



## MAC TRODE E630

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### ■ **Description & Applications:**

Tough high strength, fully austenitic electrode, designed to resist heat and impact. Fully machinable. Weld deposit will work harden under impact and retain properties at high temperatures. Easy to use in all positions producing sound welds, good build-up characteristics and good slag detachability. For joining or overlaying mild and alloy steels, spring steels, heat resisting steels, ideal for the repair of drop forging dies. Suitable for use as a buffer layer prior to hard surfacing of manganese steel, and may be used for welding manganese steel rails or similar applications involving friction, impact or corrosion.

### ■ **Related Specification:**

AWS E307-17  
Type 20.10.4 Mn

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

C	Mn	Si	S	P	Cr	Ni
0.1	3.75	0.55	0.016	0.02	20.0	10.0

### ■ **Weld Metal Micro Structure:**

Fully Austenitic

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

#### **As Welded**

Ultimate Tensile Strength	650 N/mm <sup>2</sup>
Elongation	40%
Hardness	220 Brinell
Hardness (work hardened)	350 Brinell

### ■ **Current:**

AC/DC (+).

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
60-95	70-120	110-140	130-160	120-200

### ■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 250°C before use.