



## MAC TRODE E64W

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■ **Description & Applications:**

High quality austenitic stainless steel rutile coated electrode, depositing 23% Cr, 12% Ni, 2% W weld metal to resist corrosion, heat and friction. Tungsten in the weld metal produces high strength, scale and general wear resistance at temperatures up to 1100°C. For joining and overlaying various steels especially heat resistant steels, HR Crown 1 type – primarily furnace applications and particularly suitable for repairs to mandrels used in hot forming of tubular components.

■ **Related Specification:**

AWS E309W-16 23Cr,12Ni, 2W – Special.

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

C	Cr	Ni	Mn	W	Si	S	P
0.065	23	12	1.65	2.00	0.50	0.015	0.010

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

**As Welded**

Ultimate Tensile Strength	680 N/mm <sup>2</sup>
Elongation	30-35%
Hardness	220 Brinell

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm
70-110	110-140	140-180

■ **Storage:**

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