



MAC TRODE E6430 NM

■ **Description & Applications:**

Semi basic flux coated MMA electrode made on a high purity mild steel core wire giving a metal recovery of 125% with respect to the core wire. The weld metal is of low hydrogen quality.

■ **Related Specification:**

No national specification

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

	C	Mn	Si	S	P	Cr	Ni	Mo
Min	0.00	0.00	0.00	0.00	0.00	16.0	4.0	0.80
Max	0.005	1.00	0.50	0.03	0.03	17.5	8.0	1.2

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

As Welded

Ultimate Tensile Strength	960 N/mm ²
Elongation on 4d	15%
0.2% Proof Stress	720 N/mm ²

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	90-130	130-180	160-220	250-300

■ **Storage:**

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