

**Standards**

TS EN ISO 2560-A	: E 46 3 1 Ni C 21
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AWS A5.5	: E 8010-P1

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

C	Si	Mn	Ni
0.14	0.2	0.9	0.6

**Mechanical Properties**

Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-30°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
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
- Can be used in sour gas applications
- 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
3010100305	2.50 x 350	3/32 x 14"	40 - 80	1635
3010100308	3.20 x 350	1/8 x 14"	65 - 125	2640
3010100311	4.00 x 350	5/32 x 14"	90 - 175	4000
3010100314	5.00 x 350	3/16 x 14"	140 - 220	6340

**Approvals:** BV, DNV-GL, CE, TSE, SEPRO, NACE