

GEMET 506B

Outstanding cast iron electrode nickel-iron depositing for weld metal

CHARACTERISTICS : GEMET 506B is specially formulated fully basic graphite flux coated, low heat in-put electrode designed to weld all weldable cast iron with superior strength that helps in elimination of defects in heavy casting and for welding of cast iron to mild steel.

Electrodes have good welding properties with uniform bead. Deposits are machinable and crack-proof. Deposited weld metal is less sensitive to hot cracking caused by pick up of impurities such as phosphorus which is often present in the iron castings. The electrode does not get red hot during welding and hence can be used to its full length without any wastage.

TYPICAL APPLICATIONS:

- Machine tool bases, valve body, Gear teeth, couplings Joining, repairing and surfacing of all cast iron components, viz.
- Engine heads, pumps casings, impellers, rope drums, machinery parts, ingot moulds, gears, transmission housings, spherical graphite (SG) cast iron, nodular or ductile iron or some alloy cast iron etc.

WELDING INSTRUCTIONS:

- Clean the welding area thoroughly, V angle of butt joint should be min70°.
- Remove the oxide film by grinding 10mm beside the Joint Deposit stringer beads, Keep short-arc

TECHNICAL DATA	
ALLOY BASIS UTS (N/mm ²)	Ni,Fe,C 480

CURRENT CONDITION / PACKING SPECIFICATION:

SIZE (mm)	LENGTH (mm)	DC(+) AMPS	PACKING/CARTON (KG.)
2.50	350	60-85	2 x 10 = 20
3.15/3.20	350	80-110	2 x 10 = 20
4.00	350	110-130	2 x 10 = 20