



MAC TOOL E3069

■ **Description & Applications:**

Extruded flux coated MMA electrode manufactured on a high purity nickel core wire with a complex alloyed chemically neutral flux coating. Metal recovery is some 150% with respect to the core wire.

Mac Tool E3069 is a nickel based Cr Co Mo alloyed precipitation hardening alloy for welding to similarly alloyed based materials used for high temperature applications.

E.g. to weld AMS 5706, 5707, 5708, 5709, 5544, 5586 or ASTM 637

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

Cr	Mo	Co	Ti + Al
20.0	4.5	14.0	4.5

■ **Related Specification:**

Mac Tool E3069 is not covered by any national specifications and the presence of six major alloying elements in its make up prevents compositional coding being applied.

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

As Welded	Rockwell B 95
Air Aged	Rockwell C 35 - 45

■ **Current:**

AC or DC

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
50-80	80-110	140-180	160-220

■ **Storage:**

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