

GEMET 105

MAINTENANCE ELECTRODE-CARBON STEEL

IDENTIFICATION

Gemet 105

DESCRIPTION

- Low hydrogen electrode with good ductility & creep resistance.
- Low heat in-put, All position, Basic coated electrode with high metal recovery.
- Easy weldability and high mechanical properties.
- Deposited weld metal is of radiographic quality.
- Weld metal is tough and resistant to ageing; high triaxil stresses and withstand heavy shocks.
- Non-hygroscopic flux coating, strong & stable arc, self releasing slag, no temper embrittlement of weld deposit.

ALLOY BASIS : C, Mn, Si, Mo

MECHANICAL PROPERTIES (RANGE)

TS (MPa)
660 min

TYPICAL APPLICATIONS

- Hammer bases, columns, rams, sow blocks, keyways, and kiln shell.
- Joining, build-up and repair of new, worn-out or cracked steel structures.
- Machinery components and other heavy duty equipment.
- Welding cast steels, fabrication of micro-alloyed and H.S.L.A steels including automotive applications.
- Especially suited for repair of forging equipment like columns, sow blocks etc.

WELDING PROCESS

Shielded Metal Arc Welding (SMAW)

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 - 220	2	2 x 5 = 10