

GEMET 208



A low heat input electrode for Austenitic manganese steel, weld metal has excellent heat resistant properties upto 900°C.

APPLICATION :

For joining austenitic manganese steel (12% Mn). Ideal for joining austenitic manganese steel to mild steel, Difficult to weld steels, High alloy steels etc. Used as a buffer layer before hardfacing, surfacing manganese steel rails. Joining En24 with carbon-manganese steel.

PROCEDURE :

- Use short arc.
- Use low amperage especially for high manganese steel
- Peen and deslag each pass.

Alloy Basis : Cr, Ni, Mn

UTS: 580 - 700 MPa

Elongation: 30-40%

Welding current: AC/DC(+)

PACKING SPECIFICATION :

SIZE (mm)	CURRENT CONDITIOIN AC/DC (+) Amps
2.50	60-90
3.15	80-110
4.00	110-140