



MAC STAIN E104

■ **Description & Applications:**

High recovery alloyed rutile flux coated electrode that deposits a duplex stainless steel weld deposit. The moisture resistant coating ensures freedom from porosity. Welds with a stable arc and may be used slag over slag. The quick freezing slag allows greater control over the molten weld metal. This electrode may be used on thick sections of problem steels but specifically designed for welding galvanised steel. Such welds are free from porosity and of excellent appearance and positive resistance to atmospheric corrosion similar to the base material itself.

■ **Related Specification:**

AWS E309L Mo-26 (Nearest)

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.03	0.60	0.80	0.010	0.010	23.00	12.00	2.00

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

As Welded	Min	Typical
Ultimate Tensile Strength	590 N/mm ²	660 N/mm ²
0.2% Proof Stress	350 N/mm ²	475 N/mm ²
Elongation on 4d	30 %	40 %
Reduction of Area		55 %
Impact Energy +20°C		60 Joules

■ **Current:**

AC/DC (+/-).

■ **Sizes Available and Recommended Amperages:**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm
40-60	45-70	70-115	90-150	130-210

■ **Storage:**

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