



MWA
Product Guide
2nd Edition



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MAC GROOVE E71

An electrode specially designed for cutting, gouging and piercing operations on all metals without the use of air or oxygen. Easy to use with little skill required. Operates at lower current and produces less fume than would normally be expected from an electrode of this type. Metal surfaces are seared by the force of the arc leaving them clean and ready for subsequent welding operations. Smooth and even grooves are easily produced. Applications include, grooving, cutting, gouging and piercing operations on all metals including those which would normally present difficulties by machining. These include hardenable steels, armour plate, hard weld overlays, cast iron and stainless steels. The electrodes are ideal for back gouging of butt welded seams and almost indispensable for the preparation of cast irons prior to welding repair.

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm	5.0mm
100-150	150-250	250-300	300-450

Related Specification:

N/A

Current:

AC/DC (+) (AC minimum 70 volts open circuit)

Storage:

If allowed to become damp, the electrodes should be re-dried for one hour at 110°C before use.

MAC STUD E73

Extruded flux coated MMA electrode made on high alloy Duplex microstructured high tensile non-heat treatable (hence non-softening) alloyed core wire. The electrode has the ability to maintain a continuous arc when slag over slag welding while restricting the flow of the molten metal. These physical welding characteristics make the electrode ideal for the removal of threaded bolt when the bolt head has sheared at or just below the surface.

Broken Bolt Removal Procedure: Selecting the appropriate diameter electrode, e.g. approximately 50% of the stud's diameter. Make short continuous build up welds. During the breaks in welding remove slag and check circumference of build up is within the diameter of the stud. Repeat weld procedure until build up is 5 to 8mm above component surface. File two opposite flats on weld deposit and remove broken stud (unscrew) with the use of grips.

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm	5.0mm
50-90	75-130	120-180	160-220

Related Specification:

N/A

Current:

AC/DC (+)

Storage:

If allowed to become damp, the electrodes should be re-dried for one hour at 150°C before use.

MAC CUT E74**MAC CUT E74**

Flux coated Manual Metal Arc electrode for cutting all metals using standard MMA equipment. Will cut all steels including stainless – also non ferrous cast irons and nickel based alloys.

Sizes Available and Recommended Amperages

2.5mm	3.2mm	4.0mm	5.0mm
90-140	130-190	200-280	280-350

Related Specification:

N/A

Current:

AC (OCV 70 min) or DC+

Storage:

If allowed to become damp, the electrodes should be re-dried for one hour at 150°C before use.