



## MAC TRODE E6509W

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### ■ **Description & Applications:**

A modified 9% Chromium Molybdenum type known as E911 low hydrogen electrode using a free, low Nitrogen, high purity Carbon and Manganese core wire with a concentrically extruded, moisture resistant chemically basic flux to ensure very low weld metal hydrogen. Easy to strike electrode with good slag control, which produces porosity free weld deposits.

The addition of 1% Tungsten gives increased creep strength at elevated temperatures over P91 types.

### ■ **Related Specification:**

There is no national specification for this product (modified 9%Cr-Mo)

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

C	Mn	Fe	P	S	Si	Ni	Cr	Mo	W	Nb
0.10	0.90	BAL	0.01	0.008	0.30	0.60	9.50	1.00	1.00	0.06

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

#### **As Welded**

Ultimate Tensile Strength	760 N/mm <sup>2</sup>
Elongation on 4d	19%
0.2% Proof Stress	620 N/mm <sup>2</sup>
Reduction of Area	62%
Impact Energy +20°C	60 Joules

### ■ **Current:**

AC/DC (+). (AC OCV 70V)

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

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
70-90	90-130	130-180	160-220	200-280

### ■ **Storage:**

If allowed to become damp the electrodes should be re-dried before use.

Redry at 250 - 300°C 1-2 hours to ensure H<sub>2</sub> <10ml/100g

300 - 350°C 1-2 hours to ensure H<sub>2</sub> <5ml/100g

Maximum of 3 cycles at 420°C or 10 hours in total.