MAC GROOVE E73

Description & Applications:

Extruded flux coated MMA electrode made on high alloy Duplex micro structured 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 mole grips.

Related Specification:

There is no national or international specification existing for Mac Cut E73

Typical All weld Metal Mechanical Properties :

As Welded

Tensile Strength	850 N/mm²
0.2% Proof Stress	780 N/mm²
Elongation	22%
Hardness Vickers	HV 290

Typical All Weld Metal Chemical Analysis %:

C	Si	Cr	Mn	Ni	S	P	Ti	V	N2
0.04	1.25	29	0.99	12	0.01	0.01	0.07	0.15	0.10

Current:

AC/DC (+).

Sizes Available and Recommended Amperages:

2.50mm	3.25mm	4.00mm	5.00mm
50-90	75-130	120-180	160-220

Storage:

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

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