

GEMET 303



DESCRIPTION : High wear resistance electrode with mild impact.

GEMET - 303 is a hardfacing electrode with an exceptional resistance to abrasion and wear in addition to resistance to mild impact. An all position electrode giving uniform beads. Deposits are hard and tough and free from porosities. Deposits are machinable using carbide tools. Weld deposit is air-hardening.

APPLICATIONS :

Crushers, baffle plates, pressure rollers, shear blades, roller, wheel riser, stompers, excavator parts, rock drills, tractor grousers and paddlers.

PROCEDURE :

Clean surface thoroughly. Use short arc with DC reverse polarity. No more than 2-3 layers should be deposited. Use a buffer layer of GEMET - 103 on high carbon steel. Reheat crack sensitive parent metals to 200-300°C

WELD METAL COMPOSITION (%)

TECHNICAL DATA	
ALLOY BASIS	Fe,Cr,Mn,C
HARDNESS AS	50 - 55 HRC
DEPOSITED	0.005-0.02

WELDING CURRENT & PACKING DATA :

SIZE (mm)	LENGTH (mm)	AMPS	POLARITY	WT.PER CARTON	WT. PER BOX
3.15	350	90-120	AC/DC +	2 KGS	12 KGS

4.00	350	120-160	AC/DC +	2 KGS	12 KGS
5.00	350	150-190	AC/DC +	2 KGS	12 KGS