

# GEMET 206

## FULLY AUSTENITIC HEAT RESISTANT ELECTRODE.

### IDENTIFICATION

Gemet 206

### CLASSIFICATION

AWS/SFA 5.4: E310-16

### DESCRIPTION

- Fully austenitic, heat resistant deposit.
- High strength, ductility, toughness and resistance to creep and scaling upto 1200° C in oxidizing and sulphur free environment.
- Excellent weld finish with very stable arc.
- Also used for Welding Stainless Steel to Mild Steel

### WELD METAL ANALYSIS (RANGE) %

TECHNICAL DATA		
ALLOY BASIS	UTS	EL (%) (L=4D)
Fe, Cr, Ni	56 Kg/mm <sup>2</sup> (95,000 PSi)	30% minimum

### TYPICAL APPLICATIONS

For welding of austenitic, heat resistant stainless steels of 25 Cr / 20 Ni type. Furnace apparatus, heat treatment pots and baskets, heat exchangers, valves, furnace parts, burners etc.

### APPLICATION TECHNIQUE

- Clean the joint area.
- Make an accurate fit up for long joints with tacking.
- Follow stringer bead technique and keep arc length short.
- Try and use lower current to keep interpass temperature on lower side.

**WELDING CURRENT : AC / DC (+)**

### PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 75	2	2 x 5 = 10
3.15 / 3.20	350	90 - 110	2	2 x 5 = 10
4	350	120 - 140	2	2 x 5 = 10
5	350	150 - 180	2	2 x 5 = 10