



MAC TOOL E3053

■ **Description & Applications:**

Manufactured on a high purity mild steel core wire with a concentrically extruded chemically basic flux that contains the alloying elements and deoxidants. The metal recovery rate is some 130% with respect to the core wire, the electrode is suited for all positional work and the slag is easy controlled and resists control when building up edges. Mac Tool E3053 is essentially a modified high speed steel alloy to enlarge its range of welding applications on cutting tools, reamers and similar no PWHT is needed and hot hardness up to 600°C is excellent. When toughness as well as hot hardness is needed or when machining is required the alloy should be annealed and slow cooled, followed by H.T. at 1200°C followed by air cooling or quenching.

■ **Related Specification:**

Mac Tool E3053 is not covered by any national specification. However it may be compositionally coded in accordance with BS 2926 as E 2Cr Co W.

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

Mn	Si	Mo	S	P	Cr	Ti & Nb	Fe	Co	W
0.5	0.4	0.55	0.009	0.01	1.9	0.8	BAL	2.8	8.0

■ **Typical All Weld Metal Deposit Hardness:**

	Min RC	Typical RC
As deposited	57	63
Annealed at 800°C	22	25
Slow cooled		
1200°C - 600°C	59	64

■ **Current:**

AC/DC (+) DC positive (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
70-90	90-140	130-190	160-220

■ **Storage:**

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