

SME A106

Electrodes for MMAW Process

Steels

Low-Heat Input Welding Alloys

Alloy Basis :

Fe, Cr, Ni

Characteristics :

SME A106 is a rutile coated electrode depositing austeno-Ferritic crack-resistant weld metal with approx. 25-27% ferrite. Smooth weld bead with clean edge. Excellent slag removal (self peeling characteristic). It gives almost no spatter loss and under cuts.



Technical Data :

UTS : 70-85 kgf/mm²
Elongation : 20-25%

Applications :

1. Suitable for joining armour steel, Aust. Manganese steel, cast steel, forged steel and stainless steel to carbon steel or unknown composition.
2. Surfacing of grooved rolls and repair of drop forged dies. As a cushioning layer before hardfacing.

Welding Current : AC / DC (+)

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	50 - 80	85 - 110	90 - 140

Availability:

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