



MAC TOOL E3060

■ **Description & Applications:**

Manufactured using a high purity, low silicon wire with a chemically basic, alloy bearing flux. May be used in a positions except vertically down, strong stable arc, fillet welds are convex, weld metal of bright appearance. Very low levels of hydrogen. Used to best advantage for downhand welding for critical repairs to die blocks when the weld metal must combine good toughness, high strength and resistance to oxidation at high temperatures, plus resistance to thermal shock.

■ **Related Specification:**

E6-UM-60

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

C	Mn	Si	Cr	Ni	Mo
0.13	1.0	0.9	9.5	1.75	3.0

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

After PWHT at 520°C :

Ultimate Tensile Strength	840-920 N/mm ²
0.2% Proof Stress	735-810 N/mm ²
Elongation	8-12 %
Hardness	38-45 RC

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm	6.00mm
90-140	150-190	190-220	250-300

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for two hours at 180°C before use.