

# GEMINI® - E

Shielded Metal Arc Welding  
(SMAW-Stick)

**ARC AC/DC**

All Positions

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For stainless steels, high nickel and chromium and unknown types.

## FEATURES

- Outstanding oxidation sealing and heat resistance
- Welds 25/20 type stainless
- Perfect for unknown analysis
- Spatter free deposits
- High ductility (33% elongation)
- High Strength 85,000 psi
- Good strength to 2000°F (1093°C)
- Welds steel to stainless

## CHARACTERISTICS

**GEMINI-E** is perfect for welding stainless steels of 25/20 type and for use when the exact composition of the stainless is not known. This product contains more chromium and nickel than any type of stainless filler metal. As a result, deposits have unusually high resistance to oxidation and scaling at elevated temperatures. Ideal for 309, 310 and 314 types. As well as Martensitic 400 series.

Typical applications for **GEMINI-E** are tanks, heat exchanges, furnace parts, heat treating, baskets, valves and repair work that calls for stainless to be welded to any type of carbon steel. Deposits are spatter free and provide extraordinary high ductility.

## APPLICATION

**GEMINI-E** is applied with a short arc and stringer beads. Avoid weaving. Use intermittent welding to prevent overheating. Bevel sections over 1/8 thick. Fit parts accurately and tack to maintain alignment.

## TECHNICAL

Size and Amps AC/DC  $\pm$  30%

|         |       |       |
|---------|-------|-------|
| Inches: | 3/32  | 1/8   |
| (mm):   | (2.4) | (3.2) |

|       |    |    |
|-------|----|----|
| Amps: | 60 | 90 |
|-------|----|----|

With DC use reverse polarity. (DCEP)