

GEMET 305



Low heat input electrode for abrasion proof hard facing.

APPLICATION :

Suitable for applications on mild, medium, high carbon and alloy steel base metals and jobs of thicker cross-sections e.g. Dies, shears, cane cutting knives, oil expellers, crane wheels, cater pillar tracks, rotors, chuck jaws, mill hammers, rock drills etc.

CHARACTERISTICS:

Weld metal resistant to severe abrasion between metal to metal or metal to mineral wearing stresses.

Its uniform deposit is air hardening and cannot be machined.

APPLICATION TECHNIQUE:

Clean the surface thoroughly. Use buffer layer if the job is high carbon steel. Preheat crack sensitive parent metals to 200-300 C.

Alloy Basis : Fe, Cr, Mn, C

Hardness : 55-60 RC.

Welding current: AC/DC(+)

PACKING SPECIFICATION :

SIZE (mm)	CURRENT CONDITIOIN AC/DC(-) AMPS
3.15	70-100
4.00	90-120
5.00	120-140