

GEMET 103



IDENTIFICATION : GEMET 103

MAINTENANCE ELECTRODE - CARBON STEEL

Low heat input all position electrode for medium tensile steel, ductile steel weld.

Alloy Basis : Fe, C, Mn, Si

CHARACTERISTICS :

- Finely rippled bead.
- Easily detachable slag.
- Weld metal is ductile; resistance to cracking.
- Radiographic quality.
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TYPICAL APPLICATION :

- Pressure Vessels.
- Section.
- Heavy Machine.
- Steel.
- Oil.
- Chain.
- Gun plates.

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

Mechanical Properties Range :

- Tensile strength : 540-680 mpa.
- Elongation : 24-30%

APPLICATION TECHNIQUE :

- Clean the joint area.
- Use DC reverse polarity with short arc.
- Redry electrodes at 300 °C for one hour to obtain better results.
- Slight weaving is recommended.

UTS : 55-68 kgf/mm.

Elongation : 24-30%.

Welding current : AC/DC(+)

Recommended Current And Packing Data :

| SIZE (mm) | AMPS AC/DC(+) |
|-----------|---------------|
| 3.15 | 90-140 |
| 4.00 | 120-180 |
| 5.00 | 150-240 |