



*ELECTRODES FOR WELDING UN-ALLOYED AND FINE GRAIN STEELS*

# GEMINI RB 36

## Typical Applications And Characteristics

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	0.07	Yield strength	430 N/mm <sup>2</sup>
Mn	0.28	Tensile strength	490 N/mm <sup>2</sup>
Si	0.18	Elongation (5xd)	24 %
		Impact strength ISO-V @+20 °C	80 Joule
		ISO-V @ 0 °C....	50 Joule

### Typical welding current

AC or DC+/-					
Ø/L (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	Color	End	Blue
AWS A5.1 E 6013	Coding	Side	Red
DIN 1913 E 43 22 R(C) 3	Printing	G-RB36/E 6013	
	Welding Positions	Flat, horizontal, vertical-up, vertical-down and overhead	