

GEMET 502

MONEL ELECTRODE FOR WELDING OF CAST IRON.

IDENTIFICATION

Gemet 502, ENiCu-B

CLASSIFICATION

AWS/SFA 5.15: ENiCu-B

DESCRIPTION

- Very good welding characteristics.
- Fully machinable, ductile and crack resistant weld metal.
- Good for corrosion resistant cladding.

ALLOY BASIS : Ni, Cu, Fe

MECHANICAL PROPERTIES (RANGE)

UTS (kg/mm)
48 - 52

TYPICAL APPLICATIONS

- Nickel copper electrode for repairing and surfacing all types of cast iron without pre heating the parent metal.
- Can be used for welding of Monel and similar alloys.
- If possible, iron admixture should be kept low, thus using it preferably for filler and cover passes or for filling shrinkage cavities.
- Weld metal closely matches colour of base metal.

APPLICATION TECHNIQUE

- Maintain short arc.
- DC reverse polarity is recommended for reducing the heat input.
- Straight polarity will give flat beads. Effect of AC is in between the above.
- Pre-heating of the parent metal is not required.

WELDING CURRENT : AC / DC

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	40 - 70	2	2 x 5=10
3.15 / 3.20	350	60 - 90	2	2 x 5=10
4	350	80 - 110	2	2 x 5=10\