

Standards

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| 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 (N/mm ²) | Tensile Strength (N/mm ²) | Impact Strength (ISO-V/-30°C) | Elongation (L ₀ =5d ₀) (%) |
|--|--|----------------------------------|--|
| 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 (mm) / (inch) | | Welding Current (A) | Weight 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, SEPRO