

GEMET 3715

IDENTIFICATION

Gemet 3200N

DESCRIPTION

Basic coated, low hydrogen electrode depositing weld metal which is well suited for highly abrasion resistance application. The weld deposit is high quality tool steel which is tough, hard, wear and oxidation resistance.

ALLOY BASIS : Mo, Cr, W, V, C

TYPICAL APPLICATIONS

For manufacturing new cold & hot working tools, hot cutting tools, trimming knives, cold punching tools, valves, extrusion press pistons, forging tools.

HARDNESS OF THE PURE WELD METAL: As welded 59 - 62 Rc

AFTER WORK HARDENING: 62 - 65 Rc

WELDING INSTRUCTIONS

- Redry electrodes at 300°C / 2 hrs. before use.
- Preheat the workpiece to about 400°C
- Hold electrode as vertically as possible and with a short arc, deposit welds. Allow the workpiece to cool slowly.
- Finish by grinding

HEAT TREATMENT INFORMATION

ANNEALING : 4 hours at 820°C

HARDENING : 1180 - 1230°C quenching in oil

TEMPERING : 540 - 560°C

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	80 - 110	2	2 x 5 = 10
4	350	110 - 140	2	2 x 5 = 10
5	350	150 - 200	2	2 x 5 = 10