



## MAC HICA E3074

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■ **Description & Applications:**

High recovery chrome / cobalt / iron based electrode designed to combat all four elements of wear, i.e. heat, impact, corrosion and abrasion, but with the emphasis on impact properties. The addition of molybdenum refines the grain structure and produces good hot hardness. Excellent for rebuilding corners with minimum base metal dilution. Has ability to overlay extensive areas without cracking. Will retain hardness at high temperatures. The welds are machinable and will work harden under impact.

Recommended for use in the iron and steel industries. Designed initially as a forging material for either repairs or sinking. Suitable for use on shear blades and dies, and all applications where good resistance to heat, impact, corrosion and abrasion is required. Due to its excellent impact properties and refined grain structure it is ideally suited to clipping tools and forging punches.

■ **Related Specification:**

Special manufacture no specification.

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

C	Si	Cr	Ni	Fe	Mo	Co
0.11	1.12	22.01	1.32	14.34	4.78	56.32

■ **Typical All Weld Deposit Hardness:**

25-30 RC as deposited (will work harden up to 50 RC under impact).

■ **Current:**

AC/DC.

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.40mm
70-90	90-115	110-150	140-190	220-275

■ **Storage:**

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