



## MAC HARD E308

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■ **Description & Applications:**

Hard facing electrode designed specifically for applications on ferrous metals where rapid deposition is required – especially where dot formation is required with little or no deslagging involved.

The electrode is designed to produce spatter type deposition in the vertical welding position but will also give conventional bead deposit in the downhand welding position.

Designed purposefully for the sugar cane industry for hard facing sugar cane crushing rolls welding in the vertical position whilst the rolls are being slowly revolved. The deposit is in the form of a spray spatter and results in even dot formation of a highly abrasive resistant coating. Also ideal for many wear applications in quarrying and earth moving where severe abrasion is encountered.

■ **Related Specification:**

Special

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

Cr	C
30-35	4-4.5

■ **Typical All Weld Deposit Hardness:**

66 Rockwell C on cast iron  
61-62 Rockwell C on Steel

■ **Current:**

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

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm
100-130	130-170	170-250

■ **Storage:**

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