



MAC TRODE E6410 NM

■ **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 130%. 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-16

■ **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.