

# GEMET 827

## IDENTIFICATION

Gemet 827, ENiCrMo-7

## CLASSIFICATION

AWS A 5.11 ENiCrMo7

## DESCRIPTION

Basic coated electrode depositing weld metal having about 65% Nickel, 15% Cr, 16% Mo and 1.5% Fe. The electrodes are usually used for welding in down hand position. Corrosion resistance properties are superior and withstand heavy corrosion in service.

## WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cu	Cr	Ni	Mo	Fe	Ti	Co	W	Other
0.015 max	1.5 max	0.2 max	0.03 max	0.04 max	0.5 max	14.0 - 18.0	55 min	14.0 - 17.0	3 max	0.7 max	2 max	0.5 max	0.5 max

## MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
690 min	25 min

## TYPICAL APPLICATIONS

- For welding Nickel-Chromium-Molybdenum alloys of similar composition.
- For welding of clad side of the joint.
- For joining Nickel -Chrome-Molybdenum alloys to themselves or to carbon or low alloy steels.
- ASTM B574, B575, B619, B622 and B626, UNS No. N06455

## PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition Amps DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	60 - 80	2	2 x 5 = 10
3.15 / 3.20	350	70 - 120	2	2 x 5 = 10
4	350	100 - 155	2	2 x 5 = 10
5	350	130 - 250	2	2 x 5 = 10