

Низколегированные электроды LINK

Технические характеристики

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Cellulosic Electrode

LINK 6010

Standards

TS EN ISO 2560-A	: E 38 3 C 21
EN ISO 2560-A	: E 38 3 C 21
AWS A5.1	: E 6010

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn
0.12	0.2	0.6

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation (L ₀ =5d ₀) (%)
min.380	470-540	min.47 J	min.22

Typical Base Material Grades

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P235T1-P355T1, P235T2-P355T2, L210-L360NB, L290MB-L360MB, S235JRS1-S235J2S2, P235G1TH, P255G1TH, X42-X56, for root pass X60-X80.

Features and Applications

- Suitability for use in welding large-diameter pipelines for crude oil, natural gas, and water as well as in root-pass welding or surfacing of ships, tanks, boilers, and steel constructions
- Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)
- Deep penetration obtained in welding at all positions
- Most suitability for welding at vertical down position

Welding Positions



Current Type

D.C.(+) / D.C. (-) for root pass

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100186	2.50 x 350	3/32 x 14"	40 - 80	1670
3010100189	3.20 x 350	1/8 x 14"	65 - 125	2720
3010100192	4.00 x 350	5/32 x 14"	90 - 175	4110
3010100195	5.00 x 350	3/16 x 14"	140-220	6210

Approvals: TSE, DNV-GL, TÜV, DB, CE, NACE, SEPRO, CWB

Cellulosic Electrode LINK 7010 - G

Standards

TS EN ISO 2560-A	: E 42 2 Mo C 21
EN ISO 2560-A	: E 42 2 Mo C 21
AWS A5.5	: E 7010 - G

Chemical Composition of Weld Metal % (Typical)

C	Si	Mn	Mo
0.10	0.15	0.4	0.3

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-20°C)	Elongation (L ₀ =5d ₀) (%)
min. 420	510 - 590	min. 47 J	min. 22

Typical Base Material Grades

- S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P355T2, L210-L415NB, L290MB-L415MB, S235JRS1-S235J4S2, P235G1TH, P255G1TH, X42-X65 for root pass applications is using up to X70(L485MB)

Features and Applications

- It is used for root and filler passes in all welding positions of high strength steels, assembly pipelines, closed vessels and boilers, steel constructions
- Deep penetration, especially (obtained) at vertical-down position

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010100234	2.50 x 350	3/32 x 14"	40 - 80	1700
3010100237	3.20 x 350	1/8 x 14"	65 - 125	2735
3010100240	4.00 x 350	5/32 x 14"	90 - 175	3990
3010100243	5.00 x 350	3/16 x 14"	140 - 220	6135

Approvals: TSE, CE, SEPRO

Cellulosic Electrode

LINK 7010 - P1

Standards

TS EN ISO 2560-A	: E 42 3 C 21
EN ISO 2560-A	: E 42 3 C 21
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

Cellulosic Electrode LINK 8010 - G

Standards

TS EN ISO 2560-A	: E Z 46 3 Mo C 21
EN ISO 2560-A	: E Z 46 3 Mo C 21
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

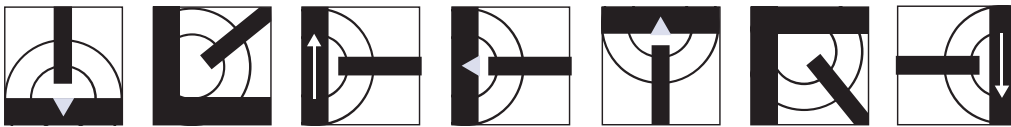
Typical Base Material Grades

- 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

Cellulosic Electrode LINK 8010 - P1

Standards

TS EN ISO 2560-A	: E 46 3 1 Ni C 21
EN ISO 2560-A	: E 46 3 1 Ni C 21
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 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
- 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

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