GeKa

LASER B 50

Standards :

TS EN ISO 2560-A	:	E 42 5 B 42 H5
EN ISO 2560-A	:	E 42 5 B 42 H5
AWS A5.1	:	E 7018 - 1 H4

Chemical Composition of Weld Metal- % (Typical) :

C	Si	Mn
0.08	0.5	1.1

Mechanical Properties :

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-50°C)	Elongation ($L_o=5d_o$)(%)
min. 420	510-630	min. 47 J	min. 24

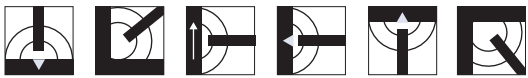
Typical Base Material Grades :

* S235JR-E295, E335, S235J2G3-S355J2G3, C22, C35, P235T1-P355T1, P235T2,P355T2, L210-L360, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S355N, P255NH-P355NH, S255NL-S355NL,GE200-GE300
* API 5L : A, B, X42, X46, X52, X56, X60

Features and Applications :

* Suitability for use in out-of-position welding except for welding at vertical down position * Excellent strength and toughness *Suitability for use in the fields of steel constructions, boiler, container, machine manifacturing and vertical construction as well as for use in welding low-purity and high-carbon steels *Suitability for the formation of welding buffer layers when building up high-carbon steels * Weld deposits with very low hydrogen content * Weld metal recovery of about 110% *Requirement of re-drying for minimum 2 hours at the temperatures between 300°C and 350°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 - 100	2220
3.20 x 350	1/8 x 14”	100 - 140	3645
4.00 x 450	5/32 x 18”	130 - 190	6765
5.00 x 450	3/16 x 18”	190 - 240	10220

Approvals :

TSE, ABS, CE, GOST-R, SEPRO, HAKC (3.20 mm)