



## MAC TRODE E6630

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■ **Description & Applications:**

Low hydrogen manual metal arc electrode using a silicon free, low carbon, high purity, C:Mn core wire with a concentrically extruded, moisture resistant rutile flux, with a recovery rate of approximately 130% with respect to core wire. Easy strike electrode which produces porosity free weld deposits.

■ **Related Specification:**

AWS E630-16

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

C	Mn	Fe	P	S	Si	Cu	Ni	Cr
0.076	0.70	BAL	0.010	0.010	0.40	2.10	4.10	15.20

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

**As Welded**

Ultimate Tensile Strength	520 N/mm <sup>2</sup>
Elongation on 4d	36%
0.2% Proof Stress	280 N/mm <sup>2</sup>
Reduction of Area	52%
Impact Energy -20°C	50 Joules
HV10	330

■ **Current:**

DC (+). (OCV 70amps) min

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
70-110	80-140	100-180

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 300°C before use.