



MAC TRODE E616

■ **Description & Applications:**

Superior 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 formation. 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, ferritic to austenitic steels and steels of unknown composition. High resistance to cracking coupled with good wear, heat, impact and corrosion resistance. Therefore this electrode has uses in practically every type of industry resulting in one of the most universally used electrodes for problem and unknown steels

■ **Related Specification:**

AWS E312-17

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.095	0.99	0.75	0.015	0.026	29.8	10.1	0.92

■ **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.