

MAC TOOL E3042

Description & Applications:

Manufactured on a high purity ferritic core wire with an alloy bearing concentrically extruded basic flux. It is used for both the maintenance and manufacture of components and tools subjected to impact and abrasion at temperatures up to 550°C. Such applications include dies, hot & cold shear blades, hammers, sewage and guillotine blades.

Typical All Weld Metal Chemical Analysis %:

| С | Mn | Si | S | Р | Cr | Mo | Fe |
|------|------|------|------|-------|-----|------|-----|
| 0.35 | 1.30 | 0.50 | 0.01 | 0.015 | 7.0 | 2.50 | BAL |

Typical All Weld Deposit Hardness:

As Deposited 55 Rockwell C

Current:

DC (+) - AC (80 amps OCV)

Sizes Available and Recommended Amperages:

2.50mm 3.25mm 4.00mm 5.00mm 50-70 80-110 140-170 170-210

Storage:

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