



MAC TRODE E66V

■ **Description & Applications:**

Superior high strength austenitic type electrode of duplex structure for joining and overlaying all steels. This variation of Mac Trode E66 is designed specifically to overcome difficult deslagging problems on high manganese tool steels and for inclined vertical down welding and root runs on certain thick sections. Has high resistance to cracking. Wear, heat, impact and corrosion resistant. Used for overlaying and joining dissimilar steels to one another, high and low carbon steels, spring steels, tool and die steels, cast steels, ferritic to austenitic steels and steels of unknown composition.

■ **Related Specification:**

AWS E312 – 16 Variation

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

C	Si	Mn	P	S	Cr	Ni	Mo
0.095	0.75	0.99	0.26	0.15	29.8	10.1	0.92

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

As Welded

Ultimate Tensile Strength	850 N/mm ²
Elongation	25%
Hardness	220 Brinell

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

1.50mm	2.00mm	2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
25-35	30-45	50-70	90-110	120-140	150-190	200-250

■ **Storage:**

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