



MAC TRODE E6410 NM HR

■ **Description & Applications:**

High quality superior low hydrogen type electrode for welding high strength martensitic corrosion resistant stainless steel. Has moisture resistant rutile flux coating with a recovery rate of approximately 150%. Easy to strike and restrike, smooth flowing electrode with low spatter and excellent slag detachability. Welds are of smooth flat appearance. For welding high strength corrosion resistant martensitic stainless and cast steels which have superior sulphide-induced SCC hydro-cavitation properties (when compared with plain 12% Cr steels).

■ **Related Specification:**

AWS E410-Ni Mo-26

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

| C | Mn | Si | S | P | Cr | Ni | Mo | Fe |
|-------|------|------|-------|------|-------|------|------|-----|
| 0.060 | 0.24 | 0.24 | 0.007 | 0.01 | 12.40 | 4.45 | 0.51 | BAL |

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

As Welded

| | |
|---------------------------|------------------------|
| Ultimate Tensile Strength | 1150 N/mm ² |
| Elongation on 4d | 17% |
| 0.2% Proof Stress | 950 N/mm ² |
| Reduction of Area | 45 |
| Impact Energy -20°C | 50 J |

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

| | | |
|--------|--------|---------|
| 2.50mm | 3.25mm | 4.00mm |
| 70-110 | 80-140 | 100-170 |

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150°C before use.