

# GEMET ST1

## IDENTIFICATION

GEMET ST1, ECOCR-C

## CLASSIFICATION

AWS/SFA 5.13: ECoCr-C

## DESCRIPTION

Rutile-coated welding electrode on cobalt base, core wire alloyed. Gemet ST1 has excellent welding properties and a homogeneous, finely rippled seam weld metal.

## WELD METAL ANALYSIS (RANGE) %

| C       | Cr     | W      | Co      |
|---------|--------|--------|---------|
| 2.5 max | 30 max | 12 max | balance |

## MECHANICAL PROPERTIES (RANGE)

| Hardness of Pure Weld Metal |
|-----------------------------|
| 46 HRC approx.              |

## TYPICAL APPLICATIONS

- Seal Rings,
- Cutters,
- Chain Saws,
- Crushers

## WELDING INSTRUCTIONS:

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

## PACKING PARAMETERS

| Size (mm)   | Length (mm) | Current Condition AC / DC (+) Amps | Packing / Packet (kg) | Packing / Box (kg) |
|-------------|-------------|------------------------------------|-----------------------|--------------------|
| 3.15 / 3.20 | 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         |