



## MAC TRODE E6728

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■ **Description:**

High quality mild steel iron powder electrode with recovery rate of 150%. Designed specifically for mild steel heavy fabrications where downhand, ('V' preparation) welding involves large volume deposits to be laid using single or multipass techniques. Very easy slag detachability – self releasing. Ideal for heavy mild steel fabrications where extended runs are involved demanding large volumes of weld metal deposits in the shortest possible time. Can be used for either fillet or butt joints

■ **Related Specification:**

AWS E7028

■ **Materials to be welded:**

BS1449, BS4360, GRADE 43A, 43C, 50B, 50C & 50D  
LLOYDS A & D SHIP STEELS, LLOYDS AH & DH  
BS1501-151, 430-490

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

C	Mn	Si	S	P
0.08	1.10	0.45	0.011	0.009

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

<u>As Welded</u>		Min	Typical
Tensile Strength	N/mm <sup>2</sup>	510	560
0.2% Proof Stress	N/mm <sup>2</sup>	420	460
Elongation on 4d	%	22	25
Reduction of area	%	-	70
Impact energy -60°C	J	-	110

■ **Current :**

AC/DC DC electrode positive (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
90-110	100-140	140-190	170-230	260-320

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 400°C before use.