



GEMINI L1

(Low Hydrogen for Mild steel and 490 MPa High tensile Strength Steel)

Description & Characteristics

GEMINI L1 is a low hydrogen type electrode for all positions welding with a relatively quiet arc and low spatter and delivers a minimum 70,000 psi (483 MPa) tensile strength. Suitable for high tensile strength steels for ships, structures and bridges. For best results, hold a close arc and use as much heat as the nature of the work permits. Avoid wide weaving and maintain a molten pool at all times during welding. Avoid a cold start by striking the arc slightly ahead of the intended start of the weld, wait for the arc to stabilize, and then bring it back to the desired starting point before progressing forward

| | |
|----------------|-------------------|
| Coating Type | Basic |
| Classification | AWS A 5.1 : E7016 |

Typical Chemical Composition of All-weld Metal (%)

| C | Mn | Si | P | S |
|------|------|------|-------|-------|
| 0.07 | 1.07 | 0.45 | 0.016 | 0.007 |

Typical Mechanical Properties of All-weld Metal

| | |
|------------------------|-----------|
| Condition | As Welded |
| Tensile Strength | 530 MPa |
| Yield Strength | 420 MPa |
| Elongation (%) | 30 |
| Impact Value at -30 °C | 100 J |

Recommended Operating Parameters

| Diameter (mm) | Type of Power | Current (A) |
|---------------|---------------|-------------|
| 2.6 | DCEP or AC | 40 - 80 |
| 3.2 | DCEP or AC | 90 - 110 |
| 4.0 | DCEP or AC | 130 - 160 |
| 5.0 | DCEP or AC | 170 - 210 |

Welding Positions



Available Diameters and Packages

| Diameter (mm) | Electrode Length (mm) | Pack Mass (kg) |
|---------------|-----------------------|----------------|
| 2.6 | 350 | 5 |
| 3.2 | 350 | 5 |
| 4.0 | 400 | 5 |
| 5.0 | 400 | 5 |

Applications

- Ship Building
- Repair Sheet metal
- Build – up of over machined
- Offshore
- General light fabrication