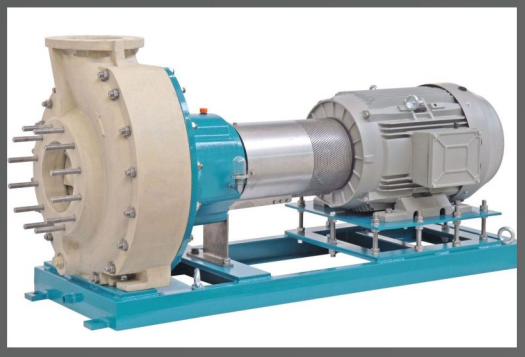
Low-Heat Input Welding Alloys

SME A17



SENOR®

One Stop Solution for Welding & Brazing Consumables

SME A17	Electrodes for MMAW Process	Cast Iron

Low-Heat Input Welding Alloys

Alloy Basis :

C, Fe, Si

Characteristics :

SME A17 is non-machinable electrode for welding cast iron. This gives good bonding properties even on difficult to weld cast iron. Close color match between deposit and base material. One can Shape by grinding

Technical Data :

UTS : upto 45 kgf/mm^2

Applications :

1. Suitable for welding or surfacing of cast Iron to steel.
2. Suitable for use on rusty, corroded and oil soaked parts.
3. Economical for repair of foundry defects or cracked castings.
4. Deposit final pass with SME A15 or SME A19 for better machinability

Welding Current : AC / DC (+)

Size (˜ mm)/ Length	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	50 - 75	70 - 115	100 - 140

Availability:

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

Note On Usage:

1) Clean the welding area by wire brush. Remove cracked metal.
2) Use low amperage and short arc and guide electrode steeply since the electrode gives a spray transfer which helps for dealing pores on cast Iron.
3) For better machinability of welded joint weld the cover passes with either SME A15 or SME A19.
4) Follow the recommended welding parameters to achieve good deposit.
5) After welding allow parts to slow cool in air.

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.