

Gemet 706

CLASSIFICATION: AWS/SFA 5.6 ECu DIN 1733: ELCu

CHARACTERISTICS:

The elements deposits porosity free weld metal which is well deoxidized and crack free. The corrosion resistance properties are equal to that of the best commercially copper grades.

APPLICATIONS:

- For joining and surfacing of oxygen free copper.
- Cladding welds on steel.

Weld Metal Analysis (%):

Cu	Mn	Ag
97% Max	0.5% approx.	1.00% Max

MECHANICAL PROPERTIES OF THE WELD METAL:

Ult. Tensile strength MPa = 200 approx.

Elongation (L=4d) % = 34% approx.

WELDING INSTRUCTION:

- Clean the weld zone thoroughly.
- Parent metal up to 5.0mm thick does not require preheating. For higher thickness sufficient.
- preheating is necessary for obtaining desired results.
- Keep the arc short.
- Slight weaving assist welding.
- Use bigger diameter electrode possible.

FOR CURRENT CONDITIONS AND PACKING SPECIFICATIONS:

SIZE (MM)	LENGTH (MM)	DC(+) AMPS	Packing/BOX (Kg)
2.5	350	60-90	2×5=10
3.15	350	80-110	2×5=10
4	350	110-140	2×5=10