

SME E24

Electrodes for MMAW Process

Ni & Ni Alloys

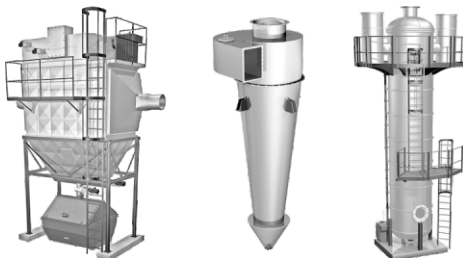
Low-Heat Input Welding Alloys

Alloys:

Cr, Ni, Mo, Nb, Mn, Fe

Characteristics :

SME E 24 weld deposit is resistant to seawater corrosion, wide variety of acids and alkalis. It has High temperature strength and oxidation stability and High resistance to pitting, crevice, inter-crystalline and stress corrosion cracking.



Technical Data :

UTS	: 76-86 kgf/mm ²
YS	: 42-52 kgf/mm ²
Elongation (L = 4d)	: 30-35%
Impact energy (CVN at 20°C)	: 55-80 J
At 196°C)	: 50-60 J

Applications :

1. Deposits are similar to ENiCrMo-3.
2. To join and hard-surfacing of identical or similar grades of heat-resisting steels and alloys.
3. Welding alloy steels like H 11, H 13, 17 Mn 4, St E 355, 15 Mo 3.
4. Suitable in sea water and offshore plants, chemical-engineering (nitric, hydrochloric, sulphuric, phosphorous acid as well as alkalis), flue gas dust collectors.

Welding Current : DC (+)

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	45 - 70	70 - 110	100 - 140

Availability:

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