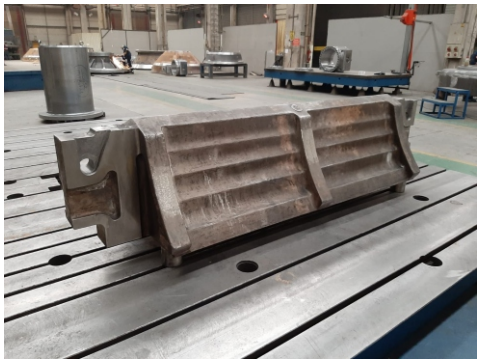
SME A08

ELECTRODE FOR WELDING AUSTENITIC MANGANESE STEELS



Alloy Basis

Cr, Ni, Mn

Characteristics :

SME A08 is an austenitic stainless-steel electrode offering excellent heat resistance up to 900°C and strong impact resistance. It is highly resistant to atmospheric corrosion, seawater and weak acids. The electrode produces a corrosion-resistant, austenitic weld deposit with high elongation and toughness which can be further enhanced through work hardening.

Typical Applications

These electrodes are ideally suited for joining austenitic manganese steels to mild steels and high alloy steels, repairing cracks in austenitic manganese steel castings and joining components exposed to thermal stress. Also used as a buffer layer prior to hard surfacing and for surfacing manganese steel components such as bucket cracks in earth-moving equipment used in the mining industry.

Mechanical Properties

Tensile Strength: 55 - 65 kgf/mm2
Elongation: 30 - 40%

Welding Current : AC/DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 80	80 - 110	110 - 140	150 - 190

Availability:

Standard Size: 5.0, 4.0, 3.15,2.50 in 350 mm length
Packing: 2 Kg

Procedure

Clean the area to be welded thoroughly. Use a short arc with low amperage especially for high manganese steel. Peen and de-slag after each pass and use a water bath to control heat buildup.