

## Low Alloyed Basic Electrode

# GeKa®

# TEMPO B 90

**Standards :** \_\_\_\_\_

**Chemical Composition of Weld Metal-  
% (Typical) :**

TS EN 757	:	E 69 5 Mn 2 NiCrMo B
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AWS A5.5	:	E 12018 - G

C	Si	Cr	Mo	Ni	Mn
0.06	0.4	0.9	0.5	2.5	1.6

**Mechanical Properties :** \_\_\_\_\_

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-50°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> )(%)	Heat Treatment
min. 740	830-950	min. 28 J	min. 16	650 °C / 2h / 300 °C (air)

**Typical Base Material Grades :** \_\_\_\_\_

\* HY 100, S690QL, S690QU, N-AXTRA 70

**Features and Applications :** \_\_\_\_\_

- \* Suitability for use in welding fine-grained steels, cementation steels, tempered steels, cast steels etc.
- \* Suitability for use in welding metals for applications requiring a minimum tensile strength value of 830 N/mm<sup>2</sup>
- \* Requirement of re-drying for minimum 2 hours at the temperatures between 350 °C and 400 °C

**Welding Positions :** \_\_\_\_\_



**Current Type :** \_\_\_\_\_

D.C.(+)

**Operating Data :** \_\_\_\_\_

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
3.20 x 350	1/8 x 14"	90 - 140	3650
4.00 x 450	5/32 x 18"	130 - 190	6740
5.00 x 450	3/16 x 18"	170 - 240	10525

**Approvals :** \_\_\_\_\_