



MAC TOOL E3064

■ **Description & Applications:**

A low hydrogen, iron powder basic flux coated electrode. Designed for special hardfacing applications involving heavy impact loading combined with abrasion. This electrode is ideally suited for forging dies because of its very tough deposit. It is an H13 type product.

■ **Additional Data:**

Pre-heat and dilution may effect hardness on first two layers but not on subsequent layers. On heavy build-ups use Mac Trode E630 on 15% manganese steels.

■ **Related Specification:**

E6-UM-60-GP

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

C	Mn	Si	Cr	Mo	V
0.45	0.70	0.50	6.50	0.60	0.80

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

	1 st Layer	2 nd Layer	3 rd Layer
Vickers HV/20	560-600	620-680	640-680
Rockwell HRC	53-55	56-69	57-60

■ **Current:**

AC (OCV 70 amps) DC(+)

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm
80-140	100-180	140-240

■ **Storage:**

Electrodes should be kept in a dry store. If allowed to become damp the electrodes should be re-dried for one hour at 180°C before use.