

GEMET 503

LOW HEAT INPUT ELECTRODE FOR DIFFERENT GRADES OF CAST IRON.

CLASSIFICATION : AWS/SFA 5.15 : ENiFeCl

IDENTIFICATION

Gemet 503

DESCRIPTION

- Highly crack resistant electrode with soft and stable arc.
- All position electrode, with smooth rippled bead and no under cuts.

ALLOY BASIS : Fe, Ni - 55%

MECHANICAL PROPERTIES (RANGE)

UTS MPa (N/mm2)	Hardness
400 - 579	165 - 218 BHN

TYPICAL APPLICATIONS

Joining, repairing, and surfacing of all cast iron components, nodular, malleable grey cast iron; for building up, overlaying and for filling up porosity in castings.

APPLICATION TECHNIQUE

- Remove casting skin from the welding area.
- For thicker sections, double -U -preparation is recommended.
- Restrike on weld and not on parent metal.
- Hold the electrode vertically.
- Peen the deposit after every pass.

WELDING CURRENT : AC / DC (-)

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (-)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 80	2	2 x 5=10
3.15 / 3.20	350	60 - 110	2	2 x 5=10
4	350	80 - 120	2	2 x 5=10
5	350	100 - 170	2	2 x 5=10