

GEMINI® - A

Shielded Metal Arc Welding (SMAW-Stick)

G/A For stainless steels 301, 302, 302B, 303, 304, 304L, 305, 308L, 321, 347, and all AISI 200 & Ferrite 400 types.

GEMINI® - B

G/B For stainless steels 316, 316L, 303, 315 and 329

FEATURES G/A

- High strength 85,000 psi
- Superior out-of-position weldability
- Excellent corrosion resistance
- Easy to use - all positions
- Extra low carbon content
- Ultra low spatter

FEATURES G/B

- High strength 80,000 psi
- Excellent out-of-position weldability
- Superior corrosion resistance
- Welds restrained joints
- Contains molybdenum
- Controlled low carbon

CHARACTERISTICS

GEMINI-A produces sound welds with excellent corrosion resistance. Ideal for use in chemical, refining, brewing, dairy and food applications. The extra low carbon in **GEMINI-A** avoids troublesome carbide precipitation and resultant weld decay. When conditions of heat and corrosion are severe **GEMINI-A** provides the ultimate protection. In addition, **GEMINI-A** has excellent impact resistance, producing ideal cushion layers prior to hardfacing.

GEMINI-B has been developed for the maintenance welder who must weld molybdenum bearing stainless and obtain superior corrosion resistance. Cracking, pitting and corrosion are easily avoided.

GEMINI-B is a perfect alloy for chemical, food and refinery applications. Unlike other electrodes used for these stainless steels, **GEMINI-B** will provide extra protection when welding highly restrained joints or crack sensitive alloys.

APPLICATION

Apply with a close arc or drag. Skip weld and avoid overheating the work. Fit parts accurately and tack to maintain alignment. Clean slag between passes. For vertical run up and weave.

TECHNICAL

Size and Amps AC/DC \pm 30%

Inches:	*5/64	3/32	1/8	
(mm):	(2.0)	(2.4)	(3.2)	

***GEMINI-B Only**

Amps:	30	55	85
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With DC use reverse polarity. (DCEP)