

GEMET 828N

IDENTIFICATION

Gemet 828N, ENiCrMo-18

CLASSIFICATION

AWS SFA 5.11: ENiCrMo18

DESCRIPTION

Basic coated Nickel base electrode depositing 50% Ni, 20% Cr, 13.5% Fe, 11.5% Mo and 1.5% W. Electrodes through the 8 3.2 mm dia can be used for welding in all positions. Electrodes larger than that are used only in the flat position.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Nb+Ta	Cr	Fe
0.03 max	0.7 max	0.6 max	0.03 max	0.03 max	0.30 max	19 - 22	Dec-15
Mo	W	Ni	Co	Cu	Al	V	Other elements
Oct-13	01-Feb	Balance	1.0 max	0.30 max	0.50 max	0.15 max	0.50 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	EL (%) (L=4D)
650 min	30 min

TYPICAL APPLICATIONS

- For welding nickel - chromium - molybdenum alloys like UNS Number N06625.
- For welding of the clad side of joints in steel clad with nickel - chromium - molybdenum alloy.
- Joining some other nickel - chromium - molybdenum alloys, such as UNS numbers N06625, N08825, N06985, N08020, N08926 and N08031.

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