



## MAC HARD E304

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■ **Description & Applications:**

The electrode is designed to deposit wear resistant overlays on all ferrous metals where high resistance to impact and abrasion is required. The electrode is all positional with a metal recovery rate of 110%. The welds are non-machinable in the as welded state but can be softened by heat treatment at temperatures of 720 – 750°C. After machining the welds can be rehardened by oil or water quenching.

■ **Related Specification:**

HF600

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

C	Mn	Cr	Mo
0.5	1.5	6.5	1.5

■ **Typical All Weld Deposit Hardness:**

57 – 59	Rockwell C
570 – 605	Brinell
660 – 725	Vickers

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
80-100	90-120	120-170	160-220	260-300

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for two hours at 180°C before use.