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
0.100%	2.00%	0.90%
Ni - Nickel	**Cr - Chromium**	
10.000%	29.000%	

Typical All Weld Metal Mechanical Properties

Yield Strength:	550N/mm^2
Tensile Strength:	750N/mm^2
Elongation (5xD):	23%
Ferrite level:	35%
Impact Strengths ISO-V	70J @ +20^{o}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