

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