



MAC HARD E301

■ **Description & Applications:**

Hard facing electrode designed for applications where high resistance to impact is the main requirement. The electrode is all positional and has a metal recovery rate of 120%. Welds can be softened by heat treatment at 720-750°C, machined and subsequently re-hardened by oil or water quenching. Used for the hard facing of crusher jaws, dredger tumbler plates, punches, shears, guillotine blades, tractor idler wheels, roller and track links. Also suitable for depositing buffer layers and for building up multi-layer deposits on badly worn components.

■ **Related Specification:**

HF300

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

C	Mn	Si	Cr
0.08	0.8	0.5	4.0

■ **Typical All Weld Deposit Hardness:**

37 – 40	Rockwell C
350 – 380	Brinell
365 – 400	Vickers

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
80-100	90-110	110-170	160-220	260-300

■ **Storage:**

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