

GEMET 103

MAINTENANCE ELECTRODE - CARBON STEEL.

IDENTIFICATION

Gemet 103

DESCRIPTION

- Low heat input all position electrode for medium tensile steel, Ductile steel weld.
- Finely rippled bead.
- Easily detachable slag.
- Weld metal is ductile; resistance to cracking
- Radiographic quality

ALLOY BASIS : Fe, C, Mn, Si

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	UTS (kgf/mm)	EL (%) (L=4D)
540 - 680	55 - 68	24 - 30

TYPICAL APPLICATIONS

- Pressure Vessels
- Section
- Heavy Machine
- Steel
- Oil
- Chain
- Gun plates

APPLICATION TECHNIQUE

- Clean the joint area.
- Use DC reverses polarity with short arc.
- Redry electrodes at 300°C for one hour to obtain better results.
- Slight weaving is recommended.

WELDING CURRENT : AC / DC (+)

PACKING PARAMETERS

Size (mm)	Length	Current Condition Amps AC / DC (+)	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	90 - 140	2	2 x 5 = 10
4	350	120 - 180	2	2 x 5 = 10
5	350	150 - 240	2	2 x 5 = 10