

GEMET 3400

IDENTIFICATION

Gemet 3200N

CLASSIFICATION

DIN 8556 E7-UM-250-KP

DESCRIPTION

Basic coated Cr alloyed Mn Steel electrode for high resistance cladding against pressure & shock. The electrode deposits weld metal having fully austenitic structure. The weld metal has increased resistance against friction and corrosion. The weld metal has very high work-hardening and high toughness properties.

TYPICAL APPLICATIONS

- Suitable for cladding on parts subjected to highest pressure and shock load in combination with abrasion.
- Crushers jaws, beaters in mining and cement industries, surfacing rail crossings, roller spindles, camers, wobblers, buckets (pads, lips, teeth), plow shears, scrappers, road rippers, hammers, 13% manganese Hadfield steel, etc.

PROCEDURE

- Dry the electrodes at 250°C / 2 hrs.
- Hold electrode nearly vertical.
- Welding should be done at low temperature.
- Inter-pass temperature should not exceed 150°C.
- Weld short beads and allow for inter-pass cooling or place the work-piece in a cold water bath.

HARDNESS OF THE PURE WELD DEPOSIT:

AFTER WELDING: 250 HB Approx

AFTER WORK HARDENING : Upto 550 HB

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	110 - 150	2	2 x 5 = 10
4	350	140 - 190	2	2 x 5 = 10
5	350	190 - 240	2	2 x 5 = 10