



MAC HSS E3062

■ **Description & Applications:**

Hard facing electrode, designed to deposit high quality high speed steel on mild or low alloy steels, having a metal recovery rate of 115%. Tough and highly crack resistant deposits, retaining hardness at temperatures up to 620° C. Deposits can be annealed and re-hardened by oil quenching. Highly recommended for the fabrication of blanking and piercing dies, knife blade edges, shear blades, lathe tools, boring tools, milling cutters, broaching tools, drills, hot working dies etc., ideal for the building up of edges on small components.

■ **Related Specification:**

AWS E Fe-B

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

C	Mn	Si	Cr	Mo	W	V
0.52	0.42	0.27	4.79	8.33	2.59	0.84

■ **Typical All Weld Deposit Hardness:**

As Deposited	59-62 Rockwell C
Annealed at 865° C	35-37 Rockwell C
Oil quenched at 1200° C	59-62 Rockwell C

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-80	90-120	130-150	150-220

■ **Storage:**

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