



MAC TRODE E6505

■ **Description & Applications:**

A 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. Exhibits good crack resistance. Mac Trode E6505 is designed specifically for welding a range of 9% Cr Mo forged and cast steels, for use in the fabrication and repair of pressure vessels.

■ **Related Specification:**

AWS E505-15 E8018-B6

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

C	Mn	Si	S	P	Cr	Mo	Fe	Cu	Ni
0.060	0.73	0.55	0.015	0.01	9.56	1.15	BAL	0.04	2.14

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

As Welded

Ultimate Tensile Strength	520 N/mm ²
Elongation on 4d	32%
0.2% Proof Stress	480 N/mm ²
Reduction of Area	75%
Impact Energy -10°C	35 Joules

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.0mm	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.