GWELD
SEAL OF TRUST

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 max	4 max	1.5 max	0.015 max	0.02 max	0.75 max	2 max	62.0 - 69.0	Remainder	1 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 70ºC.
- Weld with dried electrodes only.
- Dry the electrodes at 250ºC 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 x 5 = 10
3.15 / 3.20	350	75 - 110	2	2 x 5 = 10
4	350	90 - 130	2	2 x 5 = 10

5	350	140 - 165	2	2 x 5 = 10