

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.

Dane techniczne

Klasyfikacje	AWS A5.22 : EC439Nb
Przemys	Motoryzacja

Rodzaj stopu

MC18CrCb

Typowy skad chemiczny stopiwa %

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

Dane wydajności stopiwa

rednica	A	V	Prdko podawania drutu	Wolny wylot elektrody
1.2 mm	200 A	20 V	533 cm/min	12.7 mm
1.2 mm	215 A	21 V	584 cm/min	12.7 mm
1.2 mm	234 A	22 V	635 cm/min	12.7 mm
1.2 mm	290 A	24 V	762 cm/min	12.7 mm
1.2 mm	323 A	24 V	889 cm/min	12.7 mm

Parametry spawania

A	rednica drutu	V	Prdko podawania drutu
200-323 A	1.2 mm	20-24 V	5.33-8.89 mm/min