



MAC STAIN E103Mo

■ **Description & Applications:**

General purpose stainless steel electrode of 23/12/3 type designed for joining dissimilar stainless steels, of the most common types, to one another. Primarily designed for maintenance applications where various types of stainless steels intermediate in composition between 18/8 and 23/12 chrome nickel, are used and where the need for one electrode, to accommodate all applications on a general basis, is required. Most common types of stainless steel can be welded with this electrode, without the loss of properties.

■ **Related Specification:**

AWS E309L Mo-17 Special

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.035	1.4	0.6	0.03	0.03	23.0	13.0	2.5

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

As Welded

Ultimate Tensile Strength	620 N/mm ²
Elongation on 4d	35 %
Hardness	210 Brinell

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-60	70-100	110-140	150-190

■ **Storage:**

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