

# 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<br>AC / DC (+/-)<br>Amps | Packing / Packet<br>(kg) | Packing / Box<br>(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            |