

MAC HARD E335T

■ **Description & Applications:**

Superior highly alloyed all positional tubular flux coated electrode for hard facing where extreme abrasion is involved. Alloy content 40% minimum. Moisture resistant.

Smooth easy to use electrode with high deposition rate at low amps (employing higher amps than necessary will result in greater burn off and dilution of the alloy content, and poorer wear life). Low slag formation allows multi-layer welding without need to de-slag between runs – 4kg/hr. Surface cracking in certain instances may occur, but in practice will assist in the wear performance. The surface cracking has no detriment whatsoever.

The highly abrasive resistant deposits find numerous applications on quarrying and mining machinery and equipment, in brickworks and extensive applications on crushing equipment and on earth moving and agricultural machinery.

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

C	Cr	Mn	Mo	V	B
4.0	27.0	4.0	4.0	1.0	0.5

■ **Properties:**

Hardness: Single layer	50 – 60 Rockwell C
Multi – layer	59 – 62 Rockwell C

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

6.00mm	8.00mm	11.00mm
80-130	140-190	190-260