

# GEMET ST 12

## IDENTIFICATION CLASSIFICATION

Gemet ST12, ECoCr-B AWS/SFA 5.13: ECoCr-B, EN 14700: E Co 3,  
DIN8555: E20-UM-50-CSTZ

## DESCRIPTION

GEMET ST12 has excellent welding properties and a homogeneous, finely rippled seam due to spray arc. Very easy slag removal.

## WELD METAL ANALYSIS (RANGE) %

C	Cr	W	Co
1.6 max	29 max	8.5 max	Balance

## MECHANICAL PROPERTIES (RANGE)

Hardness of Pure Weld Metal
45 - 50 HRC

## TYPICAL APPLICATIONS

GEMET ST12 is used for highly wear resistant hard facing on parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high temperatures up to 900°C, such as running, sealing and gliding faces on fittings and pumps, tools for wood, paper, plastic, shredding tools, highly stressed hot working tools without thermal shock. Machining by grinding or with tungsten carbide cutting tools.

## WELDING INSTRUCTIONS:

- Clean welding area
- Preheating temperature 450 - 600°C
- Very slow cooling.
- Hold stock electrode vertically and with a short arc and lowest possible amperage.
- Re-dry electrodes that have become damp for 2 hrs / 300°C

## PACKING PARAMETERS

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