

Gemini® A TIG

Gas Tungsten Arc Welding (GTAW)

For stainless steels 301, 302, 302B, 303, 304, 304L, 305, 308L, 321, and AISI 200 & Ferritic 400 types.

Features

- High Strength 85,000 psi
- Excellent Corrosion Resistance
- Ideal For Most Stainless
- Stabilized Weld Deposits
- Good Puddle Fluidity
- Ultra Low Carbon Content

Characteristics

Gemini A TIG produces sound welds with excellent corrosion resistance, ideal for use in chemical, refining, brewing, dairy & food applications. The extra low carbon and stabilizing compounds in **Gemini A TIG** avoid troublesome carbide precipitation and resultant weld decay. When conditions of heat and corrosion are severe, **Gemini A TIG** provides the ultimate protection.

Technical

Inches	1/16	3/32	1/8
(mm)	(1.6)	(2.4)	(3.2)

(DCEN)

Application

- DC straight polarity with argon or argon helium shield gas.
- Clean base metal completely.
- Use stainless brush and clean oxide film between multi-pass welds.

Identification

- Marked by **Pink Tip**

Gemini® B TIG

Gas Tungsten Arc Welding (GTAW)

For stainless steels 316, 316L, 318, 303, 315 and 329.

Features

- High Strength 83,000 psi
- Resists Pitting
- Improve High Temp Strength
- Excellent Crack Resistance
- Contains Molybdenum
- Ultra-Low Carbon Content

Characteristics

Gemini B TIG is excellent for fabrication and repair of tanks, pumps, fixtures, etc., where corrosion is often encountered due to brine, organic acids, sulfurous and sulfuric acids. Extra protection and outstanding results may be expected due to the unique formulation of this alloy.

Technical

Inches	1/16	3/32	1/8
(mm)	(1.6)	(2.4)	(3.2)

(DCEN)

Application

- DC straight polarity with argon or argon helium shield gas.
- Clean base metal completely.
- Use stainless brush and clean oxide film between multi-pass welds.

Identification

- Marked by **Yellow Tip**

Gemini® C TIG

Gas Tungsten Arc Welding (GTAW)

For stainless joining and overlay in severe corrosive conditions.

Features

- 86,000 psi Strength
- Superior Elongation 39%
- High Corrosion Resistance
- Suitable For Carpenter Type Stainless
- Excellent For High Temperature Exposure

Characteristics

Gemini C TIG provides excellent joining and overlay results on stainless exposed to severe corrosive conditions. It is ideal for applications in the refinery, chemical, plastics and food processing industries on such equipment as mixing tanks, piping, pickling equipment and pumps.

Technical

Inches	3/32
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(mm)	(2.4)
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(DCEN)

Application

- Use DC straight polarity with argon and/or helium.
- Clean metal with stainless brush.

Identification

- Marked by **Unpainted Tip**

Gemini® E TIG

Gas Tungsten Arc Welding (GTAW)

For stainless steels with high nickel and chromium.

Features

- Outstanding Oxidation Sealing
- Heat Resistance
- Perfect For Unknown Analysis
- High Ductility – 33% Elongation
- High Strength 85,000 psi
- Good Strength to 2000°F (1093°C)

Characteristics

Gemini E TIG is perfect for welding stainless of the 25/20 type and for use when the exact composition of the stainless is unknown. This product contains more chromium and nickel than any type of stainless filler. Ideal for 309, 310, and 314 types as well as Martensitic 400 series.

Technical

Inches	1/16	3/32
(mm)	(1.6)	(2.4)

(DCEN)

Application

- Use DC straight polarity with argon and/or helium.
- Clean metal with stainless brush.

Identification

- Marked by **White Tip**

Gemini[®] M TIG

Gas Tungsten Arc Welding (GTAW)

For magnesium – cast, sheet, tubing. Use for joining and build up.

Features

- Strength 37,000 psi
- Excellent Color Match
- Bead Forming and Thin Flow
- Fast and Easy Use

Characteristics

Gemini M TIG has been specifically developed for the maintenance welder who must weld a variety of magnesium components such as dock plates, ladders, structural members and tool housings.

Technical

Inches	1/8
(mm)	(3.2)

(AC with Hi-Freq)

Application

- Clean and preheat.
- Use AC with high frequency and argon or helium gas.
- Paint **Neptune Flux** on the backside of the weld to aid penetration.
- Weld procedure identical to aluminum.

Identification

- Marked by **Red Tip**