

GEMET 105



IDENTIFICATION : GEMET 105

MAINTENANCE ELECTRODE - CARBON STEEL

Low hydrogen electrode with good ductility & creep resistance.

ALLOY BASIS : C,Mn,Si,Mo.

CHARACTERISTICS :

Low heat in-put, All position, Basic coated electrode with high metal recovery. Easy weldability and high mechanical properties. Deposited weld metal is of radiographic quality. Weld metal is tough and resistant to ageing, high triaxial stresses and withstand heavy shocks.

TYPICAL APPLICATION :

For welding ASTM A336 Gr FJ, A335 Gr PJ.High temperature pressure pipelines, boiler tubes and boiler plates where good creep resistance is necessary.For welding of carbon steels of unknown composition. For welding creep resistance ferritic steel in steam and chemical plant,thermal power ,tube to tube,shield in heat exchange. Difficult to weld steel, highly stressed joints.

MECHANICAL PROPERTIES (RANGE) :

Tensile Strength MPa	Elongation (%) (L=4D)	Impact Value	
550 min	26 min	Temp.	Joules
		-30°C	100 Min

WELDING PROCESS :

Shielded Metal Arc Welding (SMAW)

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	AMPS AC/DC(+)	Qty Per Pkt (Kg)	Qty Per Box (Kg)
3.20	90-140	2.0	2 x 6 = 12
4	120-180	2.0	2 x 6 = 12
5	150-220	2.0	2 x 6 = 12