MAC HARD E307

Description & Applications :

Mac Hard E307 is a high chromium hard facing electrode made on a mild steel core wire. The chemically basic flux also contains other significant carbide formers than chromium, e.g. tungsten, niobium, molybdenum and vanadium. This ensures a microstructure of complex carbides capable of withstanding not only severe abrasion but also resistance to oxidation and stress at elevated temperatures. Typical applications occur in the earth moving and cement industries also in the iron and steel industries on furnace parts – fire grate bars etc

Typical All Weld Metal Chemical Analysis % :

C	Mn	Si	Cr	Mo	Nb	V	W
4.8	0.4	1.0	24.0	5.0	4.0	1.5	4.0

Typical All Weld Deposit Hardness :

Hardness of the first layer will depend on base material but will be in the region HRC 59-62 RC. Hardness achieved in 2nd and 3rd layers will be HRC 63-66 RC

Current :

DC (+) or AC (OCV 80)

Sizes Available and Recommended Amperages :

3.25mm	4.00mm	5.00mm
110-150	140-200	190-250

Storage :

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

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