, and recommended for foundry heat treatment trays and bins, foundry thermocouple units and many furnace elements.

■ **Related Specification:**

AWS E310L Mo-15

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

C	Mn	Si	Cr	Ni	Mo
0.03	2.39	0.68	26.5	20.64	2.5

■ **Weld Metal Micro Structure:**

Fully austenitic.

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

**As Welded**

Ultimate Tensile Strength	690 N/mm <sup>2</sup>
Elongation on 4d	35-40 %
Hardness	210 BHN

■ **Current:**

AC/DC. DC electrode positive (+).

■ **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.