

GEMET 102

ELECTRODE FOR WELDING MILD STEEL STRUCTURES

IDENTIFICATION

Gemet 102

DESCRIPTION

Easy-to-use electrode with fine droplet transfer. Fine ripple pattern of weld bead. Easy striking and re-striking. Very good slag removal.

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=5D)	CVN Impact Value	
			Temp	Joules
480 - 600	400 - 490	24 - 30	20°C	60 - 90

TYPICAL APPLICATIONS

Welded joints on steel constructions, in boiler fabrication, car body works, fitting shops, construction steels, etc.

WELDING INSTRUCTIONS

- Keep short to medium arc with slight weaving.
- The electrode should be held at a slight angle to the parent metal.

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (-) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	70 - 100	2	2 x 5 = 10
3.15 / 3.20	350	100 - 140	2	2 x 5 = 10
4	350	140 - 190	2	2 x 5 = 10