



MAC TRODE RAIL ROD

■ **Description & Applications:**

High recovery (115%) Low Hydrogen electrode for the welding of rails. Due to the excellent resistance to compressive loading, this electrode is ideal for the welding of rail steels. Low and medium Carbon rail steels. Minimal slag formation permits a slag over slag technique. Ideally Pre-Heat to 200-250C and maintain an inter pass temperature of around 400C.

■ **Related Specification:**

No related specification

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

C	Mn	Si	S	P	Cr	Ni	Mo
0.1	1.2	0.5	0.008	0.01	2.3	0.2	0.3

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

As Welded

0.2% Proof Stress	700 Mpa
Ultimate Tensile Strength	900 Mpa
Elongation 4d	17%
Hardness (HV)	280

■ **Current:**

DC (+) or AC (OCV 70V min)

■ **Sizes Available and Recommended Amperages:**

3.25mm	4.00mm	5.00mm	6.00mm
100-160	140-190	200-280	230-370