



MAC HICA E3075 HR

■ **Description & Applications:**

Commonly referred to as G21, however the addition of complex metal powders to the rutile flux raises the recovery rate of this electrode to approximately 170%.

This alloy also has a reduced carbon content and as such is the most resistant of all the cobalt alloys to cracking at high temperatures.

Predominantly used in the forging industry for the repair of hot working tools and dies, alternative uses would be for repairs to valve seats in the chemical industry where corrosion resistance is paramount.

Welds are machinable.

■ **Related Specification:**

AWS E Co-Cr-E

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

C	Cr	Ni	Fe	Mo	Co
0.30	31.0	4.5	3.0	5.5	Balance

■ **Typical All Weld Deposit Hardness:**

As deposited 30HRC
Post work hardening 45HRC

■ **Current:**

AC/DC (+). (min 50 OCV).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
60-90	75-120	110-150	140-190

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 250° C before use.