

GEMINI H600R

DIN 8555/E 2-UM-55

Typical Applications And Characteristics

GEMINI H600R is a rutile coated hardfacing electrode for surfacing worn parts of civil engineering, construction and mining machinery to be used without machining. Deposited metal of approximately 600 HV provides high toughness in spite of high hardness and excellent abrasion resistance to medium impact.

Typical All-Weld Metal Properties			
Composition (%)		Mechanical	
C	0.55	Single Layer	52 HRC
Mn	0.15	Multiple Layer	55 HRC
Si	1.10		
Cr	2.42		

AC or DC±				
∅/L (mm)	3.2X350	4.0X400	5.0X400	-
Current min/max (A)	85-140	100-170	190-210	-

Typical welding current			
Approval	Color	End	Gray
	Coding	Side	Orange
	Printing	G-H600 R	
	Welding Positions	Flat, horizontal	