

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