



# NIPPON KAIJI KYOKAI

Approval No. NKY-3338  
Certificate No. TA25173E

## *Certificate* OF *TYPE APPROVAL*

Article: Welding Consumables for Stainless Steels  
Brand: GeKa ELOX UP 2209 / GeKa ELIFLUX BSS-D  
[Wire / Flux]  
Applicant: Gedik Kaynak Sanayi ve Ticaret A.S.  
Kargalıhanbaba Mahallesi , Organize Sanayi 1-8-10 Sokak Dış Kapı  
No : 27-3-2 Hendek / Sakarya , TÜRKİYE  
Manufacturer: Gedik Kaynak Sanayi ve Ticaret A.S.  
Kargalıhanbaba Mahallesi , Organize Sanayi 1-8-10 Sokak Dış Kapı  
No : 27-3-2 Hendek / Sakarya , TÜRKİYE  
Grade: Manufacturer's Specification  
Welding Process: Submerged Arc Welding  
Technique: Multi-Run  
Welding Positions and Max. Diameter of Wire: See Table 1  
Current: AC  
Shielding Gas: Not Applicable  
Applicable Grade of Parent Material: "KSUS329J3L", "S31803 and S32205 specified in  
ASTM A240" and Equivalent Duplex Stainless  
Steels  
Remarks: 1) Chemical composition and mechanical properties are to comply with  
the requirements specified in Table 2 and Table 3.  
2) For annual inspection, mechanical properties are to comply with the  
requirements specified in Table 4.

THIS IS TO CERTIFY that the above mentioned welding consumable has been approved by the NIPPON KAIJI KYOKAI in accordance with the requirements of the Society's Rules.

This Certificate will remain in force until 4 December 2025.  
Issued at Tokyo on 5 December 2024.



M. IRISAWA

General Manager

Material and Equipment Department

Note : The validity of this certificate may be renewed by endorsement on the attached sheet upon completion of the annual inspections.

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Table 1 Welding Positions and Max. Diameter of Wire

Butt Weld		Fillet Weld	
Flat:	4.0mm	Flat:	Not Applicable
Horizontal:	Not Applicable	Horizontal Vertical:	Not Applicable
Overhead:	Not Applicable	Horizontal:	Not Applicable
Vertical Upward:	Not Applicable	Horizontal Overhead:	Not Applicable
Vertical Downward:	Not Applicable	Overhead:	Not Applicable
		Vertical Upward:	Not Applicable
		Vertical Downward:	Not Applicable

Table 2 Chemical Composition of Deposited Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N
0.040	1.00	0.500	0.030	0.020	21.500	7.500	2.500	0.30	0.100
max.	max.	~ 2.000	max.	max.	~ 23.500	~ 10.500	~ 3.500	max.	~ 0.200

Table 3 Mechanical Properties

Deposited Metal Test			Butt Weld Test
Tensile Test			Tensile test
Tensile strength (N/mm <sup>2</sup> )	Yield point (N/mm <sup>2</sup> )	Elongation (%)	Tensile strength (N/mm <sup>2</sup> )
690 min.	450 min.	20 min.	640 min.

Table 4 Test Requirements for Annual Inspection

Kind of test	Test assembly <sup>1), 2), 3), 4)</sup>			Kind and number of test specimens to be taken from test assembly
	Number	Plate thickness (mm)	Welding position	Tensile test specimen <sup>5),6)</sup> : 1
Deposited metal test	1	20	Flat	

Notes:

- 1) The approved specific grades of applicable parent material are to be applied. Other parent material with appropriate buttering may be applied subject to the approval of the Society.
- 2) Shape and dimension of test assembly are to be in accordance with Fig. M6.7, Chapter 6, Part M of the NK Rules.
- 3) Test assembly is to be welded in accordance with 6.7.5, Chapter 6, Part M of the NK Rules.
- 4) The diameter of the wire is to be within the range specified by Gedik Kaynak Sanayi ve Ticaret A.S. but not exceeding the maximum diameter approved.
- 5) Kind of test specimen is to be U1A specified in Table M3.1, Chapter 3, Part M of the NK Rules.
- 6) Mechanical properties are to comply with the requirements specified in Table 2.