

Cellulosic Electrode

GeKa®

LINK 8010 - P1

Standards :

TS EN ISO 2560-A	: E 46 3 1 Ni C 25
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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 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 root-pass welding or in surfacing of high-strength low-alloyed steel pipelines (For root-pass welding, GeKa electrode LINK 6010 is recommended.)
- * Suitability for use in welding all positions, particularly vertical down position
- * Usability in sour gas - involving applications (acc. HIC Test NACE TM-0284)

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	2640
4.00 x 350	5/32 x 14"	90 - 175	4000
5.00 x 350	3/16 x 14"	140 - 220	6340

Approvals :