



## MAC HARD E306

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■ **Description & Applications:**

Hard facing electrode designed for applications on ferrous metals involving friction and severe abrasion, also where certain heat and corrosive conditions apply. The electrode is of the rutile chromium carbide all positional type and has a metal recovery rate of 150%. Ideal for foundry sand mill blades, impellor worms, screws, etc., also bucket edges and digger teeth in conjunction with Mac Trode E630 being used as a buttering layer.

■ **Related Specification:**

HF900

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

C	Mn	Si	Ni	Cr	Mo
4.40	0.77	0.30	<0.01	43.2	0.04

■ **Typical All Weld Deposit Hardness:**

62 – 65	Rockwell C
800 – 900	Vickers

■ **Current:**

AC/DC (+)  
(AC minimum 70 volts open circuit).

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm
90-130	130-170	170-220

■ **Storage:**

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