

# GEMINI® - 316 L - MIG Gas Metal Arc Welding (GMAW)

For welding type 316 L stainless and most other stainless types.

## FEATURES

- 88,000 psi strength
- Superior corrosion resistance
- Crack resistant
- Resists Pitting

## CHARACTERISTICS

**GEMINI 316 L-MIG** is a high alloy molybdenum bearing solid welding wire that is excellent for corrosion resistant deposits. The high chrome and nickel content with molybdenum make this alloy a superior choice for applications in the chemical, food and refinery industries. It is suitable for many stainless types found in repair welding situations, and is especially resistant to cracking.

**GEMINI 316 L-MIG** is ideal for "suitcase" type wire feeders.

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## APPLICATION

The base metal must be cleaned completely. Use stainless steel wire brush and clean oxide on multi-pass welds.

APPROXIMATE SETTINGS: DCEP (reverse polarity)

WIRE DIAMETER	VOLTS	AMPS	GAS FLOW (Ft <sup>3</sup> /Hr)
.030"(0.8mm)	17-26	50-200	15
.035"(0.9mm)	18-27	60-210	15
.045"(1.2mm)	18-30	125-300	20

## SHIELDING GAS OPTIONS:

99% Argon - 1% O<sub>2</sub>

98% Argon - 2% O<sub>2</sub>

90% Helium - 7.5% Argon - 2.5% CO<sub>2</sub> (Trimix)