

**Standards**

|                  |               |
|------------------|---------------|
| TS EN ISO 2560-A | : E 42 3 C 21 |
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| AWS A5.5         | : E 7010-P1   |

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

| C    | Si  | Mn  |
|------|-----|-----|
| 0.15 | 0.2 | 1.0 |

**Mechanical Properties**

| Yield Strength<br>(N/mm <sup>2</sup> ) | Tensile Strength<br>(N/mm <sup>2</sup> ) | Impact Strength<br>(ISO-V/-30°C) | Elongation<br>(L <sub>0</sub> =5d <sub>0</sub> ) (%) |
|--|--|----------------------------------|--|
| min. 420                               | 500-640                                  | min. 47 J                        | min. 22  |

**Typical Base Material Grades**

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JRS1-S235J4S, P235G1TH, P255G1TH, X42-X60

**Features and Applications**

- Suitability for use in welding large-diameter high-strength steel pipelines and especially use in hot, filler and cap passes.
- Deep penetration, especially (obtained) at vertical-down position.
- For root-pass welding, GeKa electrode LINK 6010 is recommended.

**Welding Positions**

**Current Type**

D.C.(+)

**Operating Data**

| Product Code | Diameter x Length<br>(mm) / (inch) |            | Welding Current<br>(A) | Weight<br>g / 100 pcs |
|--------------|------------------------------------|------------|------------------------|-----------------------|
| 3010100253   | 2.50 x 350                         | 3/32 x 14" | 40 - 80                | 1700                  |
| 3010100256   | 3.20 x 350                         | 1/8 x 14"  | 65 - 125               | 2735                  |
| 3010100259   | 4.00 x 350                         | 5/32 x 14" | 90 - 175               | 3990                  |
| 3010100262   | 5.00 x 350                         | 3/16 x 14" | 140 - 220              | 6135                  |

**Approvals:** TSE, CE, GOST-R, SEPRO