

# GEMET 205

## DESCRIPTION

A Low Heat Input Electrode for low alloy corrosion and heat resistant Cr-Ni. Steels of the same nature as well as for dissimilar metal joints.

GEMET 205 is a low heat input electrode producing welds of radiographic soundness with a stable arc. Deposited metal has excellent resistance to corrosion, oxidation and scaling up to 1100°C.

## TYPICAL APPLICATION:

Welding Stainless steel to Mild Steel, Chrome Steel and Clad Steels. Also suitable for dissimilar, difficult to weld steels, ferrite steels etc. A special application is surfacing non-alloy and low alloy (high temperature resistant) steels where 18/8 Cr-Ni alloy is obtained in the first pass.

## PROCEDURE:

Clean and degrease weld area thoroughly. For more than 3120mm sheet prepare 60° included Vee. Make Accurate fit up for long joints with intermediate tacking. Use DC Reverse polarity and stringer bead technique with short arc length.

TECHNICAL DATA	
ALLOY BASIS	Fe,Cr,Ni.
UTS	55-65 Kgf/mm <sup>2</sup>
ELONGATION	30-35%

## WELDING CURRENT AND PACKING DATA:

SIZE (mm)	LENGTH (mm)	AMPS	POLARITY	QTY/CARTON	QTY/BOX
2.50	350	60-80	AC/DC +	2 KGS	2 x 10 = 20
3.15	350	90-110	AC/DC +	2KGS	2 x 10 = 20
4.00	350	110-130	AC/DC +	2KGS	2 x 10 = 20