



## MAC TOOL E3063

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### ■ **Description & Applications:**

Low hydrogen manual metal arc electrode using a silicon free, low nitrogen C Mn core wire with a moisture resistant, chemically basic flux with a controlled iron powder addition. All positional electrode with good slag control. Exhibits good crack resistance and excellent resistance to oxidation at temperatures up to 650°C. For assembly welding of creep resistant steels with 5% Cr, 0.5% Mo and closely related grades. Used for pipe welds in the petrochemical industry.

### ■ **Related Specification:**

AWS E502-15

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

C	Mn	Si	Cr	Mo	S	P
0.06	0.7	0.3	5.0	0.55	0.01	0.01

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

Tensile Strength	470 N/mm <sup>2</sup>
0.2% Proof Stress	230 N/mm <sup>2</sup>
Elongation	32%

### ■ **Current:**

AC/DC (+)

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
70-90	90-130	130-180	160-220

### ■ **Storage:**

To guarantee weld metal hydrogen of 5ml per 100gns, damp electrodes should be re-dried for 30 mins at 150° C before use.