



## SIA

**CODIFICATION :**                      AWS    :    SFA 5.4 E307-15 (Nearest)  
    IS     :    5206 E18.8 MnB20

### CHARACTERISTICS AND APPLICATIONS :

SIA is a basic coated multipurpose stainless steel electrode producing a weld metal of 18Cr - 9Ni - 5Mn. The weld metal has excellent crack resistance and has good scaling resistance up to 850°C. Ideal for joining ferritic to austenitic steels, armour plates, austenitic manganese steels, heat resistant steels, dissimilar materials, for buffer layers etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	: C	Mn	Si	S	P	Cr	Ni
Percent	: 0.09	5.50	0.60	0.015	0.025	19.5	9.2

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L = 4d)%
644	38.0

### CURRENT AND PACKING DATA : DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range	: 170-200	130-170	90-130	60-90
(Amps)				
Weight/Cartron	: 2.5	2.5	2.5	2.5
(kgs)				

### PRECAUTIONS :

1. Re-dry the electrodes at 250-300°C for one hour for best results.
2. Use low current, short arc and stringer beads.