# SENOR

Ni & Ni Alloys

### SME E21

## Electrodes for MMAW Process

# Low-Heat Input Welding Alloys

#### Alloy Basis :

Ni, Cr, Mn, Nb, Fe

#### **Characteristics**:

SME E21is a Ni-Cr-Fe basic coated stick electrode and it gives soft stable arc on low currents. Deposits are smooth, tough and has excellent resistance to scaling, corrosion resistance at normal as well as elevated temperatures. This has good thermal cycles and shock resistance. Weld deposits are similar to ENiCrFe3. HK alloys, steel, stainless steel and heat resisting steels



#### **Technical Data :**

UTS : 55-62 kgf/mm<sup>2</sup> Elongation (L=5d) : 30-35%

#### **Applications :**

- 1. Welding of nickel, monel ,Inconel.
- 2. Welding of nickel-chromium-iron alloys.
- 3. For use on equipment and components made of pure nickel, for fabrication of corrosion resistant tanks and containers, heat exchangers, furnace components, boilers, fittings, anchors, mill trunnions, symmetry gears.
- 4. Welding dissimilar metals such as carbon steels, stainless steels, nickel, nickel alloys to each other.

#### Welding Current : DC (+)

Size (Ø/Length) mm	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 350
Current (amps)	50 - 70	80 - 110	100 - 140	140 - 160

#### Availability:

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

## **Options Available : SME E21 A**

www.senormetals.in