

GEMET 304



IDENTIFICATION : GEMET 304

DESCRIPTION :

Electrode depositing tough and wear resistance weld metal. Deposited weld metal withstands high abrasion and metal to metal wear in combination with high compressive load.

APPLICATION:

- Punches, Air rings
- Conveyor screws
- Dredger buckets
- Drilling bits, Croppers,
- Bamboo chipper knives
- Mine rails, Digger teeth
- Rollers, Excavator parts
- Crushing hammers
- Shovel drive sprockets
- Impellers, Muller ploughs
- I.D. fans, Mixer blades
- Extruder servers
- Earth moving equipment.
- Power plants and cement industry

CHARACTERISTICS:

Weld deposit is air hardening and Capable of withstanding severe abrasive wear. Smooth arc with low spatter level.

APPLICATION TECHNIQUE:

- Clean the weld surface.
- Use short arc with DC reverse polarity.
- Use buffer layer if the carbon content of the parent metal is high.

- In case of crack sensitive parent metals preheat is recommended in the range 200-300° C.

Alloy Basis : Cr, Mo, V,C

Hardness : 56 HRC minimum.

Welding current: AC/DC+

PACKING SPECIFICATION :

SIZE (mm)	LENGTH (mm)	CURRENT CONDITION AC/DC(-) AMPS	PACKING/BOX (KG)
3.15/3.20	350	70-100	2 × 6 = 12
4.00	350	90-120	2 × 6 = 12
5.00	350	120-140	2 × 6 = 12