SME A06

WELD DEPOSITS WITH HIGH STRENGTH, TOUGHNESS AND EXTREME CRACK RESISTANCE TO ALL STEELS

Alloy Basis

Cr, Mn, Ni

Characteristics :

Deposits are superior crack resistance, spray type metal transfer, joining steels of unknown compositions, machinable, built-up and overlay refined grain structure improved strength and ductility.

Typical Applications

Heavy machinery parts, earthmoving equipment parts, automobile springs, trunnions of cement mills, parts subject to heat, corrosion and impact. Joining and surfacing of high carbon, low and high alloy steels. also used for welding of dissimilar steels.

Mechanical Properties

Tensile Strength : 750 – 850 MPa
Elongation : 20 – 25 %

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	60 - 90	90 - 110	130 - 160	160 - 180

Availability:

Standard Size: 5.0, 4.0, 3.15, 2.5 in 350 mm length
Packing: 2 kg.

Procedure

Clean the weld area. Preheat high alloy and high carbon steel to about 200-250°C followed by slow cooling after welding. Hold a short arc and adopt a stringer bead technique. Hot peening is advisable on joints.