



MAC TRODE E6410

■ **Description & Applications:**

High quality low hydrogen type electrode specially designed for welding 12% Cr martensitic steel which air hardens to produce high strength. (For increased toughness use E6410NM). Easy to strike and restrike, smooth flowing electrode with low spatter and excellent slag detachability. Welds are of a smooth flat appearance. For joining and the repair of wrought and cast steels subject to corrosion and oxidation. If post weld heat treatment is not possible then an austenitic type stainless steel electrode should be used.

■ **Related Specification:**

AWS E410-16

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

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Mo
0.045	0.62	BAL	0.01	0.009	0.34	0.04	0.03	12.80	0.20

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

As Welded

Ultimate Tensile Strength	520 N/mm ²
Elongation on 4d	36%
0.2% Proof Stress	280 N/mm ²
Reduction of Area	52%
Impact Energy -20°C	50 J

■ **Current:**

AC/DC+ (AC Min 70OCV.)

■ **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.