

# GEMET 102



IDENTIFICATION : GEMET 102

ELECTRODE FOR WELDING MILD STEEL STRUCTURES

## CHARACTERISTICS :

Easy-to-use electrode with fine droplet transfer. Fine ripple pattern of weld bead. Easy striking and re-striking. Very good slag removal.

## TYPICAL APPLICATION :

Welded joints on steel constructions, in boiler fabrication, car body works, fitting shops , construction steels, etc.

## MECHANICAL PROPERTIES :

- Tensile strength : 480-600 Mpa
- Yield strength : 400-490 Mpa
- Elongation( l=5 d): 24-30%
- Impact energy (ISO-V/20°C): 60-90 Joules

## WELDING INSTRUCTIONS :

- Keep short to medium arc with slight weaving.
- The electrode should be held at a slight angle to the parent metal.

## PACKING SPECIFICATION :

SIZE (mm)	LENGTH (mm)	CURRENT CONDITION AC/DC(-) AMPS	PACKING PER PKT (Kg)	QUANTITY PER BOX Kg
2.5	350	50-70	2 Kg	2x5= 10 Kg
2.5	350	70-100	2 Kg	2x5= 10 Kg

3.15	350	100-140	2 Kg	2x5= 10 Kg
4.0	350	140-190	2 Kg	2x5= 10 Kg