



MAC TRODE E6430

■ **Description & Applications:**

MMA type welding electrode manufactured on a pure low carbon core wire with a recovery rate of 130% with respect to the core wire. This electrode has a moisture resistant coating giving very low weld metal hydrogen levels. It has good scaling resistance in air up to 820°C and low corrosion rate in sulphur bearing gases e.g. in H₂/H₂S mixtures some 5 to 10 times better than 12% Cr steels at 300°C-500°C. Mac Trode E6430 is immune to hydrogen attack at high temperatures and will resist stress corrosion cracking in boiling chloride, nitrate and alkali solutions. Used in the cast and wrought form in industries such as chemical, petrochemical and steam generating industries. It is also suitable for welding Cr Si Al steels with up to 18% Cr, used for furnace parts and exhaust ducting.

■ **Related Specification:**

AWS E430-16

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

C	Mn	P	S	Si	Cu	Ni	Cr	Mo
0.08	0.40	0.015	0.010	0.30	0.05	0.10	17.0	0.05

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

As Welded	After PWHT
Ultimate Tensile Strength	520 N/mm ²
0.2% Proof Stress	360 N/mm ²
Elongation on 4d	24 %
Reduction of Area	50 %
HV 40	190

■ **Current:**

DC (+) (OCV 70 amps) min

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
70-110	80-140	100-180

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 300°C before use.