



MAC TRODE E6724

■ **Description:**

High quality mild steel iron powder electrode with recovery rate of 170%-180% with respect to the weight of the core wire. Designed specifically for mild steel heavy fabrications where downhand (@V' preparation) welding involves large volume deposits to be laid using single or multipass techniques. Easy to use electrode employing either conventional to touch welding techniques.

■ **Related Specification:**

AWS E7024

■ **Materials to be welded:**

Heavy mild steel fabrication where extended runs are involved demanding large volume of weld metal deposits in the shortest possible time. Can be used for either fillet or butt joints. Mild and medium carbon-manganese steels up to 15mm thick with a UTS of 500 N/mm² max. Typical grades – BS1449 plate and sheet BS4360 grades 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.

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

C	Mn	Si	S	P
0.06	0.50	0.30	0.021	0.024

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

<u>As Welded</u>		Min	Typical
Tensile Strength	N/mm ²	510	540
0.2% Proof Stress	N/mm ²	420	480
Elongation on 4d	%	22	28
Reduction of area	%	-	70
Impact energy 0°C	J	47	55

■ **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
90-110	140-175	200-230	230-280	280-320

■ **Storage:**

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