

# GEMET 209 FGS

## IDENTIFICATION

Gemet 209 FGS

## DESCRIPTION

Austenitic-Ferritic special electrode depositing weld metal having controlled grain structure. Specially developed electrode satisfying the most exacting requirements. It is extremely crack resistant when joining steels, tool steels as well as dissimilar metal joints. Superb weld ability for all steels.

**ALLOY BASIS** : Cr, Ni

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
800 min	22 - 26

## TYPICAL APPLICATIONS

Repair and maintenance of machine and drive components shafts, gears, housings, construction machinery, high tensile steels, heat treatable and tool steel, hot trim plates, suitable as an elastic cushioning layer before hard surfacing.

## WELDING INSTRUCTION

- Dry the electrodes at 250° C for 2 hrs.
- Clean the welding zone thoroughly.
- Prepare X,V or U groove on thick-walled work pieces with an angle of 60 - 80°
- Preheat high carbon containing steel to about 250° C
- Weld with short arc, deposit stringer weld bead with slight weaving.

**HARDNESS OF THE PURE WELD METAL** : 180 - 220 HB

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

## PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 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
5	350	150 - 180	2	2 x 5 = 10