

Gemini® BBB

Shielded Metal Arc Welding (SMAW – Stick)

For most grades of stainless steel including molybdenum bearing types such as 316, 318, 303, 315 and 329.

Features

- Down Hand Welding
- 80,000 psi Strength
- Excellent Ductility
- Ideal For Poor Fit Up
- Ultra Low Carbon
- Easy To Use, All Positions
- Easy Slag Removal
- Minimum Distortion
- Low Amperage
- High Elongation

Characteristics

Gemini BBB is a uniquely designed stainless steel electrode for vertical down welding. It also can be used for all positions. A very controlled puddle for poor fit up joints or filling holes. Especially suited for thin to medium gauge, molybdenum bearing stainless steels. Makes pipe welding much easier in all situations.

Gemini BBB is a perfect alloy for chemical, food and refinery applications where vertical stainless welds are required.

Technical

Size and Amps AC/DC ±30%

Inches	3/32	1/8
(mm)	(2.4)	(3.2)
Amps	80	100

With DC use reverse polarity. (DCEP)

Application

- For vertical set amperage at high end of range.
- Electrode may show red color which is normal.
- Clean base metal.
- Run vertical down, close arc with sharp upward angle.