



## MAC TOOL E3068

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### ■ **Description & Applications:**

Extruded flux coated MMA electrode manufactured on a ferritic core wire with a complex alloyed chemically neutral flux coating. The alloy bearing chemically basic flux ensures excellent welding characteristics and metal recovery is some 125% with respect to the core wire. As the weld is a modified stainless it has excellent resistance to oxidation up to 1000°C and good wear resistance up to 600°C even under certain corrosive conditions. As welded the hardness of 52 – 56 HRC results, if the weld has to be machined it may be so annealed at 830°C and then re-hardened by air or oil cooling from 960°C to 1000°C. Although it may be used to weld medium carbon variants of AISI 410 it is intended to be used as a surfacing alloy as it attains a high hardness even under conditions of slow cooling, when welding large dies and tools, it is mainly air hardening.

### ■ **Related Specification:**

Mac Tool E3068 is not covered by any national specification. However it may be compositionally coded in accordance with BS 2926 as E 12Cr Ni Mo BMP.

### ■ **Nominal Analysis:**

C	Cr	Ni	Mo
0.2	12.50	2.20	2.50

### ■ **Physical Properties:**

As welded 52 – 56 HRC

### ■ **Current :**

DC+ or AC (OCV 80 amps)

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

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-110	100-160	140-200	190-260	240-300

### ■ **Storage:**

If allowed to become damp electrodes should be re-dried for one hour at 300°C before use