



## MAC SUPER STEEL

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■ **Description & Applications:**

Superior all positional mild steel electrode for joining light and heavy gauge steel sections. May be used with conventional or touch welding techniques and are particularly suitable where welding has to be carried out in confined or awkward places. Welds are ductile and of a high radiographic quality.

■ **Related Specification:**

AWS E6013

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

| C    | Si   | Mn   | P     | S     |
|------|------|------|-------|-------|
| 0.07 | 0.34 | 0.55 | 0.013 | 0.020 |

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

**As Welded**

|                           |                       |
|---------------------------|-----------------------|
| Ultimate Tensile Strength | 510 N/mm <sup>2</sup> |
| 0.2% Proof Stress         | 530 N/mm <sup>2</sup> |
| Elongation                | 29 %                  |
| Hardness                  | 160 BHN               |

■ **Current:**

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

■ **Sizes Available and Recommended Amperages:**

|        |        |        |        |         |         |         |
|--------|--------|--------|--------|---------|---------|---------|
| 1.50mm | 2.00mm | 2.50mm | 3.25mm | 4.00mm  | 5.00mm  | 6.00mm  |
| 25-50  | 40-60  | 55-100 | 90-130 | 130-190 | 190-240 | 220-290 |

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 110°C before use.