



## MAC TRODE E66S

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■ **Description & Applications:**

High strength rutile coated synthetic electrode for joining and overlaying dissimilar steels. Economical high recovery electrode produces a 29/9 type stainless steel weld deposit. Positive smooth arc, easy slag removal and builds up rapidly. Can be used in all positions. Ideal for buttering layers or overlaying steels to combat heat, friction and impact, where economy is of the utmost importance. Covers large areas quickly. Will join stainless to carbon steels and steels of unknown quantity.

■ **Related Specification:**

AWS E312 – 16

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

C	Si	Mn	P	S	Cr	Ni
0.08	0.7	0.80	0.01	0.009	29.15	9.5

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

**As Welded**

Ultimate Tensile Strength	695 N/mm <sup>2</sup>
Elongation	25-30%

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
80-120	120-175	160-210	200-275

■ **Storage:**

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