



GEMINI HF 800 K deposits the weld metal of extremely hard martensile structure which contains dispersed of carbides and borides. It is applicable to such on abrasion that a weld metal of ordinary martensile structure cannot withstand. Multi-layer hard surfacing is not applicable due to loss crack resistibility. Machining is impossible on the weld metal under as-welded condition.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.80	Hardness	750 HV
Mn - Manganese	0.90		
Si – Silicon	1.00		
Cr - Chromium	7.42		
B - Boron	0.30		

TYPICAL WELDING CURRENT

AC or DC +			
Diameter /Length (mm)	3.2/ 350	4.0/ 350	5.0/ 350
Current min/ max (A)	90/ 130	130/ 180	190/ 240

INTERNATIONAL STANDARD**MARKINGS & IDENTIFICATION**

DIN 8555	E 6-UM-60	End Tip Colour	Black
		End Side Colour	-
		Printing	G-HF 800K

WELDING POSITION

Flat and Horizontal

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
3.2mm	5 kg	20 kgs
4.0mm	5 kg	20 kgs
5.0mm	5 kg	20 kgs

Disclaimer: The information provided serves as a general guideline. Actual welding parameters may vary depending on the specific characteristics of the welding equipment. Additional variables to consider include weld length, plate thickness, operator proficiency, etc. Users are encouraged to assess their unique circumstances and seek professional advice as needed. It is important to acknowledge that neither we nor our affiliates can be held liable for any misuse or improper application of products.