Inweld SA 1 Blue

Ultra Strength High Alloy Electrode for all steels, AC or DC reverse polarity

Chemical Composition of Inweld SA 1 Blue

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	N	Cu
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Chemical composition not available.

Description and Applications

An ultra-high strength electrode with high corrosion, crack, and heat resistance. It can be easily welded in all positions. High strength welds are achieved while maintaining ductility. The fully machine-able deposits have no hard spots. Inweld SA 1 Blue is for the maintenance welder who does not know the type of steel he is welding, or must weld dissimilar steels. Commonly used for repairing tools, dyes, carbon steels, spring steels, and stainless steels. Ideal for removing broken studs, or welding low, medium, and high alloy steels where high strength is essential. Ideal overlay cushion prior to hard facing. To use, prepare joining area by removing foreign material. Use Inweld Chamfer Rod to bevel heavy sections. Hold a short arc, or use drag technique, use stringer beads. For high alloys and heavy sections, preheat to 400F (204C), skip weld and peen lightly to avoid internal stress.

Typical Weld Metal Properties

	AWS Spec
Average As-Welded Hardness:	230 BH
Tensile Strength:	124,000 psi
Yield Strength:	90,000 psi
Elongation:	35%
Current:	AC or DC Reverse Polarity

Recommended Parameters

SMAW

Wire Diameter	Voltage	Amperage	Wire Feed IPM
5/64”		40-70	
3/32”		60-90	
1/8”		75-125	
5/32”		95-125	
3/16”		150-240	

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