



## MAC STAIN E122

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### ■ **Description & Applications:**

Designed on a highly alloyed core wire with a high purity lime/rutile flux coating that deposits high chromium duplex weld metal with excellent resistance to corrosion and erosion. The weld metal microstructure contains 30 to 50 % delta ferrite – balance austenite. This electrode has a very stable arc, low spatter, easy strike and restrike, good slag detachability and porosity free smooth welds. Mac Stain E122 is designed to weld the following alloys when no subsequent solution heat treatment is applied to the weldment. ASTM A182 Grade F51, UNS 53 1803, DIN 1.4462, BSC Hyresist 22/5, Sandvik SAF 2209, Avesta 2209, Valorec VS22

### ■ **Related Specification:**

AWS E2209-16

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

C	Mn	Si	S	P	Cr	Ni	Mo	N <sub>2</sub>
0.02	1.0	0.4	0.01	0.011	25.0	9.0	3.5	0.18

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

#### As Welded

		<u>Min</u>	<u>Typical</u>
Ultimate Tensile Strength	N/mm <sup>2</sup>	690	760
0.2% Proof stress	N/mm <sup>2</sup>		630
Elongation on 4d %	%	20	24
Reduction of area	%		44
Impact energy -50°C	Joules		85

### ■ **Current:**

AC/DC (AC OCV 70 min)

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
45-70	70-110	110-140	140-180

### ■ **Storage:**

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

### ■ **Additional Data:**

$PRE_N = \%Cr + 3.3 \times \%Mo + 16 \times \%N_2 = 38$