

SME A18

Electrodes for MMAW Process

Cast Iron

Low-Heat Input Welding Alloys

Alloy Basis :

C, Fe, Ni

Characteristics :

1. SME A 18 is a crack resistance electrode for welding Cast Iron
2. Deposit is machinable and crack-resistant.
3. This has good weldability, can be used in multi position.



Technical Data :

UTS : 36-49 kgf/mm²

Applications :

1. For overlays on the machinable cast irons.
2. For repair welding and joining of nodular cast iron and grey cast iron or cast iron to carbon steel.
3. For filling up defects and porosity.
4. Best suited for heavy sections, cast iron pumps, housings and dies.

Welding Current : AC / DC (-)

| | | | |
|----------------------|-----------|-----------|-----------|
| Size (Ø / Length) mm | 2.5 x 350 | 3.2 x 350 | 4.0 x 350 |
| Current (amps) | 50 - 70 | 70 - 100 | 90 - 120 |

Availability:

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