

# SME A24

## LOW CARBON STAINLESS STEEL ELECTRODE WITH EXCELLENT HEAT AND CORROSION RESISTANCE FOR JOINING AND OVERLAYING APPLICATIONS

### Alloy Basis

Cr, Ni, Fe



### Characteristics :

SME A24 is an austenitic stainless steel electrode for welding AISI 304, 304L and similar grades. It provides low-carbon, corrosion & scale-resistant deposits with excellent intergranular corrosion resistance with easy arc striking, low heat input and smooth, shiny beads. Suitable for all positions with excellent color match.

### Typical Applications

Ideal for welding components used in containers, mixers, chemical plant equipment, food processing equipment and distillery machinery. It is particularly suitable for use as a protective overlay on carbon steel and for joining extra-low carbon stainless grades.

### Mechanical Properties

Tensile Strength: 55 - 65 kgf/mm<sup>2</sup>

Elongation : 35 – 40 %

### Welding Current : AC, DCEP

Size (Ø mm)	2.50	3.15	4.00	5.00
Current (amps)	50 - 80	90 - 110	120 - 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. Prepare the edges for heavy sections. Preheating requirements depend on the composition of the base metal. Use a stringer bead technique with a short arc and also remove slag after each pass. Dry the electrode at 350°C for 60 minutes before use.