

NON-MACHINABLE ELECTRODE FOR CAST IRON WELDING

Alloy Basis

Fe, C, Si

Characteristics :

SME A17 is a specially designed electrode with strong arc force and excellent cleaning action for welding contaminated cast irons. It offers strong bonding on hard-to-weld cast iron and produces deposits with a close color match to the base metal.



Typical Applications

This electrode is suitable for welding and surfacing cast iron, joining cast iron to steel and serves effectively as a single-layer buttering electrode on all types of cast iron. It is ideal for repairing massive parts and large castings, including foundry defects and cracks and performs reliably on rusty, corroded, or oil-soaked surfaces.

Mechanical Properties

Tensile Strength : Upto 45 kgf/mm²

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 80	90 - 120	100 - 150	160 - 190

Availability:

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

Packing: 2 kg

Procedure

Clean the joint area thoroughly. Use a short arc not exceeding 30 mm, and guide the electrode with a slight tilt in the direction of travel. Remove slag by chipping and brushing. For improved machinability, deposit the final pass using SME A15 or SME A19.