

GEMET 304

IDENTIFICATION

Gemet 304

DESCRIPTION

- Electrode depositing tough and wear resistance weld metal.
- Deposited weld metal withstands high abrasion and metal to metal wear in combination with high compressive load.
- Weld deposit is air hardening and Capable of withstanding severe abrasive wear.
- Smooth arc with low spatter level.

ALLOY BASIS : Cr, Mo, V, C

TYPICAL APPLICATIONS

- Punches, Air rings
- Conveyor screws
- Dredger buckets
- Drilling bits, Croppers,
- Bamboo chipper knives
- Mine rails, Digger teeth
- Rollers, Excavator parts
- Crushing hammers
- Shovel drive sprockets
- Impellers, Muller ploughs
- I.D. fans, Mixer blades
- Extruder servers
- Earth moving equipment
- Power plants and cement industry

APPLICATION TECHNIQUE:

- Clean the weld surface.
- Use short arc with DC reverse polarity.
- Use buffer layer if the carbon content of the parent metal is high.
- In case of crack sensitive parent metals preheat is recommended in the range 200-300° C.

HARDNESS : 56 HRC minimum.

WELDING CURRENT : AC / DC +

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition Amps AC / DC (+)	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	70 - 100	2	2 x 5 = 10
4	350	90 - 120	2	2 x 5 = 10
5	350	120 - 140	2	2 x 5 = 10