



## MAC TRODE E630S

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### ■ **Description & Applications:**

Tough high strength, synthetic austenitic electrode designed to resist heat and impact. Fully machinable, with a recovery rate of 170%. Easy to use in all positions producing sound welds, good build-up characteristics and good slag detachability. Weld deposit will work harden under impact and retain properties at high temperatures. For joining and overlaying mild and alloy steels, spring steels and heat resisting steels. 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 E307-26

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

C	Mn	Si	S	P	Cr	Ni
0.1	1.45	0.55	0.016	0.02	22.0	10.0

### ■ **Weld Metal Micro Structure:**

Fully Austenitic

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

#### **As Welded**

Ultimate Tensile Strength	620 N/mm <sup>2</sup>
Elongation	40%
Hardness	220 Brinell
Hardness (work hardened)	300 Brinell

### ■ **Current:**

AC/DC. DC (+)

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

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

### ■ **Storage:**

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