

GEMET 207

ELECTRODE FOR HIGH RESISTANCE TO HEAT AND CORROSION.

IDENTIFICATION

Gemet 207

DESCRIPTION

A basic coated electrode Manufactured using ER410NiMo Grade of wire depositing weld metal having 13% Cr / 4% Ni / 0.5% Mo intended for welding castings grade ASTM CA 6NM or similar material type 410, 410 S and 405.

ALLOY BASIS : C, Cr, Ni, Mo

HARDNESS (AS WELDED) : Approx 350 BHN

MECHANICAL PROPERTIES (AFTER PWHT OF 610°C/2 HRS.)

| UTS (MPa) | YS (MPa) | EL (%) (L=4D) | CVN Impact Value | |
|-----------|----------|---------------|------------------|--------|
| | | | Temp | Joules |
| 760 min | 550 min | 15 min | 0°C | 45 min |

TYPICAL APPLICATIONS

- For joining and surfacing of all types of carbon and alloyed steels, heat and scale resistant steels, manganese steels and for joining dissimilar steels.
- For cushioning alloy under hard deposits.
- For fabricating & repairing of valves, rolls, gears, hot dies, gas turbines & parts subject to heat, corrosion & impact.
- Cladding side of SS clad steels, hydrogenation plants, combustion chamber parts, furnace parts, etc.

PACKING PARAMETERS

| Size (mm) | Length (mm) | Current Condition AC / DC (+) Amps | Packing / Packet (kg) | Packing / Box (kg) |
|-------------|-------------|------------------------------------|-----------------------|--------------------|
| 2.5 | 350 | 40 - 75 | 2 | 2 x 5 = 10 |
| 3.15 / 3.20 | 350 | 70 - 110 | 2 | 2 x 5 = 10 |
| 4 | 350 | 100 - 140 | 2 | 2 x 5 = 10 |