



MAC TRODE E6818-C3

■ **Description & Applications:**

A low hydrogen, basic flux coated, low alloy electrode. Using a silicon free, low nitrogen, high purity C. Mn core wire with an extruded moisture resistant chemically basic flux with a controlled iron powder addition. For welding thick sections of ferritic steels when it is not always possible to apply post weld stress relief heat treatment. High strength levels and good toughness down to -50°C e.g. BS 4360 Grade 43E – 50E – 55L – 55EE – 55EF.

■ **Related Specification:**

AWS E8018-C3

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

C	Si	Mn	P	S	Ni	Mo
0.07	0.30	1.30	0.008	0.007	0.90	0.55

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

<u>As Welded</u>		<u>Typical</u>
Tensile Strength	N/mm ²	630
0.2% Proof Stress	N/mm ²	530
Elongation on 4d	%	27
Reduction of area	%	70
Impact Energy -40°C	Joules	120

■ **Current:**

DC +/- AC (OCV 70) Min

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.00mm
60-100	85-140	140-190	200-250	260-340

■ **Storage:**

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