



MAC TOOL E3044

■ **Description & Applications:**

Manufactured on a high purity ferritic core wire with an alloy bearing chemically basic concentrically extruded flux. All positional welding characteristics with excellent control of the molten welding pool. Used to special advantage for the repair of hot working dies by single or multi layer build ups, or surfacing rollers or hot shear blades. When machining tungsten carbide tools are used to obtain the best profile. Excellent resistance to impact and abrasion up to 550°C and this is combined with the ability of the deposit to be machined make it an exceptionally versatile alloy. Pre-Heat 200°C to 300°C. Slow cool after welding. Readily machinable with carbide tools.

■ **Related Specification:**

E3-UM-40 PT

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

C	Mn	Si	Cr	Mo	Fe	S	P
0.15	0.17	0.60	5.00	4.20	BAL	0.010	0.015

■ **Typical All Weld Deposit Hardness:**

As Deposited 40 Rockwell C

■ **Current:**

AC/DC (+) (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.