

GEMET 208

IDENTIFICATION

Gemet 208

DESCRIPTION

A low heat input electrode for Austenitic manganese steel, weld metal has excellent heat resistant properties upto 900°C.

ALLOY BASIS : Cr, Ni, Mn

MECHANICAL PROPERTIES (RANGE)

| UTS (MPa) | EL (%) (L=4D) |
|-----------|---------------|
| 580 - 700 | 30 - 40 |

TYPICAL APPLICATIONS

- For joining austenitic manganese steel (12% Mn).
- Ideal for joining austenitic-manganese steel to mild steel, Difficult to weld steels, High alloy steels etc.
- Used as a buffer layer before hardfacing, surfacing manganese steel rails.
- Joining EN24 with carbon-manganese steel.

PROCEDURE:

- Use short arc.
- Use low amperage especially for high manganese steel
- Peen and de-slag each pass.

WELDING CURRENT : AC / DC (+)

PACKING PARAMETERS

| Size (mm) | Length | Current Condition AC / DC (+) Amps | Packing / Packet (kg) | Packing / Box (kg) |
|-------------|--------|------------------------------------|-----------------------|--------------------|
| 2.5 | 350 | 60 - 90 | 2 | 2 x 5 = 10 |
| 3.15 / 3.20 | 350 | 80 - 110 | 2 | 2 x 5 = 10 |
| 4 | 350 | 110 - 140 | 2 | 2 x 5 = 10 |