

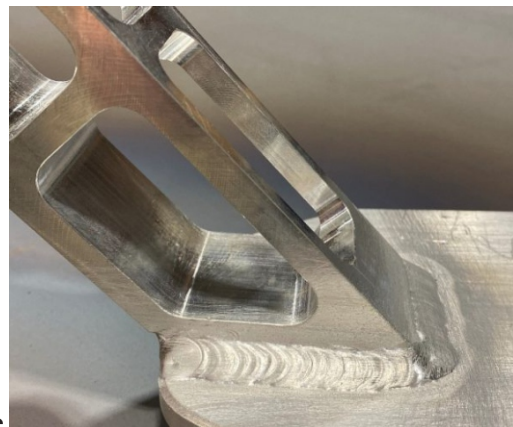
SPECIAL ALUMINIUM ELECTRODE FOR WELDING APPLICATIONS

Alloy Basis

Al, Si

Characteristics :

SME D09 electrode with excellent strength is specially designed for welding heavy aluminum castings, long joints, defect filling and rebuilding missing sections. Weld deposits are dense and porosity-free offering outstanding arc stability. The rapid solidification of the weld metal aids in assembly alignment and enables positional welding.



Typical Applications

These electrodes are used in aluminum foundries, automobile workshops and repair shops. Typical applications include engine blocks, heavy gauge aluminum bodies, cast differential housings, various aluminum pump casings, foundry patterns, aluminum rail and more.

Mechanical Properties

Tensile Strength - 20-25 Kgf/mm²

Elongation - 8-12%

Welding Current: DCEP

Size (Ø mm)	2.50	3.15	4.00
Current (amps)	50 - 80	80 - 110	120 - 140

Availability:

Standard Size: 4.0, 3.15, 2.5 in 350 mm length

Packing: 1 kg (Vacuum packed)

Note to Usage

Clean the area to be welded to remove contaminants and surface oxides. The electrodes should mainly be used for welding in down-hand position with shortest possible arc. To obtain maximum bonding and to avoid porosity in the deposits, the work piece should be preheated at 200°C.