

# GEMET 203



ACID RESISTANT, STAINLESS STEEL ELECTRODES

ALLOY BASIS : Cr, Ni, Mo

## CHARACTERISTICS :

A medium heavy coated rutile type Molybdenum bearing stainless steel electrode depositing weld metal which has very high resistance to hot cracking, chemical corrosion and stress corrosion cracking. Molybdenum imparts resistance to corrosion of reducing nature. The deposited weld metal is of radiographic quality.

## TYPICAL APPLICATION :

Suitable for welding stainless steels extra low carbon or stabilised by Titanium or Niobium such as AISI grades 316L, 317L and 318, S.S. clad plates, chemical plants, paint and dye industries turbine blades, plating tanks etc. For welding stainless steel type AISI grades 316L, 317L & 318.

## SPECIAL INSTRUCTIONS FOR :

**REDRYING** : 250°C / 2 hrs.

## WELDING :

- Clean weld area
- Tack weld at short intervals
- Deposit stringer beads
- Use short length
- Use lowest possible current
- Maintain interpass temperature of about 100°C

Use stainless steel wire brush for cleaning

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	PACKING PER BOX, KGS
2.50	350	2 x 5 = 10 Kgs

3.15/3.20	350	2 x 5 = 10 Kgs
4.00	350	2 x 5 = 10 Kgs
5.00	350	2 x 5 = 10 Kgs