

GEMET 206



Fully austenitic heat resistant electrode.

Classification: AWS/SFA 5.4: E310-16

APPLICATION

For welding of austenitic, heat resistant stainless steels of 25 Cr/20Ni type. Furnace apparatus, heat treatment pots and baskets, heat exchangers, valves, furnace parts, burners etc.

CHARACTERISTICS

- Fully austenitic, heat resistant deposit.
- High strength, ductility, toughness and resistance to creep and scaling upto 12000 C in oxidizing and sulphur free environment.
- Excellent weld finish with very stable arc.

APPLICATION TECHNIQUE:

Clean the joint area. Make an accurate fit up for long joints with tacking. Follow stringer bead technique and keep arc length short. Try and use lower current to keep interpass temperature on lower side.

Alloy Basis : Fe, Cr, Ni.

UTS : 550 min

Elongation: 30% minimum

Welding current: AC/DC(+).

PACKING SPECIFICATION :

SIZE (mm)	LENGTH (mm)	CURRENT CONDITIOIN	Packing/Box (Kg)
2.50	350	50-75	2 X 5 = 10
3.15	350	90-110	2 X 5 = 10

4.00	350	120-140	$2 \times 5 = 10$
5.00	350	150-180	$2 \times 5 = 10$