



MAC TOOL E3065

■ **Description & Applications:**

A low hydrogen, iron powder basic flux coated electrode for hard facing applications involving a combination of both impact and abrasion. Easy to use, giving sound porosity free welds. Ideally suited for use in the forging industry.

■ **Related Specification:**

E6-UM-60-GP

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

| C | Mn | Si | Cr | Mo | V | W |
|------|-----|------|------|------|------|-----|
| 0.80 | 1.4 | 0.70 | 7.50 | 0.80 | 0.15 | 1.2 |

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

| | 1 st Layer | 2 nd Layer | 3 rd Layer |
|---------------|-----------------------|-----------------------|-----------------------|
| Vickers HV/20 | 600-700 | 700-730 | 700-760 |
| Rockwell HRC | 55-60 | 60-62 | 60-63 |

■ **Current:**

AC (OCV 70 amps) DC(+)

■ **Sizes Available and Recommended Amperages:**

| | | |
|--------|---------|---------|
| 3.25mm | 4.00mm | 5.00mm |
| 90-150 | 110-190 | 150-250 |

■ **Storage:**

Electrodes should be kept in a dry store. If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.