

SME A28

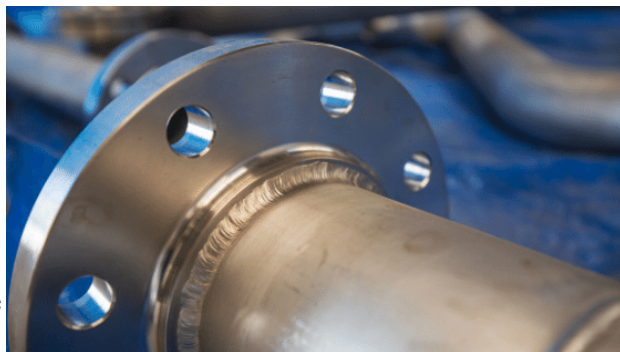
ELECTRODE FOR HIGH STRENGTH JOINING OF LOW AND MEDIUM CARBON AND LOW ALLOY STEELS.

Alloy Basis

Fe, Ni, Cr

Characteristics :

SME A28 is an austenitic electrode suitable for welding both high-alloy and unalloyed steels. It is an all-position electrode that provides weld metal with high tensile strength and excellent resistance to chemical corrosion. The electrode offers good slag detachability, a smooth and stable arc, low spatter and produces a clean weld bead of radiographic quality.



Typical Applications

These electrodes are commonly used for surfacing on mild steel (MS) to improve wear resistance and are suitable for welding dissimilar steels, including the joining of stainless steel to low alloy or carbon steel. Additionally, these can be used for cladding applications on carbon steel.

Mechanical Properties

Tensile Strength Min – 520 Mpa

Elongation Min – 30 %

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

Remove any dirt such as oil and dust from the surface before welding. It is most effective to proceed with welding by keeping the arc as short as possible in the flat position. Dry the electrode at 350°C for 60 minutes before use.