

Arcaloy MC18CrCb

Arcaloy MC18CrCb is an 18% Cr alloy metal cored electrode stabilized with Titanium (Ti) and Niobium (Nb). It is designed for welding Armco 18Cr-Cb HP-10TM stainless steels used in catalytic converters, manifolds, mufflers, and exhaust systems. It is also suited for welding parts with poor fit up. Arcaloy MC18CrCb produces a smooth spray-type metal transfer with very minimal spatter.

Specifications

Classifications	AWS A5.22 : EC439Nb
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Alloy Type	MC18CrCb
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Typical Weld Metal Analysis %

C	Mn	Si	S	P	Cr	Nb	Ti
0.02	0.70	0.51	0.02	0.01	18.60	0.50	0.25

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Electrical Stickout
1.2 mm (.045 in.)	200 A	20 V	533 cm/min (210 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	215 A	21 V	584 cm/min (230 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	234 A	22 V	635 cm/min (250 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	290 A	24 V	762 cm/min (300 in./min)	12.7 mm (0.5 in.)
1.2 mm (.045 in.)	323 A	24 V	889 cm/min (350 in./min)	12.7 mm (0.5 in.)

Recommended Welding Parameters

Current	Wire Diameter	Voltage	Wire Feed Speed
200-323 A	1.2 mm (0.045 in.)	20-24 V	5.33-8.89 mm/min (210-350 in./min)