



MAC TRODE E62000

■ **Description & Applications:**

Manufactured using a low silicon, moderate manganese core wire with a highly chemically basic flux, which ensures the metallurgical integrity of the weld, by controlling to very low levels of dissolved gases such as oxygen and nitrogen. May be used AC (OCV 80) or DC+, the optimum weld ability being obtained with the latter. This alloy is specifically designed for the repair of heavy die blocks, when detailed geometry of the component and the size of section restrict both pre-heat and post weld heat treatment. The high yield strength of this deposit combined with excellent toughness will absorb heavy impact and shock loading.

■ **Related Specification:**

No direct classification exists for this alloy, the nearest would be AMS 6468B

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

C	Mn	Si	S	P	Cr	Ni	Mo	Co	V
0.35	0.15	0.17	0.015	0.025	4.5	12.0	1.5	0.9	0.3

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

As Welded

0.2% Proof Stress	100 N/mm ²
Impact Energy +20°C	80 Joules

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
70-90	90-120	140-170

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 300°C before use.