GWELD
SEAL OF TRUST

GEMET 209

IDENTIFICATION
Gemet 209

DESCRIPTION
A rutile coated electrode depositing austenitic / ferritic stainless steel weld metal with a ferrite content of approximately FN 40. The weld metal exhibits excellent tolerance to dilution from dissimilar and difficult to weld materials without hot cracking.

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	EL (%) (L=4D)
700 – 800	22 - 32

TYPICAL APPLICATIONS
Difficult to weld steels e.g. high carbon harden able tool, die and spring steels, 13 % Mn steels, free cutting steels, high temperature steels, dissimilar joints between stainless and high carbon steels, surfacing metal-to-metal areas, hot working tools, furnace components.
HARDNESS OF THE UNDILUTED WELD METAL : 180 - 240 Brinell
OUTSTANDING FEATURES
- Spray type metal transfer.
- Smooth weld bead, electrode does not get red hot.
- Easy de-slagging.
- Very low spatter loss, soft arc.
- Excellent weld ability for all steels.

WELDING PROCEDURE
- Clean weld area.
- Bevel heavy sections.
- Use recommended current.
- Dry the electrodes at 200°C / 2 hrs.
- Use short arc.

CORROSION RESISTANCE
Good resistance to sulphurous gases at high temperature. Good resistance to wet corrosion upto approximately 300°C.

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+/-) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	65 - 80	2	2 x 5 = 10
3.15 / 3.20	350	70 - 110	2	2 x 5 = 10
4	350	110 - 150	2	2 x 5 = 10
5	350	160 - 210	2	2 x 5 = 10