

# Repair & Maintenance Products

# SME G13



 **SENOR**<sup>®</sup>

One Stop Solution for Welding & Brazing Consumables

**SME G13**

**Electrodes for MMAW Process**

**Hard Facing**

## Alloy:

Mn, Ni, Cr

## Characteristics :

SME G13 enhances parts life against impact and abrasion. Deposits are work hardened and resistance to cracking and deformation.

## Technical Data :

Hardness as welded : 17-18 RC  
Work hardened : 40-45RC



## Applications :

1. It is suitable for joining austenitic manganese steels and hardfacing of parts subject to impact and abrasion.
2. Crushing equipment parts like jaws, crushing mantles hammers & excavator teeth.
3. Rail road trucks and parts subject to heavy impact and stresses

## Welding Current: AC / DC(+)

Size (Ø mm)/Length	:	2.5 x 350	3.2 x 350	4.0 x 350	5.0 x 350
Current (amps)	:	35 – 70	95 – 130	120 – 170	160 – 210

## Availability:

Standard Size: 5.0, 4.0, 3.2 and 2.5 in 350 / 450 mm length

Packing: 5 kg.

## Note on Usage:

1. Clean the affected area properly.
2. Use the damaged material by gouging with SME I00
3. Do not preheat manganese steel.
4. Maintain a short to medium arc length.
5. Interpass temperature should be kept below 150°C using staggered or skip welding techniques
6. Peening while hot helps shape the deposit and reduces stresses.
7. Cool slowly

**Above are basic guidelines and will vary depending on joint design, number of passes and other factors.**

## **⚠** **WARNING** **Ⓢ**

**Protect yourself and others. Read and understand this warning. Do not remove this warning.**

## Fumes and Gases can be hazardous to your health

- Before use, read and understand the Material Safety Data Sheet (MSDS), the manufacturer's instructions, and your employer's safety practices.
- If MSDS is not enclosed. Obtain from your employer.
- Keep your head out of the fumes. See Section 5 of the MSDS for specific fume concentration limits.
- Use enough Ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. If needed, use a proper respirator.
- No hazards exist before this product is used in arc welding.

## Electric Shock can kill

- Always wear dry insulating gloves
- Insulate yourself from work and ground.
- Do not touch live electrical parts.

## ARC Rays can injure eyes and burn skin

- Wear welding helmet with correct filter.
- Wear correct eye, ear, and body protection.

## Welding can cause fire or explosion

- Do not weld near flammable material.
- Watch for fire, keep, extinguisher nearby.

Read American National Standards Z49.1, "Safety In Welding, Cutting and Allied Process." from American Welding Society.