



MAC TRODE E6410B

■ **Description & Applications:**

Chemically basic coated low hydrogen electrode manufactured on a high purity mild steel core wire. Easy to strike electrode with good slag control, which produces porosity free weld deposits. Recommended for welding cast 410 martensitic stainless steel.

■ **Weld Metal Properties (Typical):**

After P.W.H.T. 790°C/5 hrs, 700°C/5 hrs as required by ASTM CA15 and CA15M 12 Cr casting.

■ **Additional Information:**

3.25mm will be all positional if electrode is for offshore work. (NACE requirement for P.W.H.T.) 680°C/2 hrs, 620°C/2 hrs.

■ **Related Specification:**

AWS E410-25

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.05	0.80	0.30	0.010	0.020	12.0	1.50	0.03

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

As Welded

Ultimate Tensile Strength	660 N/mm ²
Elongation on 4d	26%
0.2% Proof Stress	470 N/mm ²
Reduction of Area	68
Hardness	18
Charpy V Notch J at 20°C	100

■ **Current:**

AC/DC (+) (AC Min OCV 70)

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm
80-140	100-140	150-240

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 400°C before use.