

GEMET 3006N

SUPER HARD-FACING ELECTRODE FOR ABRASION RESISTANT ACCOMPANIED BY IMPACT

IDENTIFICATION

Gemet 3006N

DESCRIPTION

A heavy coated, basic type electrode developed for highly abrasion resistant claddings on parts subjected to extreme sliding mineral abrasion also at elevated temperature up to 500°C. The electrode is recommended where a combination of hardness and toughness is desired on carbon, low alloy steels, manganese steel and cast iron. Deposited weld metal has good compressive strength.

TYPICAL APPLICATIONS

- Surfacing earth moving equipments
- Working parts of the cement and brick industry
- Steel Mill
- Scrappers, paddles, wear pads.

WELDING INSTRUCTIONS

- Clean surface to be welded thoroughly.
- Dry the electrodes at 250°C / 2 hrs
- Hold electrodes at vertical as possible
- Keep a short arc
- Reduce dilution from the weld metal by weaving

HARDNESS OF THE WELD METAL : 57-62 RC

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+ / -) Amps	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	80 - 110	2	2 x 5 = 10
4	350	120 - 160	2	2 x 5 = 10
5	350	150 - 220	2	2 x 5 = 10