



MAC TRODE E6502

■ **Description & Applications:**

Low hydrogen manual metal arc electrode using a silicon free, low nitrogen C Mn core wire with a moisture resistant, chemically basic flux with a controlled iron powder addition. All positional electrode with good slag control. Easy to strike electrode which produces porosity free weld deposits. Exhibits good crack resistance and excellent resistance to oxidation at temperatures up to 650°C. For assembly welding of creep resistant steels with 5% Cr, 0.5% Mo and closely related grades. Used for pipe welds in the petrochemical industry.

■ **Related Specification:**

AWS E502-15

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

C	Mn	Si	S	P	Cr	Mo
0.06	0.7	0.3	0.01	0.01	5.0	0.55

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

As Welded

Ultimate Tensile Strength	470 N/mm ²
Elongation on 4d	32%
0.2% Proof Stress	230 N/mm ²

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

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

■ **Storage:**

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