

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