



MAC TOOL E3061

■ **Description & Applications:**

Hard facing electrode, designed to produce deposits which will oil harden on mild, medium and low alloy steels. Easy to use, giving sound porosity free welds with considerable resistance to impact and abrasion in the as welded condition. Welds are non-machinable but can be finish ground, or annealed and re-hardened by oil quenching. For overlaying punches, dies, shear blades etc., extensive applications in earth moving, mining industries, particularly useful on excavator teeth, bucket lips, scraper blades, pug mill knives, etc.

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

C	Mn	Si	Cr	Mo	W	V
0.52	0.42	0.27	4.79	8.33	2.59	0.84

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

As deposited 58-60 Rockwell C
Annealed at 865°C 33-36 Rockwell C
Oil quenched at 1200°C 58-60 Rockwell C

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-80	90-120	130-150	150-220

■ **Storage:**

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