

SECTION 1

ELECTRODES





GENERAL PURPOSE

Gemini 12

AWS A5.1 E 6012

Rutile type electrode, with easy starting characteristics, can be used for all general welding of structural steel, wrought iron, gates, galvanised steel & thinner sections. Recommended for the less experienced welder as they are easy to use.

Positions: flat, horizontal, vertical up & overhead.

Size	Pkt	Ctn	Part No.
1.6mm	2Kg	30Kg/ctn	1000116
2.0mm	2Kg	30Kg/ctn	100011
2.6mm	2Kg	30Kg/ctn	100012
3.2mm	5Kg	30Kg/ctn	100013
4.0mm	5Kg	30Kg/ctn	100014



Kobe RB 26

AWS A5.1 E 6013

High titania type covered electrode. Used for general fabrication work. A popular choice as arc is stable with little spatter. Downhand welding in the vertical position becomes easy with this rod & results in beautiful bead appearance.

Positions: all positional.

Size	Pkt	Ctn	Part No.
2.6mm	5Kg	20Kg/ctn	100039
3.2mm	5Kg	20Kg/ctn	100040
4.0mm	5Kg	20Kg/ctn	100041
5.0mm	5Kg	20Kg/ctn	100042



Gemini 13

AWS A5.1 E 6013

Rutile type electrode, used for all general fabrication work where the best appearance is required. With mechanical properties this electrode is suitable for structural steel, plate, sheet steels, tubular sections or any general steel application.

Positions: flat, horizontal, vertical up, vertical down & overhead.

Size	Pkt	Ctn	Part No.
2.0mm	2Kg	30Kg/ctn	100029
2.0mm	6stk/pkt	10pkt/ctn	100029H
2.6mm	2Kg	30Kg/ctn	100030
2.6mm	6stk/pkt	10pkt/ctn	100030H
3.2mm	5Kg	30Kg/ctn	100031
3.2mm	6stk/pkt	10pkt/ctn	100031H
4.0mm	5Kg	30Kg/ctn	100032



HYDROGEN CONTROLLED

Gemini LD52U

AWS A5.1 E 7016

Low hydrogen, double coated electrode recommended for unalloyed, micro-alloyed & low alloyed steels of the medium tensile class. Suitable for root passes & all-positional welding. Has extremely stable arc & is not affected by rust/paint on work surface.

Positions: flat, horizontal, vertical up, & overhead.

Size	Pkt	Ctn	Part No.
2.6mm	5Kg	20Kg/ctn	100035
2.6mm	6stk/pkt	10pkt/ctn	100035H
3.2mm	5Kg	20Kg/ctn	100036
3.2mm	6stk/pkt	10pkt/ctn	100036H
4.0mm	5Kg	20Kg/ctn	100037



Kobe LB52-U

AWS A5.1 E 7016

Designed specifically for root runs on one side welding of pipes & general structures. Good arc stability, slag removability & smooth weld beads. This quality electrode has proven to be a popular choice & used in many critical applications.

Positions: vertical upwards.

Size	Pkt	Ctn	Part No.
2.6mm	5Kg	20Kg/ctn	100053
3.2mm	5Kg	20Kg/ctn	100054
4.0mm	5Kg	20Kg/ctn	100055



Kobe LB52-18

AWS A5.1 E 7018

An iron powder low hydrogen covered electrode for all-positional welding. Excellent X-ray soundness & mechanical properties. Smooth arc, neat bead appearance & easy slag removal. For use with heavy structures, rolling stock & heavy machinery.

Positions: all positional.

Size	Pkt	Ctn	Part No.
2.6mm	5Kg	20Kg/ctn	100061
3.2mm	5Kg	20Kg/ctn	100062
4.0mm	5Kg	20Kg/ctn	100063



IRON POWDER

Gemini 7024

AWS A5.1 E 7024

Easy striking, rutile type, full iron powder electrode for structural steel welding in the downhand & horizontal positions. Suitable in production or general fabrication where highest deposition rates are required.

Positions: downhand, flat & horizontal.

Size	Pkt	Ctn	Part No.
3.2mm	5Kg	20Kg/ctn	100045
4.0mm	5Kg	20Kg/ctn	100046
5.0mm	5Kg	20Kg/ctn	100047





DISSIMILAR METALS

Gemini 680 Dissimilar

AWS A5.4 E 312-16
Rutile austenitic-ferritic coated electrode with a 25-35% ferrite content. Weld metal is very crack resistant & enables the welding of dissimilar steels. A great choice for repair & maintenance welding of unknown steels.
Position: flat, horizontal, vertical up & overhead.

Size	Pkt	Ctn	Part No.
2.6mm	1Kg	20Kg/ctn	100018
2.6mm	6stk/pkt	10pkt/ctn	100018H
3.2mm	1Kg	20Kg/ctn	100019



CAST IRON

Gemini Nickel ARC 98

AWS A5.15 E Ni-CI
Pure nickel electrode which is universally used for welding all types of cast iron. Designed to operate at low currents which minimise heat input & thus facilitates the cold welding of cast iron. Weld induced stresses can be reduced by hammer peening.
Positions: flat, horizontal & vertical up.

Size	Pkt	Ctn	Part No.
2.6mm	1Kg	20Kg/ctn	100092
3.2mm	1Kg	20Kg/ctn	100093
3.2mm	6stk/pkt	10pkt/ctn	100093H
4.0mm	1Kg	20Kg/ctn	100094



ALUMINIUM

Aluminium DC Electrode

AWS A5 E 4043
Coated electrode providing high speed deposition of dense, machinable welds. Use for fabrication & repair of cast & wrought aluminium, foundry defects, machining errors & salvage work. Ideal for repairs & maintenance. (DC reverse polarity only).
Position: all positional.

Size	Pkt	Ctn	Part No.
3.2mm	0.454Kg	2.27Kg/ctn	100103



STAINLESS STEEL

Gemini 308L-16

AWS A5.4 E 308L-16
Rutile type electrode containing low amounts of carbon, depositing weld metal suitable for welding 301, 302, 304, 308 & 308L stainless steels, leaving a very smooth weld with a clean edge.
Positions: flat, horizontal, vertical up & overhead.

Size	Pkt	Ctn	Part No.
2.6mm	1Kg	20Kg/ctn	100006
3.2mm	1Kg	20Kg/ctn	100007



STAINLESS STEEL

Gemini 309Mo-16

AWS A5.4 E 309Mo-16
Rutile type electrode, recommended for welding 309 & 309L stainless steels. Also suitable for welding dissimilar metals; mild steel to stainless steel. Low spatter & smooth running.
Positions: flat, horizontal, vertical up & overhead.

Size	Pkt	Ctn	Part No.
2.6mm	1Kg	20Kg/ctn	100009
3.2mm	1Kg	20Kg/ctn	100010



Gemini 347

AWS A5.9 ER347
A rutile coated electrode for welding corrosion resistant, stabilised CrNi steels. Also suitable for applications of heat resistant steel up to 800°C. Smooth weld, well directed arc with clean edge.
Positions: flat, horizontal & vertical up.

Size	Pkt	Ctn	Part No.
2.6mm	1Kg	20Kg/ctn	100026
3.2mm	1Kg	20Kg/ctn	100027



Gemini 316L-16

AWS A5.4 E 316L-16
Stainless steel electrode for welding common 300 series stainless steel, including 301, 302, 304, 304L, 316 & 316L leaving a smooth weld deposit of excellent appearance.
Positions: flat, horizontal, vertical up & overhead.

Size	Pkt	Ctn	Part No.
2.0mm	1Kg	20g/ctn	100022
2.0mm	6stk/pkt	10pkt/ctn	100022H
2.6mm	1Kg	20Kg/ctn	100023
2.6mm	5Kg	20Kg/ctn	1000235
2.6mm	6stk/pkt	10pkt/ctn	100023H
3.2mm	1Kg	20Kg/ctn	100024
3.2mm	5Kg	20Kg/ctn	1000245
3.2mm	6stk/pkt	10pkt/ctn	100024H
4.0mm	1Kg	20Kg/ctn	100025





HARD FACING SOLID

Gemini H 350R

DIN 8555 E 1-UM-350

General purpose rutile coated hardfacing electrode depositing tough chromium manganese alloy weld metal. Recommended where maximum hardness & reasonable machinability is required. Suitable as buffer layer on badly worn components. 32-35 HRC. Positions: flat, horizontal & vertical up.

Size	Pkt	Ctn	Part No.
3.2mm	5Kg	20Kg/ctn	100184
4.0mm	5Kg	20Kg/ctn	100185

Gemini H 600R

DIN 8555 E 6-UM-55

Rutile coated hardfacing electrode for surfacing worn parts of civil engineering, construction & mining equipment, without machining. Deposited metal of approx. 55 HRC provides high toughness & excellent abrasion resistance to medium impact. Positions: flat, horizontal & vertical up.

Size	Pkt	Ctn	Part No.
3.2mm	5Kg	20Kg/ctn	100186
3.2mm	6stk/pkt	10pkt/ctn	100186H
4.0mm	5Kg	20Kg/ctn	100187



GOUGING CARBONS

BOSS DC Gouging Carbon

Copper coated carbon electrode designed for gouging & cutting with DC current. Provides high efficiency at low consumption. For use in removal of residual casting material & weld defects. Cuts bronze, stainless steel & copper.

Size	Pkt	Ctn	Part No.
4.8mm	50pc/pkt	5pkt/ctn	100195
6.5mm	50pc/pkt	5pkt/ctn	100196
8.0mm	50pc/pkt	5pkt/ctn	100197
9.5mm	50pc/pkt	5pkt/ctn	100198
12.7mm	25pc/pkt	5pkt/ctn	100199



GEMINI HANDY PACKS

General Purpose

Gemini 13

Part No. 100029H
Part No. 100030H
Part No. 100031H

Gemini 6 stick handy packs are ideal for small repairs & a great introduction to the Gemini brand electrodes.

Low Hydrogen

Gemini LD52U

Part No. 100035H
Part No. 100036H

Stainless 316L

Gemini 316L

Part No. 100022H
Part No. 100023H
Part No. 100024H

Dissimilar Metals

Gemini 680

Part No. 100018H

Nickel Arc 98

Gemini Nickel Arc 98

Part No. 100093H

Hardfacing

Gemini H 600 R

Part No. 100186H

