



MAC TRODE E61418-G

■ **Description & Applications:**

Low hydrogen manual metal arc welding electrode using a silicon free, low nitrogen, high purity C:Mn core wire with a concentrically extruded, moisture resistant chemically basic flux with a controlled iron powder addition. Specially developed for the repair of hot working dies, where a final hardness in the region of 30–35 RC is required. The electrode has excellent running characteristics, with easy striking and good slag detachability

■ **Related Specification:**

AWS E14018-G

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

C	Si	Mn	P	S	Mo	Cr	Ni
0.10	0.35	1.5	0.010	0.010	1.1	1.5	2.3

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

As Welded

Hardness >35Rc

■ **Stress Relieved**

Hardness >33Rc

■ **Current:**

AC/DC

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm	6.00mm
110-150	140-200	200-260	250-370

■ **Storage:**

Electrodes should be kept in a dry store. If electrodes become damp they should be re-dried at 250°C-300°C for 2 hours