

## SME A04

## Electrodes for MMAW Process

## Steels

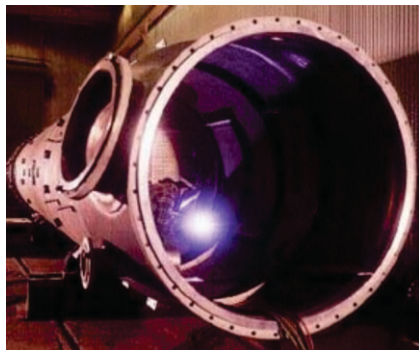
### Low-Heat Input Welding Alloys

#### Alloy Basis :

C, Mn, Si

#### Characteristics :

SME A04 gives good weld appearance and slag peels off easily. This is a Low-hydrogen structural welding electrode for highly-stressed joints. The weld metal is ductile, tough, and resistant to cracking, resists ageing and of radiographic quality.



#### Technical Data :

UTS : 55-69 kgf/mm<sup>2</sup>

Elongation : 22-30%

#### Applications :

1. Suitable for joining and building of low and medium carbon steels.
2. Suited for welding operations on structural, boiler, pressure vessels, pipes, flanges, heavy machinery parts, steel castings.
3. It is used for depositing.
4. Buffer layer before hardfacing.
5. Joining restrained joints and oil soaked parts.

#### Welding Current : AC / DC (+)

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 350
Current (amps)	60 - 80	100 - 140	140 - 180	170 - 230

#### Availability:

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

Packing: 2 , 5 Kg.