

# GEMET 204



**IDENTIFICATION :** A Low Heat Input Electrode for joining stainless steel to carbon steel and for over lays.

**GEMET-204** is a low heat input S.S. electrode with excellent arc stability, easy to strike and restrict and with finely rippled beads. Weld metal is strong and ductility and has high resistance to corrosion, erosion and is extremely heat resistance.

## TYPICAL APPLICATION :

Welding stainless steel to carbon, low alloy and cast steel and for tough over lay on cast steel and austenitic manganese steel valve faces and seats, pump impeller, shafts etc, It is used extensively in chemical, dairy, brewery and food industries.

**PROCEDURE :** Clean and degrease weld area. For more than 10 gauge sheet prepare 60° included vee. Make accurate fit up for long joint with intermediate tacking. Use DC Reverse polarity and stringer bead technique with short arc length. For best result, dry electrode at 150 °C for one hour before use.

## RECOMMENDED CURRENT AND PACKING DATA :

TECHNICAL DATA	
ALLOY BASIS	Fe,Cr,Ni,Mn,Mo.
UTS	60 - 70 Kgf/mm <sup>2</sup>
ELONGATION	30 - 35%

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS	POLARITY	WT.PER CARTON	WT. PER BOX
2.50	350	70 - 90	AC/DC +	2 KGS	12 KGS
3.15	350	100 - 120	AC/DC +	2 KGS	12 KGS
4.00	350	120 - 140	AC/DC +	2 KGS	12 KGS