

SME A15M

HIGH NICKEL ELECTRODE FOR REPAIRING AND JOINING ALL GRADES OF CAST IRON

Alloy Basis

Ni

Characteristics :

SME A15M is a versatile nickel-based electrode designed for cold welding various grades of cast iron, offering very soft fusion and high conductivity. Its high nickel content ensures a soft machinable weld with minimal heat input reducing the risk of cracking. The electrode is suitable for in-situ maintenance work ensuring high-quality welds with minimal distortion.



Typical Application

Typical applications include the repair of cast iron components such as cracks in engine blocks, pump housings, gearboxes, and frames, as well as the correction of foundry defects. It is also suitable for welding cylinder heads, blocks, pump castings, compressors, and valves.

Technical Data:

Tensile strength : 42 - 50 kgf/mm²

Elongation : 5 - 10 %

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 75	70 - 90	100 - 140	150 - 190

Availability:

Standard Size : 5.0,4.0,3.15 & 2.50 in 350 mm length

Packing : 2 Kg

Procedure

Clean the surface to remove rust, oil, dirt, grease, and any other contaminants. Use a short arc with low current to deposit a stringer bead not exceeding 50 mm. Peen the deposit to reduce residual stress.