

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/mm²

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.