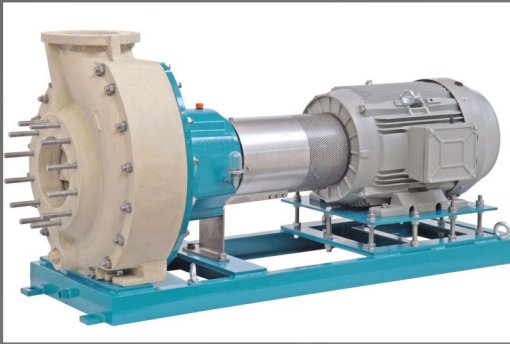


Low-Heat Input Welding Alloys

SME E01



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

Low-Heat Input Welding Alloys

Alloy Basis :

Ni, Al, Ti

Characteristics :

SME E01 delivers weld which has good resistance against corrosion and Oxidation and gives Porosity-free, crack-resistant deposit. Gives minimum spatter level slag which is thin, removes easily leaving behind smooth shining and uniform weld bead which is of radiographic quality.



Technical Data :

UTS : 41-55 kgf/mm²
Elongation (L = 4d) : 20-30%

Applications :

1. Apparatus construction, chemical industry, valves and pipe lines.
2. Welding of pure nickel and nickel-plated steels.
3. Overlay of nickel on steel.
4. Joint welding of copper and copper alloys with steel.

Welding Current : DC (+)

Size (~ mm)/ Length	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	50 - 80	90 - 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.
2. Dry the electrode prior to welding for 2 hours at 300°C.
3. Use short arc with stringer bead technique as far as possible..
4. Use DCRP (DC+) for best results.
5. 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.