



MAC HARD E30618

■ **Description & Applications :**

Manufactured using a high purity, low silicon core wire with a chemically basic, alloy bearing flux. Smooth arc with a low spatter, easy strike and re-strike. May be used in all positions except vertically down, strong stable arc. Fillet welds are convex, weld metal is of bright appearance. Very low levels of hydrogen. Used to best advantage for critical repairs to die blocks which allows the deposit to be machined while still resulting in a tough, impact resistant deposit of around Rockwell C 40 hardness.

■ **Related Specification:**

AWS E16018-G

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

C	Si	Mn	Cr	Ni	Mo
0.122	0.38	1.33	1.90	3.06	1.46

■ **Physical Properties after PWHT at 600°C max:**

Tensile Strength	58 – 63 Ton / in ²
0.2% Proof Stress	52 – 55 Ton / in ²
Elongation	8 - 12%
Hardness	38 – 43 RC

■ **Current:**

DC (+) OR AC (80 MIN OCV)

■ **Sizes Available and Recommended Amperages :**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	90-140	150-190	900-250	250-300

■ **Storage :**

Re-drying electrodes at 180°C will ensure very low hydrogen levels, e.g. less than 5-ml H²/100 grams as per scale D BS 5135.