

Standards

TS EN ISO 2560-A	: E Z 46 3 Mo C 21
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AWS A5.5	: E 8010 - G

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

C	Si	Mn	Ni	Mo
0.14	0.2	0.9	0.2	0.15

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation (L ₀ =5d ₀) (%)
min. 460	550 - 650	min. 47 J	min. 20

Typical Base Material Grades

- L290NB-L415NB, L290MB-L415MB, -L485MB, S235JRS1-S235J4S, X42-X70

Features and Applications

- Suitability for use in all-positions of welding high-strength low alloyed steel pipelines joining
- Suitability for use in welding all positions, particularly vertical down position
- Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
- For root-pass welding, GeKa 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
3010100273	2.50 x 350	3/32 x 14"	40 - 80	1635
3010100276	3.20 x 350	1/8 x 14"	65 - 125	2640
3010100279	4.00 x 350	5/32 x 14"	90 - 175	4000
3010100282	5.00 x 350	3/16 x 14"	140 - 220	6340

Approvals: TSE, CE, SEPRO