

# 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