

**SME A15****Electrodes for MMAW Process****Cast Iron****Low-Heat Input Welding Alloys****Alloy Basis :**

Ni,

**Characteristics :**

SME A15 is an electrodes for cold welding of cast iron and has smooth stable arc and is good for positional welding. The heat affected zone is machinable since there is little mixing up with base material.

**Technical Data :**

UTS : 30-35 kgf/mm<sup>2</sup>

**Applications :**

1. Surfacing cast iron parts subject to erosion, corrosion and high temperatures.
2. Cold welding of cast iron without preheat and for joining cast iron to mild steel.
3. repairing intricate cast iron parts electric motor bodies and covers, machine frames, water pump housing, gears.
4. salvaging foundry castings, gear box and differential housing sugar mill rollers, glass moulds and cast iron dies.

**Welding Current : AC 70 OCV DC -**

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

**Availability:**

Standard Size: 5.0, 4.0, 3.2 and 2.5 in 350 mm length  
Packing: 2 , 5 Kg.