

Alloy Basis

Cr, Ni, Mo, Fe

Characteristics :

SME A25 is a molybdenum-bearing extra-low carbon stainless steel electrode for superior corrosion resistance including protection against acid pitting and grain disintegration up to 300°C. It ensures excellent slag control in tight fit-ups and provides a durable protective overlay for enhanced chemical and frictional resistance.

Typical Applications

Applications include chemical tanks and vessels, dyeing and dairy equipment, brewery and food processing equipment, pumps, mixers, hydraulic and steam turbine blades and plating tanks. It is ideal for welding crack-sensitive alloys, highly restrained joints, austenitic stainless steels, Cr-Ni-Mo steels and similar grades.

Mechanical Properties

Tensile Strength: 54 - 64 kgf/mm²

Elongation : 30 – 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.

