

SMA

CHARACTERISTICS AND APPLICATIONS :

SMA is a basic coated electrode operating on AC/DC(+) producing a tough austenitic manganese steel weld metal. The deposit work hardens in service and has excellent resistance to wear by impact. Typical applications include surfacing of parts subjected to abrasion and heavy impact as in the case of crusher jaws, bucket teeth and lips, rail crossing, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr
Percent	:	0.85	14.5	0.55	3.0

WELD METAL HARDNESS : As welded: 200-250 BHN

Work hardens (under impact) to 500 BHN

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	:	6.3x450	5x450	4X450	3.15x350
Dia x Length					
Current Range	:	200-270	160-200	130-160	90-120
(Amps)					
Qty.(Pcs./Carton)	:	20	35	55	75

PRECAUTIONS:

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. While welding of austenitic manganese steel, restrict the heat input by:
 - a) Short arc;
 - b) Stringer bead;
 - c) Deposit in short length;
 - d) Intermittent welding;
 - e) Keeping the base material partly immersed in water.