# SME A26HC

## SPECIAL ELECTRODE FOR WELDING HK30, HK40 AND SIMILAR HEAT RESISTING ALLOYS

**Alloy Basis**

Cr, Ni, Fe, C

**Characteristics :**

SME A26HC is a stainless steel electrode designed for high-temperature applications where creep resistance is essential. Its weld deposit is capable of withstanding continuous service temperatures up to 1200ºC offering superior creep rupture strength at elevated operating temperatures. The electrode features easy arc-striking, excellent slag removal and produces a smooth, evenly rippled and glossy weld bead.

**Typical Applications**

Applications include welding of reformer or furnace tubes made of HK 30 and HK 40 alloys which are commonly used in the fertilizer industry, oil refineries, petrochemical plants, cement plants and the steel industry.

**Mechanical Properties**

Tensile Strength: 60 - 70 kgf/mm2
Elongation min : 10 %

**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..