

# GEMET 501

**FERROUS ELECTRODE FOR NON-MACHINABLE WELDING OF CAST IRON.**

## IDENTIFICATION

Gemet 501, Est

## CLASSIFICATION

AWS/SFA E 5.15: Est

## DESCRIPTION

- Economical electrode with good bonding properties.
- Soft stable arc with good crack resistivity.

**ALLOY BASIS** : Fe, Si, C

## MECHANICAL PROPERTIES (RANGE)

| UTS (kg/mm) |
|-------------|
| 55 - 60     |

## TYPICAL APPLICATIONS

- Specially designed electrode suitable for welding of cast iron to cast iron and for joining cast iron to carbon or low alloy steels.
- For surfacing of cast iron, repair or large size castings.
- Best suited for rusty, corroded and greasy castings.

## APPLICATION TECHNIQUE

- Clean the weld area properly.
- Recommended to use DC reverse polarity and lowest possible current.
- Weld with short arc and slight weaving if necessary.
- Peen the deposit after every pass.

**WELDING CURRENT** : AC / DC (+)

## PACKING PARAMETERS

| Size (mm)   | Length (mm) | Current Condition AC / DC (+) | Packing / Packet (kg) | Weight / Box (kg) |
|-------------|-------------|-------------------------------|-----------------------|-------------------|
| 2.5         | 350         | 40 - 70                       | 2                     | 2 x 5=10          |
| 3.15 / 3.20 | 350         | 60 - 130                      | 2                     | 2 x 5=10          |
| 4           | 350         | 90 - 160                      | 2                     | 2 x 5=10          |