

## SPECIAL NICKEL BASED MOLYBDENUM BEARING ELECTRODE FOR TOUGH, HEAT AND CORROSION RESISTANCE JOINTS

### Alloy Basis

Ni, Cr, Mn, Fe, Cb, Mo

### Characteristics :

SME E21A is a non-synthetic electrode that deposits a homogeneous Ni-Cr-Fe alloy composition. It provides a stable arc with superior performance ensuring excellent resistance to scaling at elevated temperatures. The deposits exhibit exceptional durability against abrasion, oxidation and corrosion making it ideal for demanding applications.



### Typical Applications

This electrode is suitable for welding Ni-Cr-Fe alloys to themselves as well as for welding nickel, Inconel, Monel, nickel-iron-chromium alloys, HK alloys, stainless steels and heat-resistant steels. It is ideal for use on equipment and components made of pure nickel and is also well-suited for the fabrication of corrosion-resistant tanks, containers, heat exchangers, furnace components and more.

### Mechanical Properties

Tensile Strength: 55 – 60 kgf/mm<sup>2</sup>

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 and bevel out 90° U with SME I00. Preheat sections more 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.