

GEMINI 680

AWS/SFA5.4 E 312-16

Typical Applications And Characteristics

GEMINI 680 is a rutile austenitic-ferritic coated electrode with a 25-30 % ferrite content. The weld metal is extremely crack resistant and lends itself admirably to the welding of dissimilar and "difficult to weld" steels. It can be used for the welding of high nickel alloys without becoming fully austenitic due to nickel pick-up.

Typical All-Weld Metal Properties			
Composition (%)		Mechanical	
C	0.10	Yield Stress	655 N/mm ²
Mn	0.83	Tensile strength	750 N/mm
Si	1.00	Elongation	24 %
Ni	9.70		
Cr	28.75		

AC or DC±					
∅/L (mm)	2.6X300	3.2X350	4.0X350	5.0X350	-
Current min/max (A)	50-75	75-110	110-150	140-190	-

Typical welding current			
Approval	Color	End	Green
	Coding	Side	Green
	Printing	G-680/E 312-16	
	Welding Positions	Flat, horizontal, vertical-up and overhead	