

GEMET 717

MANGANESE-NICKEL-ALUMINIUM BRONZE ELECTRODE

IDENTIFICATION

Gemet 717, ECuMnNiAl

CLASSIFICATION

AWS/SFA 5.6: ECuMnNiAl, DIN 1733:E31-UM-150-CNR

DESCRIPTION

Medium coated basic type electrode depositing Porosity free weld metal with very good resistance to corrosion and wear.

WELD METAL ANALYSIS (RANGE) %

Al	Mn	Fe	Ni	Cu
7.00 max	13.0 max	2.50 max	2.50 max	Remainder

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	PS (MPa)	EL (%) (L=4D)	Hardness
520 - 650	380 min	20%	180 - 220 BHN

TYPICAL APPLICATIONS

- Welded joints and surfacing on aluminium bronzes, multi-alloy aluminium bronzes and aluminium bronze castings.
- In shipbuilding, apparatus engineering, machine industry and fittings manufacture.
- Welding repairs on similar parent materials.
- Weld surfacing of corrosion resistant multi-alloy aluminium bronze armour coatings on unalloyed steels and cast iron.
- Suitable for welded joints on Wnr. 2.0916, 2.0920, 2.0928, 2.0932, 2.0936, 2.0940, 2.0962, 2.0966, 2.0970, 2.0978, 2.0980. Joint preparation should have 90° included angle. Preheating is only necessary when welding large castings. A fast welding speed is recommended in order to keep down the size of the weld pool.

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	60 - 90	2	2 x 5 = 10
3.15 / 3.20	350	90 - 120	2	2 x 5 = 10
4	350	120 - 150	2	2 x 5 = 10