



## MAC TRODE E6610

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■ **Description & Applications:**

A cellulose electrode for welding by the vertical down technique. Also recommended for welding general mild steel fabrication work in all positions. An extremely fast deposition rate can be obtained by using a 'touch' or short arc technique, the electrode provides a very steady arc over a wide range of current values. Smooth and regular weld beads are obtained with absence of undercut. Ideal for vertical down butt welds in oil storage tanks.

■ **Related Specification:**

AWS E6010C

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

C	Mn	Si	S	P
0.14	0.4	0.15	0.02	0.02

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

**As Welded**

Ultimate Tensile Strength	530 N/mm <sup>2</sup>
Elongation on 4d	24%
Reduction of Area	60%
Charpy V notch at 0°C	70 Joules

■ **Current:**

AC/DC (+). (Min OCV 90)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
65-90	90-120	120-160	135-200

■ **Storage:**

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