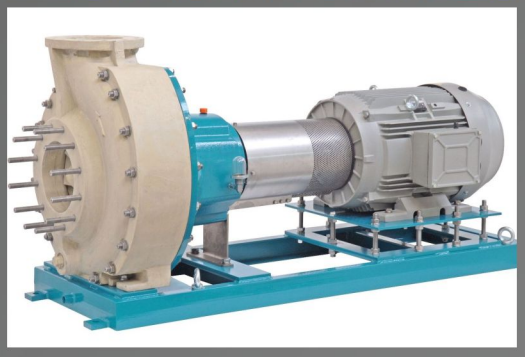
Low-Heat Input Welding Alloys

SME A07



SENOR®

One Stop Solution for Welding & Brazing Consumables

SME A07	Electrodes for MMAW Process	Steels

Low-Heat Input Welding Alloys

Alloy Basis :

Cr, Mn, Ni

Characteristics :

SME A 07 an electrode with high resistance to heat and corrosion. Fully austenitic electrode with high strength and resistance to heat and corrosion. Scale resistance up to 1200°C. Suitable for positional welding .The deposit is tough, crack-proof and war resistant..

Technical Data :

UTS : 55-75 kgf/mm^2
Elongation : 30-35%

Applications :

1. Cladding Carbon steels, hydrogenation plants, combustion chamber parts furnace parts
2. Used for joining and surfacing of all types of steels, alloy steels, heat, scale resistant steels, manganese steels and dissimilar steels.
3. As a cushioning layer under hard deposits,
4. Fabricating and repairing of valves, rolls, gears, hot dies, parts subject to heat, corrosion and impact.

Welding Current : AC / DC (+)

Size (˜ mm)/ Length	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	40 - 75	70 - 110	110 - 140

Availability:

Standard Size:5.0, 4.0, 3.2 and 2.5 in 350 mm length
Packing: 2 , 5 Kg.

Note On Usage:

1. Clean the area to be welded thoroughly.
2. Prepare edges of heavy section depending on thickness.
3. Preheating depends on the composition of parent metal.
4. Stringer bead technique with short arc is recommended.
5. De-slag every pass for good penetration.
6. Bake the electrode at 300°C for 1 hour.
7. Back whip to fill craters.
8. Do not exceed recommended welding parameters

Above are basic guidelines and will vary depending on joint design, number of passes and other factors.

WARNING

Protect yourself and others. Read and understand this warning. Do not remove this warning.

Fumes and Gases can be hazardous to your health

- Before use, read and understand the Material Safety Data Sheet (MSDS), the manufacturer's instructions, and your employer's safety practices.
- If MSDS is not enclosed. Obtain from your employer.
- Keep your head out of the fumes. See Section 5 of the MSDS for specific fume concentration limits.
- Use enough Ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding.

Electric Shock can kill

- Always wear dry insulating gloves
- Insulate yourself from work and ground.
- Do not touch live electrical parts.

ARC Rays can injure eyes and burn skin

- Wear welding helmet with correct filter.
- Wear correct eye, ear, and body protection.

Welding can cause fire or explosion

- Do not weld near flammable material.
- Watch for fire, keep, extinguisher nearby.

Read American National Standards Z49.1, "Safety In Welding, Cutting and Allied Process." from American Welding Society.