

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