



## MAC Trode E6716

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■ **Description & Applications:**

Manual Metal Arc welding electrode with a silicon free C: Mn core wire with a concentrically extruded chemically basic flux coating which has been so modified to provide good weldability on poor quality AC welding sets.

■ **Material to be welded:**

Mild and medium carbon-manganese steels up to 15mm thick with a UTS of 500N/mm<sup>2</sup> max. Typical grades:- BS1449 plate and sheet BS4360 grade 43A and 43C Lloyds A and D ship steel BS4360 grade 50B, Lloyds grade AH and DH BS3059 and BS3601 grade 320-410 AP15L A-B and X42, BS4360-50B-50C-50D, BS1501-151 430-490, BS3602-410-460.

■ **Related Specification:**

AWS E7016

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

C	Si	Mn	P	S
0.08	0.65	0.80	0.020	0.020

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

**As Welded**

		Min	Typical
Tensile Strength	N/mm <sup>2</sup>	510	580
0.2% Proof Stress	N/mm <sup>2</sup>	420	500
Elongation on 4d	%	20	28
Reduction of area	%		70
Impact energy – 0°C	Joules	47	100

■ **Current:**

AC/DC DC electrode positive (+-) AC (OCV 50) Min

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
60-100	80-130	120-170	140-200	190 - 250

■ **Storage:**

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