

GEMET 374CW

IDENTIFICATION

Gemet 374 CW

DESCRIPTION

Specially developed electrode for surfacing crane wheels and for surfacing points and crossings (frogs) of rails. The weld metal has fully austenitic structure. The weld metal has increased resistance against friction, corrosion, pressure and shock. The weld metal has very high toughness.

ALLOY BASIS : Cr, Mo, Mn

MECHANICAL PROPERTIES (RANGE)

UTS (N/mm ²)
850 approx.

TYPICAL APPLICATIONS

- Suitable for cladding on parts subjected to highest pressure and shock load in combination with abrasion. Cladding and built-up can be made on ferritic as well as on hard manganese steel.
- Crane wheels, cement & mining industry, roller spindles, carrier and wobblers in the steel works, hydraulic press piston etc.
- For surfacing points and crossings (frogs) of rails.

WELDING INSTRUCTIONS

- Dry the electrodes at 250°C / 2 hrs.
- Hold electrode nearly vertical.
- Welding should be done at low temperature.
- Interpass temperature should not exceed 150°C.

HARDNESS OF THE PURE DEPOSIT : Approx. 260 HB

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC (70 OCV) / DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
3.15 /3.20	350	100 - 150	2	2 x 5 = 10
4	350	140 - 190	2	2 x 5 = 10
5	350	190 - 240	2	2 x 5 = 10