



MAC STAIN E125B

■ **Description & Applications:**

Designed on an alloyed core wire with a special basic flux which deposits a super duplex weld metal system to give optimum all-positional welding. The electrode is designed for all positional welding of super duplex alloys subject to service in the as welded condition. The weld has a matching microstructure to the base alloy by virtue of an increased nickel content eg; microstructure of weld and base metal austenite with 40 to 60 Ferrite. The materials and applications it is suitable for are 25% chrome super duplex alloys conforming to ASTM A182 F53, UNS S32760, BS EN 1088-2, X2 Cr Ni Mo, N25-7-4

Casting's UNS J93404 ASTM A890 Grade 5A/6A

Proprietary Alloys Weir pumps – Zeron 100 XKS – Sandvik – Avesta – SAF 2507. Particularly recommended for fixed positional pipework in the ASME 5G/6G position.

■ **Related Specification:**

E25.9.4 NLB 42 Nominal to AWS E25.9.4 L-15

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

C	Mn	Si	S	P	Cr	Ni	Mo	Fe	N	Cu	PRE N
0.03	1.0	0.5	0.015	0.020	25.0	9.5	3.9	59	0.28	0.10	42

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

As Welded

		<u>Min</u>	<u>Typical</u>
Ultimate Tensile Strength	N/mm ²	800	910
0.2% Proof stress	N/mm ²	550	710
Elongation on 4d	%	22	28
Reduction of area	%		45
Impact energy -50°C	Joules		>50

■ **Current:**

DC+ (OCV 80 min)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-75	70-95	100-160	130-190

■ **Storage:**

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