

# GEMET 104

## MAINTENANCE ELECTRODE

### IDENTIFICATION

Gemet 104

### DESCRIPTION

- Low heat input electrode for medium tensile steels.
- Very smooth, uniform bead of radiographic quality with high metal recovery.
- Excellent impact resistance at sub-zero temperature.
- Deposited welds are of radiographic quality.
- Diffusible Hydrogen in the weld metal is very low; hence it has crack resistance properties.

**ALLOY BASIS** : C, Mn, Si

### MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
500 - 610	22 - 30

### TYPICAL APPLICATIONS

- Highly stressed crack sensitive joints
- Ship building
- Heavy boilers
- Pressure vessels
- High pressure piping
- Gun plates
- Heavy equipment maintenance

### PACKING PARAMETERS

Size (mm)	Length (mm)	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 - 220	2	2 x 5 = 10