



MAC TRADE STEEL

■ **Description & Applications :**

High quality all-positional mild steel electrode balanced specifically to give good performance in all positions. Easy to use employing touch or conventional welding techniques, smooth forceful arc, low spatter loss, easy slag detachability, clean welds of good appearance. Fabrications and repairs. Designed for joining light or heavy mild steel sections. Highly suitable for use in confined spaces.

■ **Related Specification :**

AWS E6013

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

C	Mn	Si	S	P
0.08	0.40	0.30	0.015	0.025

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

As Welded

Ultimate Tensile Strength	540 N/mm ²
0.2% Proof Stress	530 N/mm ²
Elongation	28 %
Hardness	190 Brinell
Alloy Basis	Mild Steel

■ **Current :**

AC/DC (+). (AC minimum 50 volts open circuit).

■ **Sizes Available and Recommended Amperages :**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
25-50	40-60	55-90	70-120	110-160	140-200	200-290

■ **Storage :**

If allowed to become damp the electrodes should be re-dried for one hour at 110°C before use.