

GEMET 202

LOW HEAT INPUT AUSTENITIC STAINLESS STEEL ELECTRODE FOR STABILIZED GRADES OF STEELS.

IDENTIFICATION

Gemet 202

DESCRIPTION

- Balanced Cr-Ni ratio with controlled Ferrite.
- Columbium stabilised; ensures excellent resistance to corrosion.
- All position, easy arc striking electrode.

ALLOY BASIS : Fe, Ni, Cr, Cb

MECHANICAL PROPERTIES (RANGE)

UTS (kgf/mm)	EL (%) (L=4D)
55 - 65	30 - 35

TYPICAL APPLICATIONS

For welding of 304, 309, 321, 347 grades. For surfacing low alloyed and cast steels; extensive usage in food industry, dairy, chemical, aircraft industries, pipelines, hospital equipment, oil refineries etc.

APPLICATION TECHNIQUE

- Clean and degrease the weld area. For more than ten gauge sheet prepare 60 included -V-.
- Make accurate fit up for long joints with intermediate tacking.
- Adopt stringer bead technique with short arc length.

WELDING CURRENT : AC / DC (-)

PACKING PARAMETERS

Size (mm)	Length	Current Condition AC / DC (-) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	40 - 70	2	2 x 5 = 10
3.15 / 3.20	350	40 - 70	2	2 x 5 = 10
4	350	80 - 140	2	2 x 5 = 10