GeKa®

LINK 6010

Standards :

TS EN ISO 2560-A	:	E 38 3 C 21
EN ISO 2560-A	:	E 38 3 C 21
AWS A5.1	:	E 6010

Chemical Composition of Weld Metal- % (Typical) :

C	Si	Mn
0.12	0.2	0.6

Mechanical Properties :

Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Impact Strength (ISO-V/-30°C)	Elongation (L_o=5d_o)(%)
min. 380	470-540	min. 47 J	min. 22

Typical Base Material Grades :

* S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH,P235T1-P355T1, P235T2-P355T2, L210-L360NB, L290MB-L360MB,S235JRS1-S235J2S2, P235G1TH, P255G1TH, X42-X52, for root pass L555NB, L555MB

Features and Applications :

* Suitability for use in welding large-diameter pipelines for crude oil, natural gas, and water as well as in root-pass welding or surfacing of ships, tanks, boilers, and steel constructions
* Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
* Deep penetration obtained in welding at all positions
* Most suitability for welding at vertical down position

Welding Positions :

Current Type :

D.C. (+)
D.C. (-) for root pass

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 350	3/32 x 14”	40 - 80	1620
3.20 x 350	1/8 x 14”	65 - 125	2650
4.00 x 350	5/32 x 14”	90 - 175	4010
5.00 x 350	3/16 x 14”	140 - 220	6080

Approvals :

TSE, GL, TÜV, DB, CE, NACE