

# GEMET 302



## CHARACTERISTICS :

Highly wear resistance and tough surfacing electrode. Basic coated electrode depositing wear resistance weld metal.

## APPLICATION :

For surfacing parts subject to severe abrasion and moderate impact. Conveyor, screwa, cutting and forming tools, , guide rails, stamping, mixer blades, pump and crushing parts operating in clay, sand and cement plants.

**Alloy basis :** Cr,C,Mo.

**Hardness of the weld metal :** 55 to 60 HRC

**Welding Current :** DC (-) or AC ( 70 OCV min)

## WELD METAL COMPOSITION (%) :

C	Mn	Si	Cr	Mo
0.4-0.55	0.8 max	1.0 max	9-11	1.0 - 2.0

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS DC(-)/AC (10 OCV)	PACKING PER CARTON/Box, Kg
3.20	350	90-130	2 x 6 = 12
4.0	350	120-160	2 x 6 = 12
5.00	350	160-200	2 x 6 = 12

