

Cellulosic Electrode

GeKa®

LINK 7010 - P1

Standards :

TS EN ISO 2560-A	: E 42 3 C 25
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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
- * Suitability for particular use in root-pass or surfacing (For root-pass welding, GeKa electrode LINK 6010 is recommended.)
- * Deep penetration, especially (obtained) at vertical-down position

Welding Positions :



Current Type :

D.C. (+)

Operating Data :

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

Approvals :

TSE