# MAC TRODE E6505-Sb Free

## Description & Applications:

Basic flux coated 9 Cr 1 Mo electrode for high temperature service in power generating plants with controlled additions of Nb-V-N2 to enhance creep resistance and a moderate Nickel level to enhance toughness.

## Related Specification:

AWS E9015-B9

## Typical All Weld Metal Chemical Analysis %:

| Mn | Si | S | P | Cr | Mo | Ni | Nb | V | N |
|---|---|---|---|---|---|---|---|---|---|
| 0.7 | 0.25 | 0.010 | 0.008 | 8.8 | 1.0 | 0.7 | 0.05 | 0.2 | 0.05 |

## Typical All Weld Metal Mechanical Properties:

**As Welded**

| | **(P.W.H.T. 750°C – 2 hours)** | |
|---|---|---|
| | **Minimum** | **Typical** |
| Ultimate Tensile Strength | 650 N/mm² | 650 – 780 N/mm² |
| Elongation on 4d | 17% | 20% |
| 0.2% Proof Stress | 550 N/mm² | 750 – 880 N/mm² |
| Reduction of Area | - | 60 |
| Impact Energy +20°C | 47 Joules | 80 Joules |

## Current:

DC (+). AC (OCV 80) min

## Sizes Available and Recommended Amperages:

| 2.50mm | 3.25mm | 4.00mm | 5.00mm |
|---|---|---|---|
| 70-105 | 80-135 | 100-175 | 140-235 |

## Storage:

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

**WELDFAST MWA** Unit 9 Prospect Business Park Longford Road
Cannock United Kingdom WS11 0LG
Tel: (44)121 556 6366 **www.mwa-international.com**

Company Registered No. 5668641
VAT Registration No. 874 5884 65