

## SPECIAL ELECTRODE FOR WELDING PURE NICKEL

### Alloy Basis

Ni, Ti, Al, Fe

### Characteristics :

SME E01 electrode delivers a porosity- and crack-free weld deposit with outstanding resistance to corrosion and oxidation. It ensures smooth operation with minimal spatter, self-releasing slag and produces a uniformly rippled, bright weld bead of radiographic quality.



### Typical Applications

This electrode is used for welding pure nickel and nickel-plated steels as well as for nickel overlay on steel. It is also suitable for joining copper and copper alloys to steel. Typical applications include apparatus construction, components in the chemical industry, valves and pipelines.

### Mechanical Properties

Tensile Strength: 40 – 45 kgf/mm<sup>2</sup>

Elongation: 20-25%

### Welding Current : DCEP

Size (Ø mm)	2.50	3.15	4.00
Current (amps)	60 - 80	90 - 110	120 - 140

### Availability:

Standard Size: 4.0, 3.15, 2.50 in 350 mm length

Packing: 2.0 KG

### Procedure

Clean the area to be welded. Use a short arc and stringer bead technique ensuring complete slag removal between passes. Allow the weldment to cool slowly to room temperature.