

Repair & Maintenance Products

SME G11



 **SENOR[®]**

One Stop Solution for Welding & Brazing Consumables

SME G11

Electrodes for MMAW Process

Hard Facing

Alloy:

Cr, Mo, Mn

Characteristics :

Senor SME G11 is economical electrode for making overlays in all positions. This resists high abrasion and gives spatter free deposit. The deposit is porosity free permits heavy build-up without cracking.



Technical Data :

Hardness (as deposited): 55-59 RC

Applications :

1. To hardface parts subject to heavy abrasive wear and impact.
2. Surfacing of chipper knives, digger teeth, drills, Buckets, shovels and excavating equipment
3. For use on steel, malleable iron.
4. Suitable for both new or worn parts, especially for multi-pass build-ups
5. In crushing applications as final layer on manganese weld deposit to reduce initial wear.
6. Cultivators, pulverisers

Welding Current: AC / DC(+)

Size (Ø mm)/Length	:	3.2 x 350	4.0 x 350	5.0 x 350
Current (amps)	:	95 – 130	105 – 180	160 – 210

Availability:

Standard Size: 5.0, 4.0, 3.2 and 2.5 in 350 / 450 mm length

Packing: 5 kg.

Note on Usage:

1. Clean the surface properly
2. Remove cracked and spalled material
3. Preheat heavy sections to about 200°C - 250°C
4. Apply buffer layer with SME A08 for multi-pass hardfacing
5. Use stringer or weaving technique holding a short to medium arc
6. Do not allow excessive heat build-up
7. Remove slag between passes and allow to cool.
8. Deposit 3 layers to attain recommended hardness.

Above are basic guidelines and will vary depending on joint design, number of passes and other factors.

⚠WARNING Ⓢ

Protect yourself and others. Read and understand this warning. Do not remove this warning.

Fumes and Gases can be hazardous to your health

- Before use, read and understand the Material Safety Data Sheet (MSDS), the manufacturer's instructions, and your employer's safety practices.
- If MSDS is not enclosed. Obtain from your employer.
- Keep your head out of the fumes. See Section 5 of the MSDS for specific fume concentration limits.
- Use enough Ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding.

Electric Shock can kill

- Always wear dry insulating gloves
- Insulate yourself from work and ground.
- Do not touch live electrical parts.

ARC Rays can injure eyes and burn skin

- Wear welding helmet with correct filter.
- Wear correct eye, ear, and body protection.

Welding can cause fire or explosion

- Do not weld near flammable material.
- Watch for fire, keep, extinguisher nearby.

Read American National Standards Z49.1, "Safety In Welding, Cutting and Allied Process." from American Welding Society.