Key Facts

- Extreme crack resistant
- Lends itself admirably to the welding of "difficult to weld" steels.

Description

A rutile coated, austenitic electrode with 25-35% ferrite content. Weld metal is crack resistant and enables the welding of dissimilar steels. Position: flat, horizontal, vertical-up and overhead.

Classification

AWS A5.4: E312-16

Welding Positions

Flat, horizontal, vertical-up, and overhead.

Markings & Identification

End tip Colour: Green
End side Colour: Green
Printing: GEMINI 680

Applications

A great choice for repair and maintenance welding of unknown steels. Excellent maintenance electrode railway iron. Buffer layer prior to hard facing. General repair and maintenance.

Dissimilar Metals Welding Chart:

METAL 1	METAL 2	STICK
Mild Steel	Stainless Steel	Gemini 680
Mild Steel	Austentic Manganese	Gemini 680
Mild Steel	Unknown Steel Type	Gemini 680
Mild Steel	Tool Steels	Gemini 680
Mild Steel	Spring Steel	Gemini 680



Typical All Weld Metal Analysis

C - Carbon	Mn - Manganese	Si - Silicon
0.10%	2.00%	0.90%
Ni - Nickel	**Cr - Chromium**	
10.00%	29.00%	

Typical All Weld Metal Mechanical Properties

Yield Strength:	550 MPa
Tensile Strength:	750 MPa
Elongation (5xD):	23%
Ferrite level:	35%
Impact Strengths ISO-V	70J @ +20°C

Packaging & Ordering Information

Size	Packet	Ctn	Current Range	Part Number
2.6mm	1kg	20kg	50-75	100018
2.6mm	6stk	10pkt	50-75	100018H
3.2mm	1kg	20kg	75-110	100019

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.