



MAC TRODE E63000

■ **Description & Applications:**

Manufactured using a low silicon, moderate manganese core wire with a highly chemically basic flux coating. The weld metal has excellent resistance to oxidation at elevated temperatures and excellent toughness after PWHT. Designed for welding die blocks etc when the application of PH9 or PWHT does not represent any difference. Used in the 'as welded' condition this alloy is suited to those components subjected to abrasion at extended temperatures. Used in the 'tempered' condition, toughness and resistance to impact loading increases, which extends its range of use to die blocks.

Weld metal hardness – as welded HV660 with good toughness. The weld may be annealed by PWHT at 750°C followed by slow cooling.

■ **Related Specification:**

Modified AWS E410-15

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

C	Mn	Si	S	P	Cr	Ni
1.4	0.7	0.8	0.018	0.015	11.0	0.10

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

<u>As Welded</u>	<u>Typical</u>
Ultimate Tensile Strength	600 N/mm ²
0.2% Proof Stress	100 N/mm ²
Elongation on 4d	24 %
Reduction of Area	46 %
Impact Energy +20°C	40 Joules
PWHT	760°C Furnace cooled

■ **Additional Data:**

Fully Martensitic Microstructure

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-90	90-130	140-170

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 180°C before use.