



## MAC SUPER STEEL VDH

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■ **Description & Applications:**

All positional superior electrode for joining light and heavy gauge mild steel. Due to its characteristics, this electrode is suited to applications in confined and awkward spaces involving positional vertical down welding.

■ **Related Specification:**

AWS E6013

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

C	Mn	Si	S	P
0.08	0.35	0.35	0.019	0.021

■ **Typical All Weld Metal Mechanical Properties:**

**As Welded**

Ultimate Tensile Strength	550 N/mm <sup>2</sup>
0.2% Proof Stress	530 N/mm <sup>2</sup>
Hardness	180 Brinell

■ **Current:**

AC/DC (+). (AC minimum 50 volts open circuit).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
55-100	90-130	130-190

■ **Storage:**

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