

GEMET 831N

IDENTIFICATION

Gemet 831N, ENiMo-1

CLASSIFICATION

AWS/SFA 5.11: ENiMo-1

DESCRIPTION

Basic coated electrode manufactured by using alloy wire of specific composition and is normally used in down-hand position for welding. Deposited welds are of radiographic quantity.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	P	S	Cu	Fe	Co	Cr	Mo	V	W
0.07 Max	1 max	1 max	0.04 Max	0.03 max	0.5 max	4.0 - 7.0	2.5 max	1 max	26.0 - 30.0	0.6 max	1 max
Nickel - Remainder (Balance)											

MECHANICAL PROPERTIES (RANGE)

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

TYPICAL APPLICATIONS

- For welding Nickel - Molybdenum alloys as well as clad side of joints in steel clad with a Nickel - Molybdenum alloys.
- Nickel - Molybdenum alloy to steel and other Nickel base alloys.
- ASTM B 333, BB35, B619, B6226

REDRYING OF ELECTRODES : 300°C for 2 hrs.

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition Amps DC (+)	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	50 - 70	2	2 x 5 = 10
3.15 / 3.20	350	70 - 100	2	2 x 5 = 10
4	350	100 - 140	2	2 x 5 = 10