

## SPECIAL ELECTRODE FOR WELDING MONEL ALLOYS

### Alloy Basis

Ni, Cu, Mn, Ti, Fe

### Characteristics :

SME E11 is a monel electrode with low iron content in the weld deposit providing excellent corrosion resistance especially in aggressive environments. The weld deposit is easily machinable in both as-welded and stress-relieved conditions and it offers strong resistance to a wide range of chemicals.

### Typical Applications

This electrode is suitable for joining monel alloys and dissimilar metals as well as for overlaying applications to achieve corrosion resistance. Ideally used in applications such as refineries, offshore installations, foundries, chemical and fertilizer plants, heat exchangers, pressure vessels, column manufacturing units, food processing equipment, pump and valve manufacturing etc.

### Mechanical Properties

Tensile Strength: 440 - 540 Mpa

Elongation: 30-35%

### 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 Kg

### Procedure

Clean the area to be welded. Preheat sections thicker than 25 mm to 100 °C. Use a short arc and stringer bead technique ensuring complete slag removal between passes. Allow the weldment to cool slowly to room temperature.

