



MAC TRODE E606

■ **Description & Applications:**

Specially designed high strength austenitic type electrode of duplex structure. All purpose low amperage electrode. Easy to use with smooth arc, low spatter and even bead formulation. Can be used for overlaying and joining dissimilar steels to one another, high and low carbon steels, spring steels, tool and die steels, cast steels, and steels of unknown composition. High resistance to cracking coupled with good wear, heat, impact and corrosion resistance.

■ **Related Specification:**

AWS E312-17

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.11	1.06	0.95	0.01	0.02	28.5	8.65	0.87

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

As Welded

Ultimate Tensile Strength	840 N/mm ²
Elongation	25%
Hardness	220 Brinell

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
25-35	30-45	50-70	90-110	120-140	150-190	200-250

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.