



MAC STAIN E105

■ **Description & Applications:**

Manufactured using a high purity ferritic core wire with an alloyed flux whose slag and de-oxidation system ensures full alloying with no trace segregation of anyone element. Ideal electrode for contact welding and segregation of any one element. Ideal electrode for contact welding and mitred fillets joints and deposits smooth even weld appearance for extra efficiency and deposits a weld metal recovery rate of 180%. The electrode is designed to weld ASTM 317 and similar austenitic alloys in which the high Mo content provides extra resistance to pitting in high chloride environments. This electrode may be used in cast or wrought form e.g. BS 317S16 – 317S12 – 317C16 – 317C12 – ASTM 317 and CG 8M. May also be used for mixed welds between 317 – 316 – 304 – 321 – 347 etc

■ **Related Specification:**

AWS E317-16

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

| C | Mn | Si | S | P | Cr | Ni | Mo |
|------|-----|-----|-------|-------|------|------|-----|
| 0.06 | 0.7 | 0.5 | 0.021 | 0.018 | 19.0 | 13.0 | 3.5 |

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

| As Welded | Min | Typical |
|---------------------------|---------------------------------------|-----------------------|
| Ultimate Tensile Strength | 520 N/mm ² | 630 N/mm ² |
| 0.2% Proof Stress | | 450 N/mm ² |
| Elongation on 4d | 30 % | 35 % |
| Reduction of Area | | 41 % |
| Impact Energy | | 110 Joules |
| Other Properties | Austenitic Plus 3 – 7 % Delat Ferrite | |

■ **Current:**

DC (+/-). AC (OCV 80 min)

■ **Sizes Available and Recommended Amperages:**

| | | |
|---------|---------|---------|
| 3.25mm | 4.00mm | 5.00mm |
| 140-180 | 200-230 | 230-280 |

■ **Storage:**

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