



Electrodes for Un-alloyed and Fine Grain Steels |

GEMINI LD 52

GEMINI LD 52 is a basic, easy to use, all positional, low hydrogen electrode. The control of the weld metal and slag enables the operator to be in command of the work at all times. Excellent impact values at sub-zero temperatures makes this electrode suitable for most types of fabrications where high mechanical properties is required. Ideal for shipbuilding, offshore structures.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.07	Yield Strength	470 N/mm ²
Mn - Manganese	0.80	Tensile Strength	560 N/mm ²
Si - Silicon	0.50	Elongation (5xd)	30 %
		Reduction of Area	70 %
		Impact Strength ISO-V @ 0°C	150 Joule
		ISO-V @ -20°C	80 Joule

TYPICAL WELDING CURRENT

AC or DC +/-					
Diameter /Length (mm)	2.6/ 300	2.6/ 350	3.2/ 350	4.0/ 400	5.0/ 400
Current min/ max (A)	60/ 90	60/ 90	90/ 130	120/ 160	160/ 250

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.1	E 7016	End Tip Colour	Grey
ISO 2560	E 513 B 26 H	End Side Colour	Red
DIN 1913	E 51 33 B (R) 10	Printing	G-LD52/E 7016

WELDING POSITION

Flat, Horizontal, Vertical-up and overhead

PACKAGING & ORDERING INFORMATION

Size	Packet	Carton
2.6mm	5 kg	20 kgs
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.