

Gemini® C

Shielded Metal Arc Welding (SMAW – Stick)

For nickel & steel alloys, overlay and joining, ideal for Inconel or Hastelloy.

Features

- 121,000 psi Strength
- Outstanding Corrosion Resistance To 2000°F (1093°C)
- Resists Acid, Salts and Chlorine Compounds.
- Contains Tungsten
- Resists Deformation and Wear At Elevated Temperatures
- 47% Elongation
- For Joining and Overlaying
- Work Hardens With Use
- 25 RC As Welded, 40 to 45 RC Work Hardened
- Excellent For Hot Metal Implements
- Machine With Carbide Tools

Characteristics

Gemini C has unsurpassed corrosion resistance to vapors and solutions of sulphuric and hydrochloride acids, as well as chlorine gas and hypochlorite's. Deposits resist oxidizing and non-oxidizing salts, alkalis and organic acids. They have high resistance to pitting in sea water and marine atmosphere. **Gemini C** has been developed to produce unsurpassed durable deposits to resist wear and corrosion even at elevated temperatures and with heavy impact loads. Deposits retain hardness to 1000°F (538°C) and resist oxidation and corrosion up to 2000°F (1093°C).

Gemini C is excellent for joining and overlaying high alloy material, such as Inconel and Hastelloy or stainless steels. In addition, it can be used to provide a corrosion resistant overlay on mild or low alloy steels. It is ideal for hot forging dies, ladles, tong bits, forming rolls, draw punches and any parts exposed to extreme thermal shock, heavy corrosion at elevated temperatures. Contains tungsten, chromium and molybdenum (nickel base).

Technical

Size and Amps AC/DC ±20%

Inches	3/32	1/8	3/16
(mm)	(2.4)	(3.2)	(4.8)
Amps	80	100	160

With DC use reverse polarity. (DCEP)

Application

- Remove all damaged metal.
- Use short arc and stringer beads.
- For optimum results, limit thickness to two passes and preheat heavy or critical parts to 600°F (315°C).
- Fill all craters.
- Not heat treatable.