

# GEMET 302B



IDENTIFICATION : GEMET 302B

## CHARACTERISTICS :

A basic coated, all position, electrode depositing tough and wear resistant weld metal. The weld metal is completely machinable.

## TYPICAL APPLICATION :

Rails, dies, striking tools, rolling surfaces, sprockets, rollers, shafts, gear teech, concrete mixer blades, construction machinery parts like tractor, sprockets.

## TECHNICAL DATA :

**Hardness** : 280 - 340 Brinell

## PROCEDURE :

- Clean thoroughly weld area.
- Preheat heavy sections to about 100-150°C.
- Dry the electrodes at 250°C/2 hrs before use.
- Use short arc and recommended current.
- Chip slag between passes.

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS AC/DC (+)	PACKING PER BOX
3.15	350	80-110	2 x 5 = 10 kg.
4.00	350	110-160	2 x 5 = 10 kg.
5.00	350	140-200	2 x 5 = 10 kg.