

GEMET ST 21

IDENTIFICATION

Gemet ST21, ECoCr-E AWS/SFA 5.13: ECoCr -E, EN 14700: ECo1,
DIN8555: E20-UM-300 -CTZ

CLASSIFICATION

DESCRIPTION

Basic coated stick electrode for the hardfacing of unalloyed, low-alloyed and high-alloyed steels. The weld metal is heat resistant and shows a good resistance against corrosive media. In the case of friction and sliding wear the alloy has a low friction coefficient against steels. Service temperatures up to 800°C.

WELD METAL ANALYSIS (RANGE) %

C	Cr	Mo	Ni	Co	Mn	Si	Fe	W
0.15 min 0.4 max	24 min 29 max	4.5 min 6.5 max	2 min 4 max	Bal	1.5 max	2.0 max	5.0 max	0.5 max

MECHANICAL PROPERTIES (RANGE)

Hardness of Pure Weld Metal
33 HRC

TYPICAL APPLICATIONS

- High heat resistant special alloy with good high temperature strength. The weld metal shows an excellent resistance against mechanical shock.
- This electrode is normally used for the hardfacing of forging dies, punches and hot cutting tools. Hot Trimming dies, valves.
- Suitable for the cladding of sealing surface of valves used in power plants and chemical industry.

REDRYING : 300 - 320°C / 2 h of electrodes.

PACKING PARAMETERS

Size (mm)	Length (mm)	Welding Current (A) Polarity = (+) ~	Packing / Packet (kg)	Packing / Box (kg)
2.5	350	70 - 110	2	2 x 5 = 10
3.15 / 3.20	350	100 - 140	2	2 x 5 = 10
4	350	140 - 180	2	2 x 5 = 10
5	350	180 - 220	2	2 x 5 = 10