

# **GEMET 811**

## **IDENTIFICATION**

Gemet 811, ENiCu7

## **CLASSIFICATION**

AWS/SFA 5.11 ENiCu7 DIN 1736 EL-NiCu30Mn (2.4366)

## **DESCRIPTION**

Basic coated electrode suitable for joining and surfacing of Nickel Copper - clad steels. The welds are of X-ray / radiographic quality.

The electrode can be used in all positions and has excellent striking and restriking properties. The Fe content in the weld metal is very low. Hence, for overlay applications, it is an ideal electrode.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Al	Fe	Ni	Cu	Ti
0.1	4	1.5	0.015	0.02	0.75	2	62.0 - 69.0	Remainder	1
max	max	max	max	max	max	max			max

## **MECHANICAL PROPERTIES (RANGE)**

TS (MPa)	EL (%) (L=4D)
480 min	30 min

#### TYPICAL APPLICATIONS

- For surfacing nickel copper alloys, nickel-copper clad steel.
- Chemical and Petrochemical Industries fabrication of sea water evaporations plants and marine equipments.
- ASTM UN NO 4400, UNS NO 440S, NO 5500
- Inco Monel 400, R405, K 500.

#### WELDING INSTRUCTIONS

- Clean thoroughly the welding area / zone.
- Vee angle of the butt joint should be 70°C.
- Weld with dried electrodes only.
- Dry the electrodes at 250°C for 2 hrs.

## **PACKING PARAMETERS**

Size (mm)	Length (mm)	Current Condition Amps DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	55 - 75	2	$2 \times 5 = 10$
3.15 / 3.20	350	75 - 110	2	$2 \times 5 = 10$
4 350		90 - 130	2	$2 \times 5 = 10$



350

140 - 165

2

 $2 \times 5 = 10$