



MAC TRODE E6130

■ **Description & Applications:**

High recovery rutile type electrode for welding, surfacing and building up manganese steel components. Weld deposits have excellent impact resistance and rapid work hardening properties. For applications where a hard surface, resistant to wear under heavy impact and battering is required. For weld reclamation of crushers, railway frogs and crossings and for reclamation of defective manganese steel castings. For welding manganese steels to each other or to mild and low alloy steels. Cool between runs on thick sections to prevent surface fissuring.

■ **Related Specification:**

AWS E Fe-Mn-B

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

C	Mn	Cr	Ni
0.8	13.0	5.0	3.0

■ **Deposited Weld Metal Structure:**

To achieve required properties and analyses at least 3 layers of weld metal must be deposited, when welding on mild and low alloy steels. Keep work piece as cool as possible to achieve maximum weld soundness. Water quench if necessary.

■ **Typical Hardness Values:**

As deposited	230 - 245 Brinell - 20 Rockwell C
Work Hardened	480 - 550 Brinell - 50 Rockwell C

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
80-110	110-140	150-180	180-210	210-240

■ **Storage:**

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