

GEMET 367B

IDENTIFICATION

Gemet 367B

DESCRIPTION

A basic coated iron-chromium-molybdenum-nickel-vanadium alloyed electrode designed to resist metal-to-metal wear, fatigue, oxidation, cavitation of high temperature. Deposited welds are crack free.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Mo	V	Ni	Cu
0.09 - 0.14	1.4 - 1.7	0.4 - 0.7	0.025 Max	0.03 Max	2.6 - 3.2	1.2 - 1.55	0.2 - 0.5	1.9 - 2.25	0.06 - 0.10

TYPICAL APPLICATIONS

- Surfacing / rebuilding hot forging dies
- Repairing hot working tools
- Surfacing hammer dies etc.

SPECIAL INSTRUCTIONS DURING WELDING

- Dry the electrodes at 300°C for 1 to 2 hrs.
- Use recommended currents.
- Hold short arc.
- Clean work piece thoroughly before depositing weld.
- Allow weld metal to cool slowly.

HARDNESS OF THE WELD METAL (3 LAYERS) : 35 - 39 HRC approx

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	80 - 110	2	5 x 4 = 20
4	350	130 - 170	2	5 x 4 = 20
5	350	180 - 230	2	5 x 4 = 20