

GEMET 306

LOW HEAT INPUT AUSTENITIC MANGANESE STEEL ELECTRODE.

IDENTIFICATION

Gemet 306

DESCRIPTION

- Deposit is work hardening type and highly resistant to cracking.
- Good abrasion resistance in work hardening condition and gives long working life if subject to simultaneous impact and braion.

ALLOY BASIS : Fe, Mn, C

TYPICAL APPLICATIONS

Best suited for crusher jaws and cones, Mn points and crossings, excavator teeth, mill hammers, scraper blades, beaters, grinding rings & rollers, gyratory crusher mantles and liners etc.

APPLICATION TECHNIQUE

- Clean the weld area.
- Temperature of the base metal to be maintained as low as possible.
- Use low current, weld in small lengths at a time.
- If possible, part of the job be submerged in water for better heat transfer.
- Peen all the layers.

HARDNESS

25 RC-As welded, work hardening-hardness increases upto 500 Brinell under severe impact applications.

WELDING CURRENT : AC / DC (+)

PACKING PARAMETERS

| Size (mm) | Length (mm) | Current Condition AC / DC (+) Amps | 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 |