



## MAC HARD E304B

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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 720 - 750°C. After machining the welds can be rehardened by oil or water quenching. Applications include earth moving equipment, scraper blades, bucket lips and facings, farm implements and any application subject to impact and abrasion.

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

C	Mn	Si	Cr	Mo	Ni
0.5	0.7	0.5	6.5	0.5	0.1

■ **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 150°C before use.