

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