

## SME A124

## Electrodes for MMAW Process

## Stainless Steels

### Low-Heat Input Welding Alloys

#### Alloy Basis :

Fe, Cr, Ni

#### Characteristics :

SME A124 is an Austenitic Stainless Steel electrode with Special features. This gives weld deposit which is Austenitic with controlled ferrite content 3 to 7%. Inter granular corrosion resistibility is much superior due to extremely low carbon content in weld metal. The weld metal has excellent corrosion resistance with superior mechanical properties. Exceptional weld bead appearance. Self-releasing slag with little or negligible spatter.

This gives high quality weld deposit with defect free radiographic performance in multipass welds. Smooth spray metal transfer with AC or DC (+) operation. Weld deposit is flat / concave with consistent ripples and free from porosity.



#### Technical Data :

UTS : 55-67 kgf/mm<sup>2</sup>

Elongation : 35-45%

#### Applications :

1. For Joining Stainless Steels such as 18/8 stainless steels. (e.g. AISI 302, 304, 304 L or equivalent stainless steel).
2. Making joints in ferritic chromium steels (upto max. 18% Cr.).
3. For Surfacing on steels in chemical and fertilizer Plants.
4. Excellent alloy for surfacing on stabilized, corrosion resistant, cold tough Cr-Ni steels in Nuclear plants, breweries, food industries.

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

Size (Ø / Length) mm	2.5 x 350	3.2 x 350	4.0 x 350
Current (amps)	60 - 80	90 - 110	120 - 140

#### Availability:

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

Packing: 2 , 5 Kg.