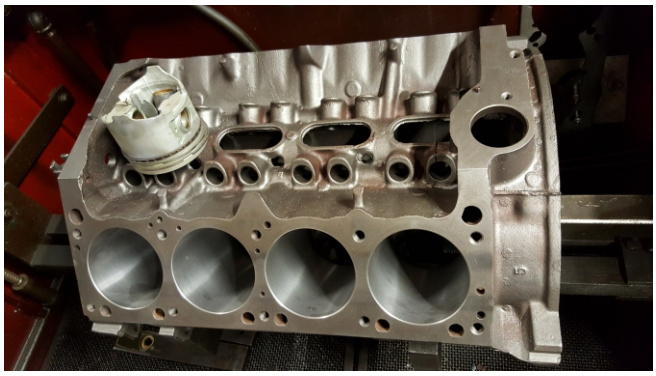
SME A19M

PREMIUM NICKEL-IRON ELECTRODE FOR SUPERIOR CAST IRON WELDING DESIGNED WITH INNOVATIVE INPUT MATERIAL



Alloy Basis

Ni, C, Fe

Characteristics :

SME A19M electrode is designed for welding a wide range of cast irons as well as for welding cast iron to steel. The advanced core wire prevents overheating at rated amperage, reducing stub loss while maintaining weld ability. The deposits are highly crack-resistant with superior machinability. The smooth stable arc offers excellent strike and re-strike characteristics with minimal spatter and fuming.

Typical Applications

These electrodes are used for repair welding of high-strength, heavy-duty ductile irons involving massive sections and joints under restraints. Applications include machine tool bases, valve bodies, pumps, gearboxes, gear teeth, couplings, piping, transmission housings, joining cast iron and cast iron to steel of similar or dissimilar thicknesses and more.

Mechanical Properties

Tensile Strength : 50 Kgf/ mm^2
Elongation : 10 - 15 %

Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 80	70 - 100	100 - 130	140 - 180

Availability:

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

Procedure

Clean the welding surface for cracks and defects. Use a short arc with low current to deposit stringer beads not exceeding 25 mm long at a time. Hot Peen the deposit to reduce residual stresses. Use skip welding technique. Cool slowly.