

GEMET 826

IDENTIFICATION

Gemet 826, ENiCrMo-6

CLASSIFICATION

AWS A 5.11: ENiCrMo6

DESCRIPTION

Basic coated electrode depositing weld metal having about 14.6% Cr, 6.5% Mo, 1.1% Nb, 1.2% W, 8% Fe & remaining Nickel.

The electrode is all positioned & deposit radiographic quality weld metal.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cu	Cr	W	Mo	Fe	Nb+Ta	Ni	Other elements
0.01 max	2.0 - 4.0	1 max	0.02 max	0.03 max	0.5 max	12.0 - 17.0	1.0 - 2.0	5.0 - 9.0	10 max	0.50 - 2.0	Remainder	0.5 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
690 min	420 min	40 min	-196°C	70

TYPICAL APPLICATIONS

- Welding cryogenic steels for applications down to -196°C.
- Especially designed for welding 9% nickel steel.
- Easy handling even in difficult welding positions.

CURRENT : DC+ and AC (Uo:70V)

REDRYING : Min 1 hour at 300°C

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition Amps DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	70 - 110	2	2 x 5 = 10
3.15 / 3.20	350	90 - 150	2	2 x 5 = 10
4	350	130 - 190	2	2 x 5 = 10