

# GEMET 103 (Spl)

## IDENTIFICATION

Gemet 103 (Spl)

## DESCRIPTION

- Special low hydrogen electrode for high-stressed welds. The weld metal has good ductility and has creep resistance properties at elevated temperature.

**ALLOY BASIS :** Mn, Mo

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)	CVN Impact Value	
		Temp	Joules
520 - 620	26 - 32	0°C	150 - 200

## TYPICAL APPLICATIONS

- As a buffer layer on difficult to weld steel or prior to depositing hard facing layer.
- For welding steel of unknown composition.
- For welding highly restrained joints.
- For welding difficult to weld steel.
- For welding heavy and thick sections of the steel.

## WELDING INSTRUCTIONS

- Dry electrodes at 250°C / 2 hrs.
- Keep short arc.
- If parent metal has carbon content more than 0.60% then preheat to about 200°C

**WELDING CURRENT :** AC 70 OCV / DC (+)

## PACKING PARAMETERS

Size (mm)	Length (mm)	CURRENT CONDITION AMPS AC (70 OCV) / DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	60 - 90	2	2 x 5 = 10
3.15 / 3.20	350	90 - 140	2	2 x 5 = 10
4	350	130 - 180	2	2 x 5 = 10
5	350	150 - 200	2	2 x 5 = 10