



## MAC TRODE E65

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### ■ **Description & Applications:**

Synthetic austenitic stainless steel electrode of 22Cr, 10Ni, 3Mo type, designed mainly for joining hardenable high tensile steels, armour plate and dissimilar steel combinations including stainless to mild steel. Smooth positive arc, good slag detachability, high deposition rate and good bead formation. Produces sound welds with lower pre-heat temperatures than would normally be expected. Repairs to armour plate, mild to low alloy high tensile steels, and for joining such to stainless and other difficult steels. Should not be used when extreme conditions, such as elevated or cryogenic temperatures exist.

### ■ **Related Specification:**

AWS E309Mo-16 22Cr, 10Ni, 3Mo - Special

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.09	0.5	1.5	0.015	0.012	22	10	3.0

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

#### **As Welded**

Ultimate Tensile Strength	680 N/mm <sup>2</sup>
Elongation	30%
Hardness	190 Brinell

### ■ **Current:**

AC/DC (+).

### ■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
80-120	120-175	160-210	200-275

### ■ **Storage:**

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