

GEMET 207



ELECTRODE FOR HIGH RESISTANCE TO HEAT AND CORROSION.

CHARACTERISTICS :

A basic coated electrode Manufactured using ER410Ni Mo Grade of wire depositing weld metal having 13% Cr / 4% Ni/0.5% Mo intended for welding castings grade ASTM CA 6 NM or similar material type 410,410 S and 405.

APPLICATION :

For joining and surfacing of all types of carbon and alloyed steels, heat and scale resistant steels, manganese steels and for joining dissimilar steels. For cushioning alloy under hard deposits. For fabricating & repairing of valves, rolls, gears, hot dies, gas turbines & parts subject to heat, corrosion & impact. Cladding side of SS clad steels, hydrogenation plants, combustion chamber parts, furnace parts, etc.

ALLOY BASIS: C, Cr, Ni, Mo

Hardness (as welded): Approx 350 BHN

MECHANICAL PROPERTIES (After PWHT of 610°C/2 hrs.):

Ultimate Tensile Strength (MPa)	Yield Stress (0.2% offset) (MPa)	Elongation % (L=4D)	Charpy v-notch Impact strength in joules	
			Temp	Value
760 min	550 min	15 min	0° C	45 min

PACKING SPECIFICATION :

SIZE (mm)	LENGTH (mm)	CURRENT CONDITIOIN AC/DC(+) AMPS	PACKING/PKT (KG)	QUANTITY/BOX (KG)
2.50	350	40-75	2.0	2x5=10
3.15	350	70-110	2.0	2x5=10
4.00	350	100-140	2.0	2x5=10