

# 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 .