

GEMET 3200



Basic coated electrode for surfacing carbon or carbon-manganese steel parts undergoing abrasion, heavy impact and erosion. Weld deposit is crack free.

TYPICAL APPLICATIONS :

- Wear resistance surfacing of mild steel or low alloy steel.
- Bucket edges.
- Bucket teeth
- Surfacing earth moving equipments
- Working parts of the cement and brick industry
- Steel Mill
- Scraper blades.
- Conveyor screws
- Dragger teeth.

WELDING RECOMMENDATIONS:

- Clean surface to be welded thoroughly.
- Dry the electrodes at 2500C/2hrs
- Hold electrodes as vertical as possible
- Keep a short arc
- Reduce dilution from the weld metal by weaving

HARDNESS OF THE WELD METAL: 57-62 RC

PACKING SPECIFICATION AND CURRENT CONDITION:

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+)	PACKING SPECIFICATION (KG)
3.15/3.20	350	110-150	2 x 5 = 10
4.00	350	150-210	2 x 5 = 10
5.00	350	180-240	2 x 5 = 10

