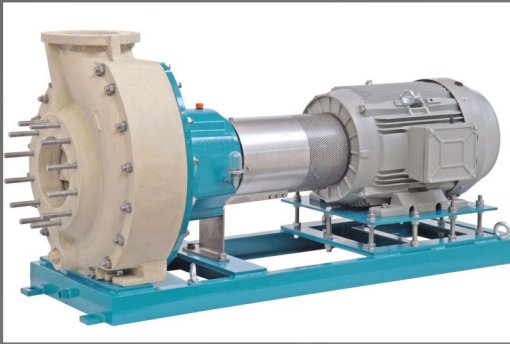


Low-Heat Input Welding Alloys

SME E11



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

SME E11

Electrodes for MMAW Process

Ni & Ni Alloys

Low-Heat Input Welding Alloys

Speicification:

AWS / SFA 5.14M : ER Ni Cu-7
UNS No. : N04060
DIN 1736 : SG-Ni Cu 30 Mn Ti

Characteristics :

SME E11 is an electrode for low heat input welding of Nickel and suitable for Corrosion resistance against seawater, heat & good creep-resistance at high temperature The weld metal is free from porosity and resistant to many chemicals.. Suitable for applications with working temperatures from -196 to +450°C. Protection of the reverse side is necessary when welding root runs.



Technical Data :

UTS : 48-53 kgf/mm²
Elongation (L = 5D) : 30-40%

Applications :

1. Pump impellers, tubes
2. Welding of Monel and Monel-clad steels. Joining Monel to steel.
3. Chemical Industry, Oil Industry, Shipbuilding Industry
4. Distillation tower, tanks

Welding Current : DC (+)

Size (~ mm)/ Length	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	60 - 75	90 - 120	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.
2. Preheat sections above 25 mm.
3. Use short arc and adopt stringer bead technique.
4. Chip the slag completely.
5. Allow the job to cool slowly to room temperature.
6. 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.