

# Gemini® B MIG

## Gas Metal Arc Welding (GMAW – Wire)

For welding type 316L stainless and most other stainless types.

### Features

- 88,000psi Strength
- Superior Corrosion Resistance
- Crack Resistant
- Resists Pitting

### Characteristics

**Gemini B MIG** is a high alloy molybdenum bearing solid welding wire that is excellent for corrosion resistant deposits. The high chrome and nickel content with molybdenum make this alloy a superior choice for applications in the chemical, food and refinery industries. It is suitable for many stainless types found in repair welding situations and is especially resistant to cracking. **Gemini B MIG** is ideal for “suitcase” type wire feeders.

### Technical

Inches	.030	.035	.045
(mm)	(0.8)	(0.9)	(1.2)
Volts	17-26	18-27	18-30
Amps	50-200	60-210	125-300
Gas Flow (ft <sup>3</sup> /hr)	15	15	20

Use Reverse Polarity (DCEP)

### Spool Size

- 2# Available in .035
- 10 # Available in .030 and .035
- 25 # Available in .045
- 33 # Available in .035

### Application

- The base metal must be cleaned completely.
- Use stainless steel wire brush and clean oxide on multi-pass welds.
- We recommend **Gemini Anti-Spatter spray** for lasting protection of your contact tip and MIG nozzle (see chemical aids in Abrasives & Metal Working products section).

### Shielding Gas Options

- 99% Argon – 1% O<sub>2</sub>
- 98% Argon – 2% O<sub>2</sub>
- 90% Helium – 7.5% Argon – 2.5% CO<sub>2</sub> (Trimix)