

Low-Heat Input Welding Alloys

Alloy Basis :

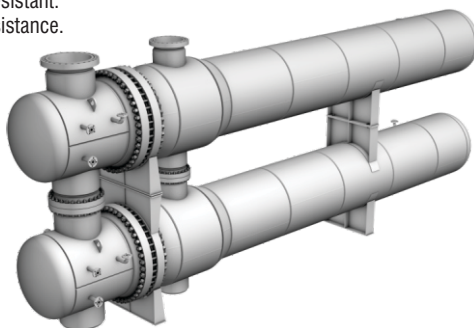
Fe, Cr, Mo, Ni

Characteristics :

1. SME A 128 is an Austenitic stainless Steel electrode for welding dissimilar Steels
2. All-position electrode deposit which is highly crack-resistant.
3. Medium-high tensile strength with good corrosion resistance.
4. Soft arc, easily de-slagging.
5. Weld ripples are uniform with no undercuts.

Technical Data :

UTS : 60-74 kgf/mm²
Elongation : 30-40%



Applications :

1. For joining mild steels to various grades of austenitic stainless steels.
2. Suitable for joining one grade of stainless-steel to other grades of stainless-steels such as, AISI 304 to 316 or 316 to 317.
3. For building up carbon steels to improve their crack resistance.

Welding Current : AC / DC (+)

| Size (Ø / Length) mm | 2.5 x 350 | 3.2 x 350 | 4.0 x 350 |
|----------------------|-----------|-----------|-----------|
| Current (amps) | 60 - 75 | 90 - 110 | 110 - 140 |

Availability:

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