

# GEMET 210

**A LOW HEAT INPUT ELECTRODE FOR 430 TYPE OF STAINLESS STEEL.**

**IDENTIFICATION**

Gemet 209

**DESCRIPTION**

- Versatile electrode for complex dissimilar alloys, high strength steels; giving sound and crack resistant deposit.
- Excellent weld finish with very stable arc.

**ALLOY BASIS :** Fe, Cr, Ni, Mo, Mn

**MECHANICAL PROPERTIES (RANGE)**

UTS (kg f/mm)	EL (%) (L=4D)
50 - 65	30 - 35

**TYPICAL APPLICATIONS**

Joining mild steel to high alloy steel, difficult to weld steels and dissimilar steels; used in oil refineries, chemical industries, dredger and crusher teeth, rubber and glass industries.

**APPLICATION TECHNIQUE**

- Clean and degrease the weld area.
- Use stringer bead technique with short arc length.
- Keep the heat input low by using lower possible current.
- Peening is advised after welding as it helps to relieve locked-up stresses.

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

**PACKING PARAMETERS**

Size (mm)	Current Condition AC / DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	50 - 70	2	2 x 5 = 10
3.15 / 3.20	70 - 100	2	2 x 5 = 10
4	90 - 120	2	2 x 5 = 10