

## SME A119

## Electrodes for MMAW Process

## Cast Iron

### Low-Heat Input Welding Alloys

#### Alloy Basis :

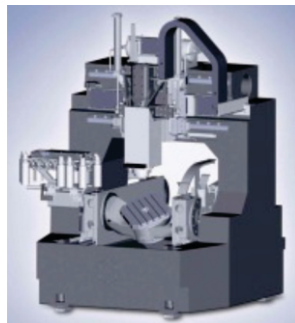
Fe, Ni

#### Characteristics :

1. SME A119 is a crack resistant Nickel Iron electrode suitable for welding different grades of Cast Iron and gives stable and soft arc, regular flow.
2. It requires Minimum penetration and hence very less dilution.
3. Nodular deposit which provides crack-resistivity specially in joining of cast irons to carbon steel.
4. All position weldability.
5. No undercuts and fine weld ripples

#### Technical Data :

UTS : 36-49 kgf/mm<sup>2</sup>



#### Applications :

1. Suitable for welding different grades of Cast Iron.
2. For joining of machinable cast irons to carbon steels.
3. For overlaying, building up, and filling porosity.
4. Suitable for heavy and thin sections of cast irons.

#### Welding Current : AC / DC (-)

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	50 - 70	80 - 110	90 - 120

#### Availability:

Standard Size: 5.0, 4.0, 3.2 and 2.5 in 350 mm length

Packing: 2 , 5 Kg.