



Electrodes for Un-alloyed and Fine Grain Steels |

GEMINI RB 36

GEMINI RB 36 is a rutile-cellulosic type stick electrode for a wide range of general fabrication application for workshop and site conditions. Excellent operability in all positions including vertical-down. Particularly suited where poor fit-up conditions prevail. Easy slag removal and low spatter loss. Weld bead appearance is smooth with fine ripple formation.

TYPICAL ALL-WELD METAL PROPERTIES

COMPOSITION (%)		MECHANICAL	
C – Carbon	0.07	Yield Strength	430 N/mm ²
Mn - Manganese	0.28	Tensile Strength	490 N/mm ²
Si - Silicon	0.18	Elongation (5xd)	24 %
		Reduction of Area	70 %
		Impact Strength ISO-V @ +20°C	80 Joule
		ISO-V @ 0°C	50 Joule

TYPICAL WELDING CURRENT

AC or DC +/-					
Diameter /Length (mm)	2.0/ 300	2.6/ 300	3.2/ 350	4.0/ 400	5.0/ 400
Current min/ max (A)	50/ 90	50/ 90	90/ 130	110/ 170	150/ 210

INTERNATIONAL STANDARD

MARKINGS & IDENTIFICATION

AWS A5.1	E 7016	End Tip Colour	Blue
		End Side Colour	Red
DIN 1913	E 43 22 R (C) 3	Printing	G-RB36/E 6013

WELDING POSITION

Flat, Horizontal, Vertical-up, Vertical-down 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.