

GEMET 201

EXTRA LOW CARBON ELECTRODE FOR CrNi STEELS

IDENTIFICATION

Gemet 201

DESCRIPTION

The rutile coated electrode with a low carbon content, is used for joining and building up of identical low carbon, austenitic CrNi cast steels. Due to the low C content the deposit is highly resistant against intercrystalline corrosion and can be used for working temperatures up to + 350°C .

MECHANICAL PROPERTIES (RANGE)

YS (N/mm ²)	UTS (N/mm ²)	EL (%) (L=4D)
360 - 460	520 - 620	35 - 48

TYPICAL APPLICATION

The electrode is weldable in all positions except vertical down. She has a smooth drop transfer and the deposit is finely rippled and without undercut. Slag removal is easy and without residues.

WELDING PROCEDURE

The electrode should be welded slightly inclined and with a short arc. Re-drying 2-3 hours at 250 - 300°C

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (-) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 90	2	2 x 5 = 10
3.15 / 3.20	350	80 - 120	2	2 x 5 = 10
4	350	110 - 160	2	2 x 5 = 10
5	350	140 - 200	2	2 x 5 = 10