GWELD
SEAL OF TRUST

GEMET 203

ACID RESISTANT STAINLESS STEEL ELECTRODES

IDENTIFICATION
Gemet 203

DESCRIPTION
• A medium heavy coated rutile type Molybdenum bearing stainless steel electrode depositing weld metal which has very high resistance to hot cracking, chemical corrosion and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.
ALLOY BASIS : Cr, Ni, Mo

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
550 - 650	35 - 45

TYPICAL APPLICATIONS

- Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 316L, 317L and 318, S.S. clad pleas, chemical plants, paint and dye industries turbine blades, plating tanks etc.
- For welding stainless steel type AISI grades 316L, 317L & 318.

SPECIAL INSTRUCTIONS FOR WELDING

- Clean weld area
- Tack weld at short intervals
- Deposit stringer beads
- Use short length
- Use lowest possible current
- Maintain interpass temperature of about 100°C
- Use stainless steel wire brush for cleaning

REDRYING: 250°C / 2 hrs.

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