

# GEMET 104



IDENTIFICATION : GEMET 104

MAINTENANCE ELECTRODE

Low heat input electrode for medium tensile steels.

Alloy Basis : C, Mn, Si

CHARACTERISTICS :

- Very smooth, uniform bead of radiographic quality with high metal recovery.
- Excellent impact resistance at sub-zero temperature.
- Deposited welds are of radiographic quality.
- Diffusible Hydrogen in the weld metal is very low, hence it has crack resistance properties.

TYPICAL APPLICATION :

Highly stressed crack sensitive joints, ship building, heavy boilers, pressure vessels, high pressure piping, gun plates, heavy equipment maintenance.

MECHANICAL PROPERTIES :

- Tensile strength : 500 – 610 mpa
- Elongation : 22-30%

Recommended Current And Packing Data :

SIZE (mm)	LENGTH (mm)	AMPS AC / DC (+)	QUANTITY / BOX (kg)
3.20	450	90-140	2 x 10 = 20 Kg
4.00	450	120-180	2 x 10 = 20 Kg
5.00	450	150-220	2 x 10 = 20 Kg

