

SME A26

**FOR JOINING WIDE RANGE OF SS AND MS BASE METAL
SPECIALLY FOR OXIDATION AND HEAT RESISTANCE APPLICATIONS**



Alloy Basis

Fe, Ni, Cr

Characteristics :

Fully Austenitic weld deposit, heat resistant upto 1200°C in oxidizing and sulphur free atmosphere. smooth rapid spatter free deposition. Ideal for joining SS of unknown composition.

Typical Applications

Welding of austenitic stainless steel, heat resistance steel, of the type 25 Cr/20Ni. application in to welding of tanks, heat exchangers, heat treating boxes and baskets .

Mechanical Properties

Tensile Strength : 540 – 640 MPa

Elongation : 30 – 35 %

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, 2.5 in 350 mm length

Packing: 2 kg.

Procedure

Clean the area to be welded. For heavy thickness prepare a 60 included angle V. Fit up should be accurate for long joints. Weld at regular intervals and use jigs & fixtures to avoid distortion. Use DCRP (DC+) on DC Power Source for good ripple & finish. Stringer bead technique with shortest possible arc length is recommended .