

**GeKa®**

**TEMPO Ni Cu**

**Standards :** \_\_\_\_\_

TS EN ISO 2560-A	: E 42 3 Z (NiCrCu) B 42
EN ISO 2560-A	: E 42 3 Z (NiCrCu) B 42
AWS A5.5	: E 7018-G / 7018-W1(mod.)

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

C	Si	Cr	Ni	Cu	Mn
0.06	0.5	0.3	0.4	0.4	1.0

**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. 420	510-630	60 J	min. 25

**Typical Base Material Grades :** \_\_\_\_\_

\* S235JR, S235JRW, S325J2W, S355J2G1W, S355JRW, S355J2G 3 Cu, COR-TEN A

**Features and Applications :** \_\_\_\_\_

- \* Content of Ni-Cu-Cr alloy
- \* Suitability for use in welding structural steels exposed to weathering, such as COR-TEN.
- \* High mechanical properties with excellent crack resistance
- \* Convenience of welding at all positions except for vertical down position
- \* Weld deposits with very low contents of hydrogen
- \* Requirement of re-drying for minimum 2 hours at the temperatures between 350 °C and 400 °C

**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"	80 - 110	2340
3.20 x 350	1/8 x 14"	130 - 150	3480
4.00 x 450	5/32 x 18"	150 - 190	6685
5.00 x 450	3/16 x 18"	200 - 250	10115

**Approvals :** \_\_\_\_\_

TSE,