

Low-Heat Input Welding Alloys

SME A15



 **SENOR[®]**
One Stop Solution for Welding & Brazing Consumables

SME A15

Electrodes for MMAW Process

Cast Iron

Low-Heat Input Welding Alloys

Alloy Basis :

Ni,

Characteristics :

SME A15 is an electrodes for cold welding of cast iron and has smooth stable arc and is good for positional welding. The heat affected zone is machinable since there is little mixing up with base material.



Technical Data :

UTS : 30-35 kgf/mm²

Applications :

1. Surfacing cast iron parts subject to erosion, corrosion and high temperatures
2. Cold welding of cast iron without preheat and for joining cast iron to mild steel
3. repairing intricate cast iron parts electric motor bodies and covers, machine frames, water pump housing, gears
4. salvaging foundry castings, gear box and differential housing sugar mill rollers, glass moulds and cast iron dies

Welding Current : AC / DC (-)

Size (~ mm)/ Length	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	50 - 75	65 - 110	90 - 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 welding area by wire brush. Remove cracked metal
- 2) Use a short arc with low current to deposit a stringer bead not exceeding 50 mm
- 3) Follow the recommended welding parameters to achieve good deposit
- 4) After welding allow parts to slow cool in air
- 5) Peen the deposit to reduce residual stresses

Clean the welding zone and check the surface for cracks and defects. Use short arc with low current to deposit stringer bead not exceeding 25 mm. Hot Peen the deposit to reduce residual stresses.

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.