



Gedik Welding



GeKa®



GeKaTec®



GeKaMac®



GeKaRobotics®



Gedik Welding

GEDIK WELDING is one of the largest manufacturers in Europe and exports welding consumables to more than 80 countries around the world under its internationally - registered trademarks GeKa® and GeKaTec®. The company also produces welding machines under the brand name of GeKaMac® and generates robotic solutions and welding automation equipment (GeKaRobot®) for various industries, both in Turkey and overseas.

GEDIK WELDING was established in 1963 and is today a global industry leader in the field of welding consumables and equipment. The Company manufactures about 90,000 tons / year of superior quality coated welding electrodes, brazing rods, special repair and maintenance products, as well as gas-shielded arc, submerged arc, flux-cored welding wires, rectifiers, gas shielded arc and submerged arc welding generators.

Joining. For Life...



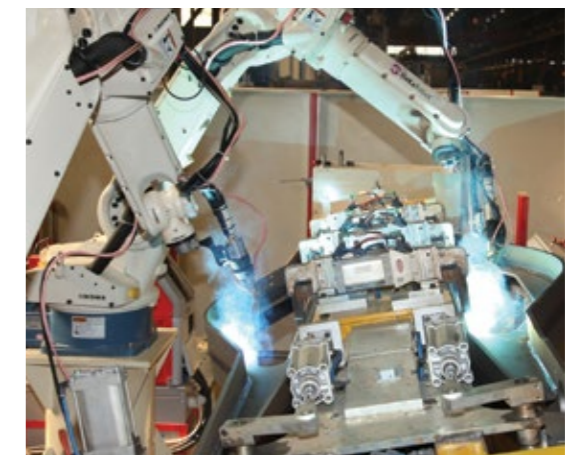
 **GeKa®**



 **GeKaTec®**



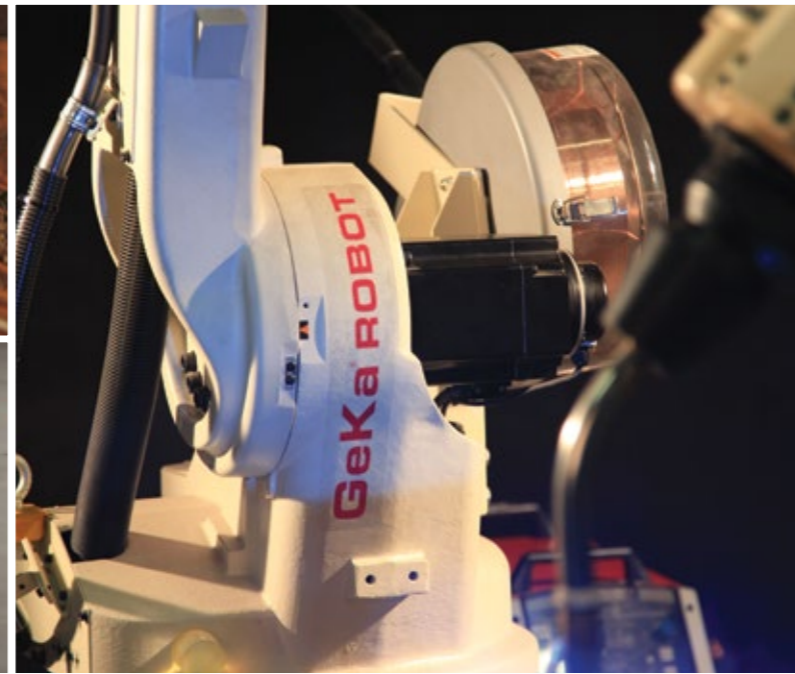
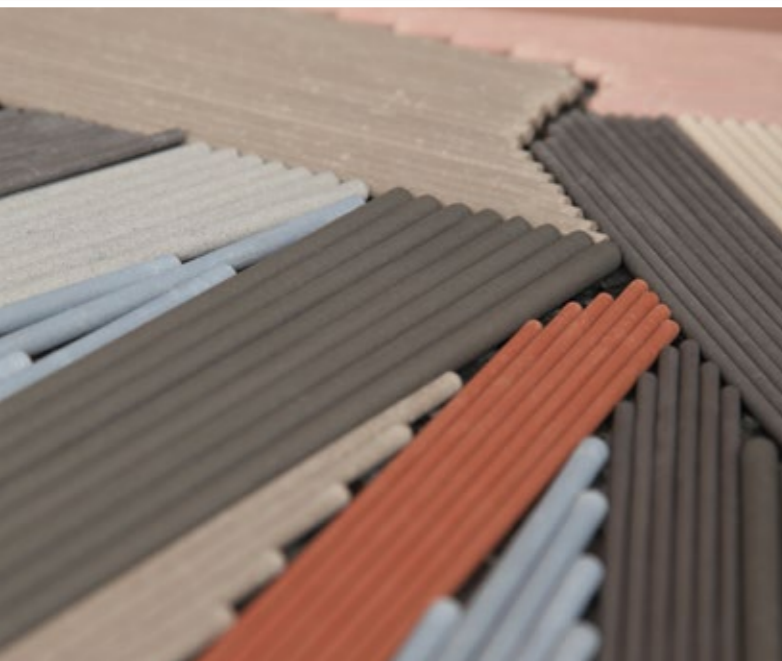
 **GeKaMac®**



 **GeKaRobotics®**

Product Variety Where The Technology and Quality Join...

 GeKa  GeKaTec  GeKaMac  GeKaRobotics



A Golden Star in Export ...



With its 52 years of experience and high quality products, Gedik Welding exports to more than 80 countries in the world.

Gedik Welding has been rewarded as the number one exporter company by Istanbul Minerals and Metals Exporter's Associations in the category of the middle scale of exporters for the last three years.

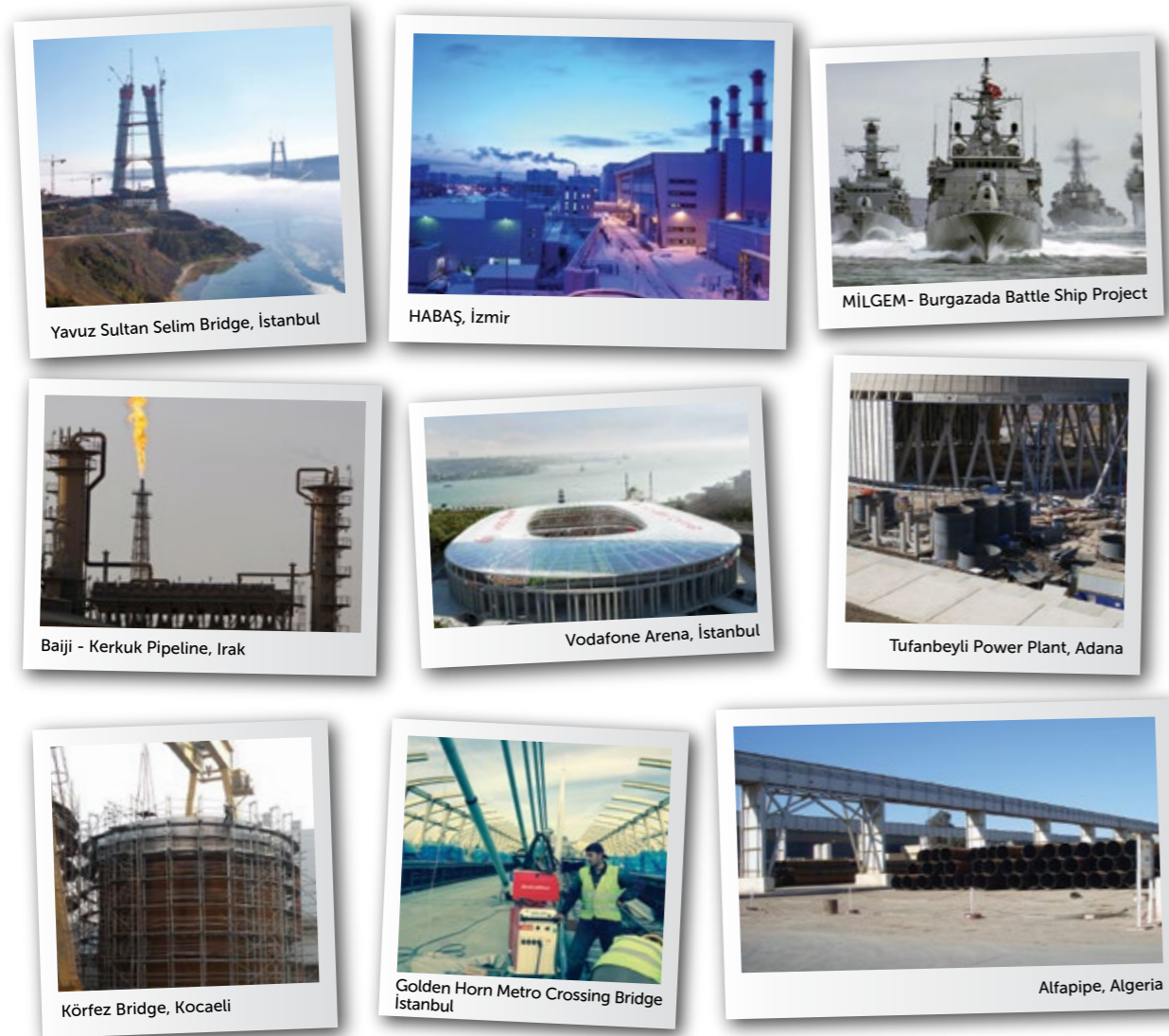
Gedik Quality is the Preference of Mega Projects Throughout Turkey and Around the World...

Having added various worldwide achievements such as Bosphorus Bridge Project, Fatih Sultan Mehmet Bridge Project and Marmaray Project to its over half a century past, Gedik Welding continues to supply products to new projects such as Yavuz Sultan Selim Bridge and Gulf Pass Bridge, and provides services for many projects in Turkey and around the world with its modern technological infrastructure and quality products.

Industrial Fields, We Provide Products and Services...

Gedik Welding continues to be the robotic automated welding service provider under the brand of GeKaRobot® and provides welding products that are branded GeKa®, GeKaTec® and GeKaMac® for the following industrial fields.

- Electric Power-plants
- Pressure Vessels
- Wind Energy
- Platforms
- Pipe Lines
- Ship Construction
- Steel Construction
- Bridge Construction
- Automotive Industry
- Aircraft Industry
- Machine Manufacturing
- Storage Facilities



WELDING ELECTRODES

- Rutile Electrodes
- Cellulosic Electrodes
- Basic Electrodes
- Low-alloyed Electrodes
- Heat Resisting Electrodes
- Stainless Steel Electrodes
- Cast Iron Electrodes
- Hardfacing Electrodes
- Nickel Based Electrodes
- Cutting & Gouging Electrodes



GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)			Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	0 °C (32 °F)	3/32 x 14" (2,5 x 350)	1/8 x 14" (3,2 X 350)	5/32 x 14" (4,0 x 350)	3/16 x 14" (5,0 x 350)
Rutile	ELIT	AWS A5.1:12 E 6013	D.C. (-) / A.C.	F, V, OH, H	0,07	0,3	0,5	>420 (>61)	510-610 (74-88)	>22	-	>47 (35)	+	+	+*	+*
	LOTUS	AWS A5.1:12 E 6013	D.C. (-) / A.C.	F, V, OH, H, V down	0,07	0,3	0,4	>420 (>61)	510-610 (74-88)	>22	-	>47 (35)	+	+	+	+
	ELIT ARMCO	EN ISO 2560-A E 35 A RR 12	D.C. (-) / A.C.	F, V, OH, H	0,05	<0,2	0,3	>355 (>52)	440-560 (64-81)	>22	>47 (35)	-	-	+	+	+
	CEM	AWS A5.1:12 E 7024	D.C. (-) / A.C.	H-fillet, F	0,07	0,4	0,7	>420 (>61)	510-610 (74-88)	>22	-	>47 (35)	-	+	+	+

* Also 18" is produced for those diameters

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)					Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Mo	Ni	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	0 °C (32 °F)	3/32 x 14" (2,5 x 350)	1/8 x 14" (3,2 X 350)	5/32 x 14" (4,0 x 350)	3/16 x 14" (5,0 x 350)
Cellulosic	LINK 6010	AWS A5.1:12 E 6010	D.C.(+) D.C.(-) for root pass	F, V, OH, H, V down	0,12	0,20	0,60	-	-	>380 (>55)	470-540 (68-78)	>22	-	>47 (35)	+	+	+	+
	LINK 7010-G	AWS A5.5:06 E 7010-G	D.C. (+)	F, V, OH, H, V down	0,10	0,15	0,40	0,40	-	>420 (>61)	510-590 (74-86)	>22	>47 (35)	-	+	+	+	+
	LINK 8010-P1	AWS A5.5:06 E 8010-P1	D.C. (+)	F, V, OH, H, V down	0,14	0,20	0,90	-	0,60	>460 (>67)	550-650 (80-94)	>20	-	>47 (35)	+	+	+	+

Please visit our website for detailed information



GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)			Mechanical Properties			Charpy V-Notch J (ft-lbf)				Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-30 °C (-22 °F)	-40 °C (-40 °F)	-50 °C (-58 °F)	-60 °C (-76 °F)	3/32 x 14" x 350	1/8 x 14" x 350	5/32 x 18" x 450	3/1 x 18" x 450
Low Hydrogen Basic	LASER B 43	AWS A5.1:12 E 7016-1 H4	D.C.(+) D.C.(-) for root pass	F, V, OH, H	0,06	0,5	0,7	>400 (>58)	490-600 (71-87)	>24	-	-	>47 (35)	-	+	+	+	+
	LASER B 47	AWS A5.1:12 E 7018 H4	D.C. (+)	F, V, OH, H	0,07	0,5	1,0	>420 (>61)	510-600 (74-87)	>24	-	>47 (35)	-	-	+	+	+	+
	LASER B 55-S	AWS A5.1:12 E 7018-1 H4	D.C. (+)	F, V, OH, H	0,08	0,4	1,4	>460 (>67)	530-650 (77-94)	>24	-	-	-	>47 (35)	+	+	+	+
	LASER B 160	AWS A5.1:12 E 7028 H4	D.C. (+)	H-fillet, F	0,07	0,4	0,7	>420 (>61)	510-610 (74-88)	>24	>47 (35)	-	-	-	-	-*	+	+

* Also 18" is produced for this diameter

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)						Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-50 °C (-58 °F)	-60 °C (-76 °F)	3/32 x 14" x 350	1/8 x 14" x 350	5/32 x 18" x 450	3/1 x 18" x 450
Low Alloyed High Strength Basic	TEMPO B 60	AWS A5.5:06 E 8018-G H4	D.C.(+)	F, V, OH, H	0,07	0,3	1,3	-	0,9	-	>460 (>67)	580-680 (84-99)	>24	-	100 (74)	+	+	+	+
	TEMPO B 70 S**	AWS A5.5:06 E 9018-G H4	D.C.(+)	F, V, OH, H	0,07	0,2	0,6	-	2,4	0,4	>550 (>80)	620-780 (90-113)	>20	-	90 (66)	+	+	+	+
	TEMPO B 85 M	AWS A5.5:06 E 11018-M H4	D.C.(+)	F, V, OH, H	0,05	0,2	1,6	0,35	2,2	0,45	>700 (>102)	>760 (>110)	>20	47 (35)	-	-	+	+	+

* Also 14" is produced for this diameter

** Heat treatment :600 °C 1h/300 °C air (1120 °F 1h/572 °F air)

Please visit our website for detailed information



GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)									Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	V	Nb	N	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	3/32 x 14" (2,5 x 350)	1/8 x 14" (3,2 x 350)	5/32 x 18" (4,0 x 450)	3/16 x 18" (5,0 x 450)
Heat Resisting	OPUS 5 CM*	AWS A5.5:06 E 8016-B6	D.C.(+)	F, V, OH, H	0,06	0,4	0,8	5,2	-	0,5	-	-	-	>460 (>67)	590-740 (86-107)	>19	>47 (35)	+	+	+***	+
	OPUS 9 CMV**	AWS A5.5:06 E 9018-B9	D.C.(+)	F, V, OH, H	0,09	0,2	1,0	9,0	0,6	1,0	0,2	0,04	+	>530 (>77)	>620 (>90)	>21	80 (59)	+	+	-***	-
	OPUS 9 CMV-15**	AWS A5.5:06 E 9015-B9	D.C.(+)	F, V, OH, H	0,09	0,3	0,5	9,0	1,0	1,0	0,2	0,04	+	>530 (>77)	>620 (>90)	>17	>47 (35)	+	+	-***	-

* Heat treatment :740°C 2h/300°C air (1364°F 2h/572°F air)
 ** Heat treatment :760°C 2h/300°C air (1400°F 2h/572°F air)
 *** 14" is produced for this diameter

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)						Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (+68 °F)	3/32 x 10" (2,5 x 250)	1/8 x 14" (3,2 x 350)	5/32 x 18" (4,0 x 450)	
Stainless Steel	ELOX R 308 L	AWS A5.4:06 E 308L-16	D.C.(+) / A.C.	F, V, OH, H	0,03	0,8	0,9	20,0	10,5	-	>355 (>55)	520-660 (68-78)	>35	>47 (35)	+	+*	+	
	ELOX R 309 L	AWS A5.4:06 E 309L-16	D.C.(+) / A.C.	F, V, OH, H	0,03	0,8	0,8	23,0	12,6	-	>420 (>61)	510-590 (74-86)	>30	>47 (35)	+	+	+	
	ELOX R 310	AWS A5.4:06 ~E 310-16	D.C.(+) / A.C.	F, V, OH, H	0,12	0,9	2,5	26,0	20,0	-	>460 (>67)	550-650 (80-94)	>25	>47 (35)	+	+*	+	

* Also 12" is produced for this diameter



GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)						Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	3/32 x 10" (2,5 x 250)	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)	
Stainless Steel	ELOX R 312	AWS A5.4:06 ~E 312-16	D.C.(+) / A.C.	F, V, OH, H	0,12	1,0	0,8	30,0	10,5	-	>490 (>71)	700-830 (102-120)	>20	>24 (18)	+	+*	+	
	ELOX R 316 L	AWS A5.4:06 E 316 L-16	D.C.(+) / A.C.	F, V, OH, H	0,03	0,8	0,9	19,0	11,5	2,6	>355 (>51)	540-670 (78-97)	>30	>47(35)	+	+	+	
	ELOX R 317 L	AWS A5.4:06 E 317 L-16	D.C.(+) / A.C.	F, V, OH, H	<0,04	0,8	0,9	18,7	12,5	3,2	>400 (>58)	570-700 (83-102)	>30	>47 (35)	+	+*	+	

* Also 12" is produced for this diameter

Please visit our website for detailed information



Please visit our website for detailed information



GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)									Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)		
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	N	Nb	Cu	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (+68 °F)	3/32 x 10" (2,5 x 250)	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)
Stainless Steel	ELOX R 318	AWS A5.4:06 ~E 318-16	D.C.(+) / A.C.	F, V, OH, H	0,04	0,8	0,8	19,4	11,0	2,8	-	+	-	>390 (>57)	580-750 (84-109)	>30	>47 (35)	+	+++	+
	ELOX R 385	AWS A5.4:06 E 385-16	D.C.(+) / A.C.	F, V, OH, H	<0,03	0,75	1,0	20,0	25,0	4,5	-	-	1,5	>400 (>58)	550-700 (80-102)	>30	>47 (35)	+	+	+
	ELOX R 2209	AWS A5.4:06 E 2209-17	D.C.(+) / A.C.	F, V, OH, H	0,03	0,50	0,9	22,0	10,0	2,7	0,12	-	-	>520 (>75)	690-850 (100-123)	>20	>47 (35)	+	+	+

* Also 5/65" is produced this length.
 ** Also 12" is produced for this diameter.

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)									Mechanical Properties				Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	V	Welding Wire Hardness (HB)	Hardness After Cold Deformation (HB)	300 - 400°C (572 - 757°F) Tempered	1000 - 1050°C (1832 - 1922°F) Hardening in Oil	3/32 x 14" (2,5 x 350)	1/8 x 14" (3,2 x 350)	5/32 x 18" (4,0 x 450)	3/16 x 18" (5,0 x 450)		
Hardfacing	ELHARD 350	EN 14700:06 E Fe 1	D.C.(+)	F, OH	0,17	0,8	1,5	2,0	-	-	-	330 - 380 HB	-	-	-	-	+	+	+		
	ELHARD 600	EN 14700:06 E Fe 8	D.C.(+)	F, OH, H	0,5	1,1	0,5	7,5	-	1,0	1,0	55 - 59 HRC	-	~53 - 55 HRC	~60 HRC	+	+	+	+		
	ELHARD 14 Mn	AWS A5.13:00 E FeMn-A	D.C.(+)	F, OH, H	0,60	0,1	13,5	0,60	3,0	-	-	180 - 220 HB	~550	-	-	-	+	+	+		

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)			Mechanical Properties				Diameter x Length inch (mm)		
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Ni	Fe	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	Hardness (HB)	3/32 x 12" (2,5 x 300)	1/8 x 12" (3,2 x 300)	5/32 x 16" (4,0 x 400)
Cast Iron	ELNIKEL	AWS A5.15:05 E Ni-CI	D.C.(-) / A.C.	F, V-up	0,50	rest	-	200 (29)	250 (36)	3	~170	+	+	+
	ELNIFER	AWS A5.15:05 E NiFe-CI	D.C.(+)	F, V-up	-	>45,0	>40,0	200 (29)	350 (51)	6	~190	+	+	+

GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)								Mechanical Properties	Diameter x Length inch (mm)		
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Mo	V	Co	Hardness (HRC)	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)	3/16 x 14" (5,0 x 350)	
Hardfacing	ELHARD 58	EN 14700:06 E Fe 4	D.C.(+) / A.C.	F, OH, H	0,7	1,0	1,0	4,0	7,0	1,7	2,0	56 - 60	+	+	-	
	ELHARD 60	EN 14700:06 E Fe 14	D.C.(+) / A.C.	F, H	3,20	1,0	0,5	29,0	-	-	-	58 - 62	+	+	+	
	ELHARD 63	AWS A5.13:00 ~E FeCr-A8	D.C.(+) (-) / A.C.	F, H	4,5	1,0	0,5	34,0	-	-	-	60 - 64	+	+	+	

Please visit our website for detailed information



Please visit our website for detailed information





GeKa Welding Electrodes					Chemical Composition of Weld Metal % (Typical)									Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)		
Group	Product name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Fe	Nb	Ti	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elong. (%)	+20 °C (+68 °F)	3/32 x 10" (2,5 x 250)	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)
Nickel Based	NIBAZ B 65	AWS 5.11:05 E NiCrMo-3	D.C.(+)	F, V-up, OH, H	0,04	0,7	0,4	21,0	rest	9,0	5,0	3,5	+	>420 (>61)	>760 (>110)	>30	>60 (>44)	+	+	+
	NIBAZ B 70	AWS A5.11:05 ~E NiCrFe 3	D.C.(+)	F, V-up, OH, H	0,05	0,4	4,5	20,0	>65	1,5	3,0	1,8	0,25	>390 (>57)	630 - 710 (91 - 103)	>30	>60 (>44)	+	+	+

GeKa Welding Electrodes						Diameter x Length inch (mm)				
Group	Product name	Current Type & Polarity	Position	Typical Base Material Grades	Features and Applications	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)	5/32 x 18" (4,0 x 450)	3/16 x 14" (5,0 x 350)	5/32 x 18" (5,0 x 450)
Cutting	ELIT CUT	D.C.(-) / A.C.	F, V-up, H, OH	Non-alloyed and low-alloyed steels, stainless steels, aluminium and aluminium alloys, copper and copper alloys, cast-iron and steel casts.	Usability in cutting, in making welding grooves, or in drilling all metals that cannot be oxygen-cut or -drilled. Resistance against high values of current at welding. Requirement of holding the electrode in direction perpendicular to work direction.	+	+	+	-	+
Gouging	ELIT NUT	D.C.(-) / A.C.	F, V-up, H, OH	Non-alloyed and low-alloyed steels, stainless steels, aluminium and aluminium alloys, copper and copper alloys, cast-iron and steel casts.	Usability in making welding grooves, or in removing defective weld beads in all metals that cannot be worked through oxygen. Very easy usage. Arc start by holding the electrode in a direction perpendicular to that of the work, and, by subsequently pushing it forward after approaching it at an angle of 15° to work direction. Groove depth of half of the electrode's coating thickness. Deeper grooves obtained only by repeating the operation after the work piece is cooled.	+	+	-	+	+

Please visit our website for detailed information



GAS SHIELDED ARC WELDING WIRE

- Non-alloyed Gas Shielded Arc Welding Wire & Rods
- Heat Resisting Arc Welding Wires & Rods
- Low-alloyed High Strength Gas Shielded Welding Wires & Rods
- Weather Resistant Gas Shielded Arc Welding Wire
- Stainless Steel Gas Shielded Welding Wires & Rods
- Aluminium-alloyed Gas Shielded Welding Wires
- Aluminium-alloyed TIG Welding Rods
- Copper-alloyed Gas Shielded Welding Wires
- Copper Based Gas Shielded Welding Wires



GeKa Gas Shielded Welding Wires & Rods					Chemical Composition of Welding Wire % (Typical)						Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)					
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	Zr	Ti	Al	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-30 °C (-22 °F)	-40 °C (-40 °F)	1/16 x 39" (1,6 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,4 x 1000)	1/8 x 39" (3,2 x 1000)	5/32 x 39" (4,0 x 1000)	13/64 x 39" (5,0 x 1000)
Gas Shielded	SG 1*	AWS A5.18:05 ER 70 S-3	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	0,6	1,2	-	-	-	>460 (>67)	530-680 (67-99)	>24	-	>47 (35)	+	+	+	+	+	+
	SG 2*	AWS A5.18:05 E 70 S-6	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,08	0,85	1,45	-	-	-	>420 (>61)	500-640 (73-93)	>22	>47 (35)	-	+	+	+	+	+	+
	SG 3*	AWS A5.18:05 ER 70 S-6	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	1,0	1,70	-	-	-	>460 (>67)	540-670 (78-97)	>22	-	>47 (35)	+	+	+	+	+	-
	SG 70 S-2*	AWS A5.18:05 ER 70 S-2	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,05	0,55	1,1	0,07	0,12	0,11	>400 (>58)	>480 (>70)	>22	>47 (35)	-	+	+	+	+	+	+

* Also 0,030"(0,80mm), 0,040"(1,00mm), 0,047"(1,20mm),0,062"(1,60mm) are produced for these types.

GeKa Gas Shielded Welding Wires & Rods					Chemical Composition of Welding Wire % (Typical)					Mechanical Properties			Charpy V-Notch J (ft-lbf)			Diameter x Length inch (mm)					
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	Mo	Cr	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	-30 °C (-22 °F)	-40 °C (-40 °F)	1/16 x 39" (1,6 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,4 x 1000)	1/8 x 39" (3,2 x 1000)	5/32 x 39" (4,0 x 1000)	13/64 x 39" (5,0 x 1000)
Heat Resisting	SG Mo*	AWS A5.28:05 ER 80 S-G mod. (ER 70 S-A1)	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	0,6	1,1	0,5	-	>460 (>67)	550-670 (80-97)	>22	-	-	>47 (35)	+	+	+	+	+	-
	SG 80 S-D2*	AWS A5.28:05 ER 80 S-D2	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	0,65	1,8	0,5	-	>470 (>68)	550-680 (80-99)	>22	-	>47 (35)	-	+	+	+	+	+	+
	SG CrMo 1*	AWS A5.28:05 ER 80 S-B2	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	0,6	0,5	0,5	1,2	>470 (>68)	550-670 (80-97)	>19	>78 (58)	-	-	+	+	+	+	+	-
	SG CrMo 2*	AWS A5.28:05 ER 90 S-B3	TIG D.C.(-) MAG D.C.(+)	F, V, OH, H	0,10	0,6	0,5	1,0	2,4	>540 (>78)	620-760 (90-110)	>20	>47 (35)	-	-	+	+	+	+	+	-

* Also 0,030"(0,80mm), 0,040"(1,00mm), 0,047"(1,20mm),0,062"(1,60mm) are produced for these types.

Please visit our website for detailed information

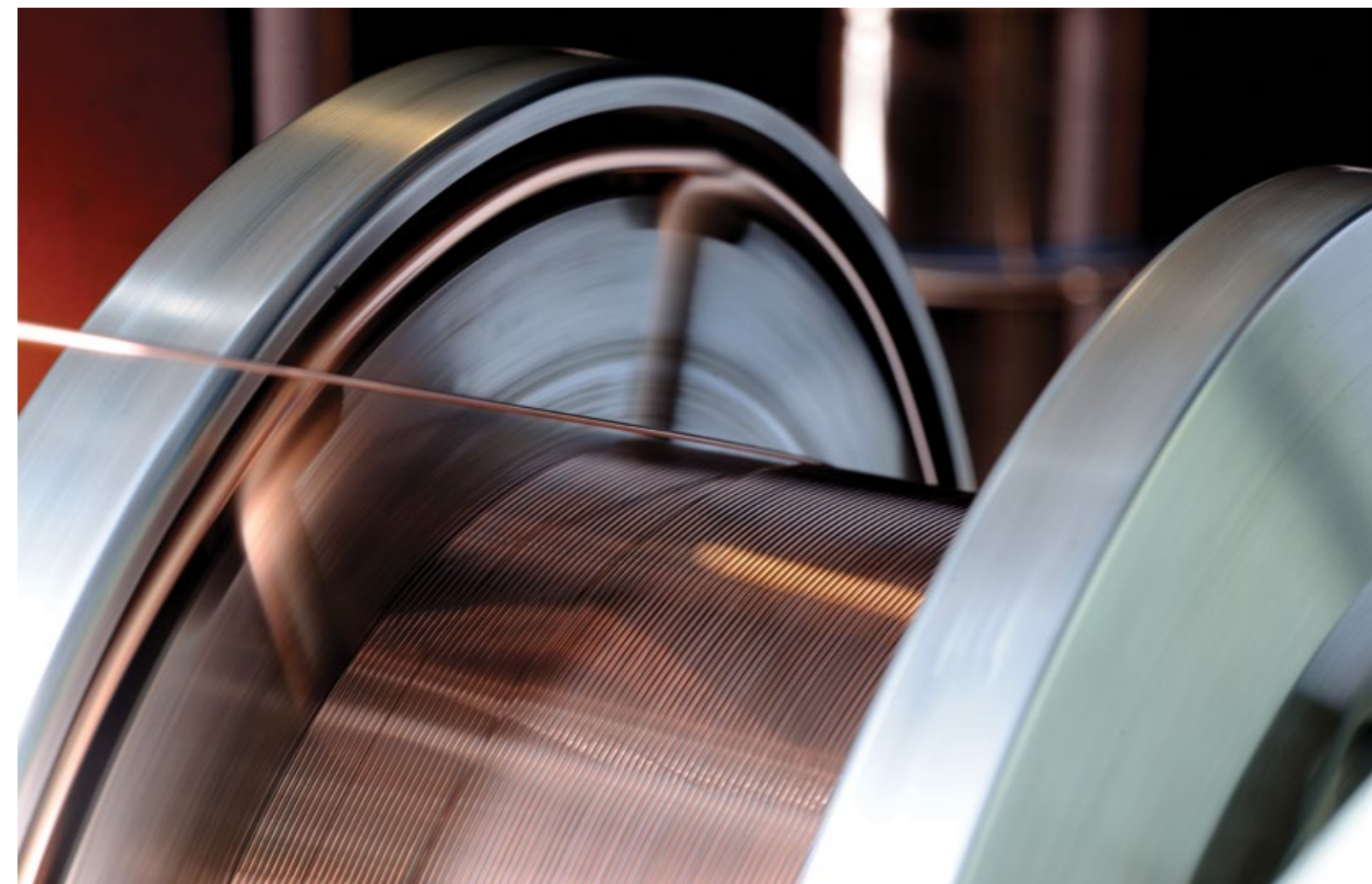


GeKa Gas Shielded Welding Wires & Rods					Chemical Composition of Welding Wire % (Typical)							Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	Mo	Cr	Ni	Cu	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-30 °C (-22 °F)	-40 °C (-40 °F)	0,030" (0,80)	0,040" (1,00)	0,047" (1,20)	0,062" (1,60)
Low Alloyed High Strength Gas Shielded	ER 100 SG*	AWS A5.28:05 ER 100 S-G	MAG D.C.(+)	F, V, OH, H	0,077	0,50	1,55	0,25	0,25	1,50	-	>620 (>90)	700-890 (102-129)	>18	>47 (35)	-	+	+	+	+
	ER 110 SG*	AWS A5.28:05 ER 110 S-G	MAG D.C.(+)	F, V, OH, H	0,09	0,75	1,70	0,50	0,30	2,0	0,20	>690 (>100)	770-940 (112-136)	>19	>47 (35)	-	+	+	+	-
	ER 120 SG	AWS A5.28:05 ER 120 S-G	MAG D.C.(+)	F, V, OH, H	0,10	0,55	1,70	0,50	0,30	2,50	0,20	>890 (>129)	940-1180 (136-171)	>15	-	>47 (35)	-	+	+	-

* Also (1/16,5/64,3/32,1/8)x39" are produced.

GeKa Gas Shielded Welding Wires & Rods					Chemical Composition of Welding Wire % (Typical)							Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	Cr	Ni	Mo	Nb	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (+68 °F)	1/16 x 39" (1,6 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,4 x 1000)	1/8 x 39" (3,2 x 1000)
Stainless Steel	ELOX SG 312	AWS A5.9:10 ER 312	TIG D.C.(-) MIG D.C.(+)	F, V, OH, H	0,12	0,40	1,80	30,0	9,0	-	-	>450 (>65)	>660 (>96)	>20	>47 (35)	+	+	+	+
	ELOX SG 316 L	AWS A5.9:10 ER 316 L	TIG D.C.(-)	F, V, OH, H	0,02	0,5	1,60	18,5	11,5	2,20	-	>420 (>61)	570-700 (83-102)	>35	>63 (46)	+	+	+	+
	ELOX SG 318	AWS A5.9:10 ER 318	TIG D.C.(-) MIG D.C.(+)	F, V, OH, H	0,035	0,5	1,7	19,6	11,4	2,7	+	>440 (>64)	640-780 (93-113)	>30	>63 (46)	+	+	+	-

GeKa Gas Shielded Welding Wires & Rods					Chemical Composition of Welding Wire % (Typical)					Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	Cr	Ni	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	1/16 x 39" (1,6 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,4 x 1000)	1/8 x 39" (3,2 x 1000)
Stainless Steel	ELOX SG 308 L	AWS A5.9:10 ER 308 L	TIG D.C.(-)	F, V, OH, H	<0,02	0,5	1,7	20,1	9,80	>390 (>57)	540-660 (78-96)	>35	>63 (46)	+	+	+	+
	ELOX SG 309 L	AWS A5.9:10 ER 309 L	TIG D.C.(-)	F, V, OH, H	0,03	0,45	1,80	23,5	13,0	>320 (>46)	>520 (>75)	>30	>47 (35)	+	+	+	+
	ELOX SG 310	AWS A5.9:10 ER 310	TIG D.C.(-) MIG D.C.(+)	F, V, OH, H	0,12	0,5	1,6	25,0	20,5	>350 (>51)	550-720 (80-104)	>30	>63 (46)	+	+	+	+



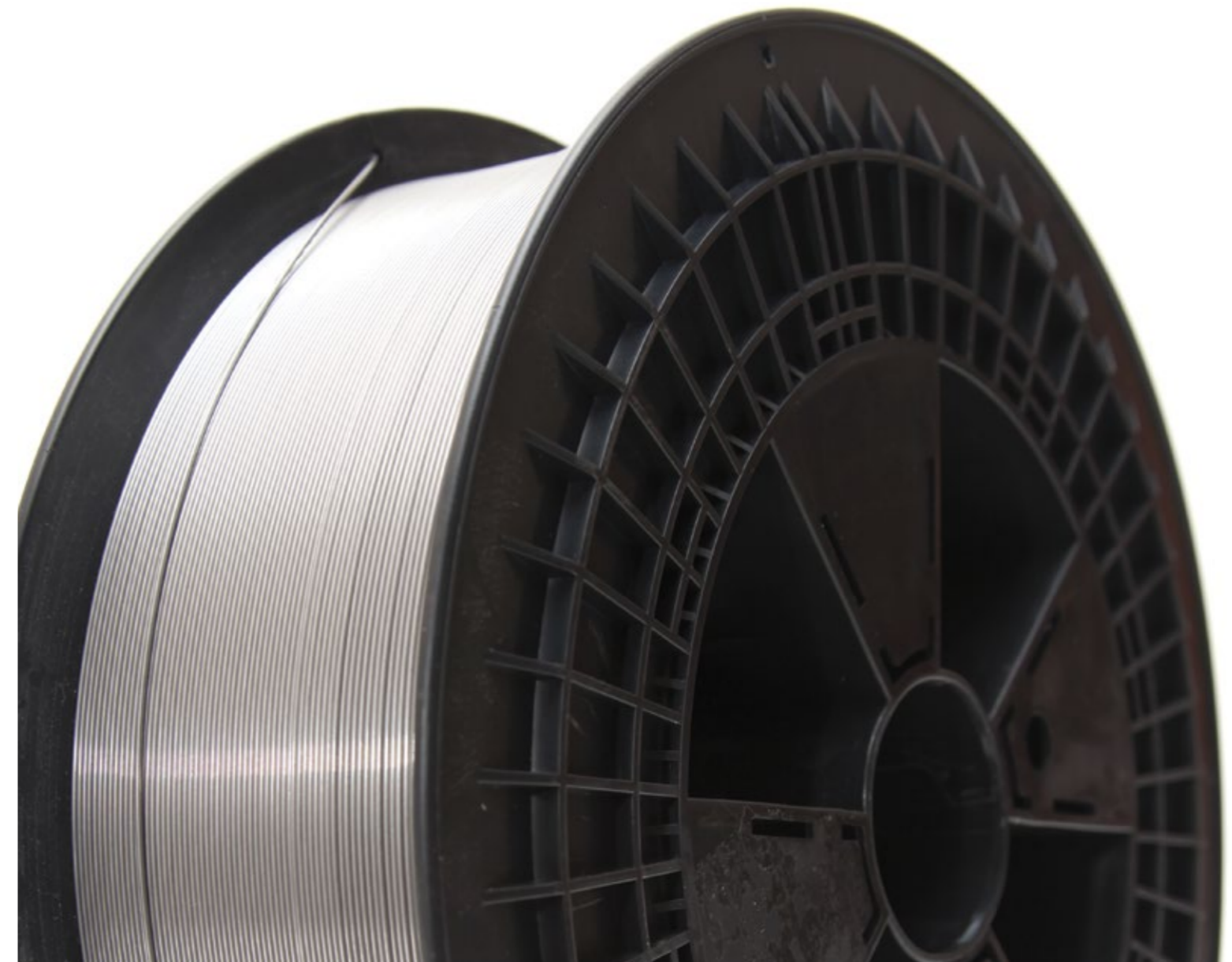
Please visit our website for detailed information



GeKa Gas Shielded Welding Wires					Chemical Composition of Welding Wire % (Typical)					Mechanical Properties (Typical)				Diameter x Length inch (mm)			
Group	Product name	Standard & Classification	Current Type	Position	Si	Mn	Al	Fe	Mg	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	Working Temperature (°C) (°F)	0,030" (0,8)	0,040" (1,0)	0,047" (1,2)	0,062" (1,6)
Aluminium Alloyed	AlSi 5	AWS A5.10 ER-4043	MIG D.C.(+)	F, V-up, OH, H	5,0	<0,05	rest	<0,8	-	110 (16)	150 (22)	15	575-633 (1067-1171)	+	+	+	+
	AlSi 12	AWS A5.10 ER-4047	MIG D.C.(+)	F, V-up, OH, H	12,0	<0,15	rest	<0,8	-	80 (12)	160 (23)	8	573-585 (1063-1085)	+	+	+	-
	AlMg 5	AWS A5.10 ER-5356	MIG D.C.(+)	F, V-up, OH, H	<0,25	0,3	rest	<0,40	5,0	180 (26)	260 (38)	20	575-633 (1067-1171)	+	+	+	+
	Al 99,5	AWS A5.10 ~ER-1100	MIG D.C.(+)	F, V-up, OH, H	<0,30	-	99,5	<0,40	-	50 (7)	85 (12)	25	647-658 (1197-1216)	+	+	+	+

GeKa Flux Cored Welding Wires					Chemical Composition of Welding Wire % (Typical)								Mechanical Properties			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	P	S	Ni	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-20 °C (-22 °F)	-40 °C (-40 °F)	0,047" (1,20)	
Low Alloyed High Strength	ELCOR R 91	AWS A5.29:10 E 91 T1 - K2 C J	D.C.(+)	F, V, OH, H	0,08	0,5	1,20	<0,015	<0,015	1,70	-	>620 (>90)	690-890 (100-129)	>18	>62 (46)	>47 (35)	+	
	ELCOR R 110	AWS A5.29:10 E 111 T1-GC	D.C.(+)	F, V, OH, H	<0,08	0,5	1,70	<0,015	<0,015	2,10	0,20	>690 (>100)	770-940 (112-136)	>17	-	>47 (35)	+	

GeKa Flux Cored Welding Wires					Chemical Composition of Welding Wire % (Typical)						Mechanical Properties			Charpy V-Notch J (ft-lbf)			Diameter x Length inch (mm)	
Group	Product name	Standard & Classification	Current Type	Position	C	Si	Mn	P	S	Ni	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-20 °C (-4 °F)	-30 °C (-22 °F)	-40 °C (-40 °F)	0,047" (1,20)	0,062" (1,60)
Unalloyed & Low Alloyed Flux Cored	ELCOR R 71	AWS A5.20:05 E 71 T-1C-J	D.C.(+)	F, V, OH, H	0,06	0,5	1,3	0,015	0,015	-	>420 (>61)	500-640 (73-93)	>22	-	-	>50 (37)	+	+
	ELCOR R 71 CM	AWS A5.20:05 E 71 T-1C/-1M	D.C.(+)	F, V, OH, H	0,06	0,5	1,3	<0,015	<0,015	-	>460 (>67)	530-600 (77-87)	>22	>50 (37)	-	-	+	-
	ELCOR M 70	AWS A5.18:05 E 70 C-6 M	D.C.(+)	F, H	0,05	0,65	1,60	0,015	0,010	-	>450 (>65)	>550 (>80)	>22	-	55 (41)	>47 (35)	+	+
	ELCOR B 70	AWS A5.20 :05 E 70 T-5 M J	D.C.(+)	F	0,05	0,55	1,35	<0,015	<0,015	-	>420 (>61)	520-670 (75-97)	>22	-	120 (89)	100 (74)	+	+
	ELCOR R 81 Ni	AWS A5.29 :10 E 81 T1-Ni1 C	D.C.(+)	F, V, OH, H	0,05	0,50	1,30	<0,015	<0,015	0,90	530 (77)	560-690 (81-100)	>24	-	80 (59)	50 (37)	+	-

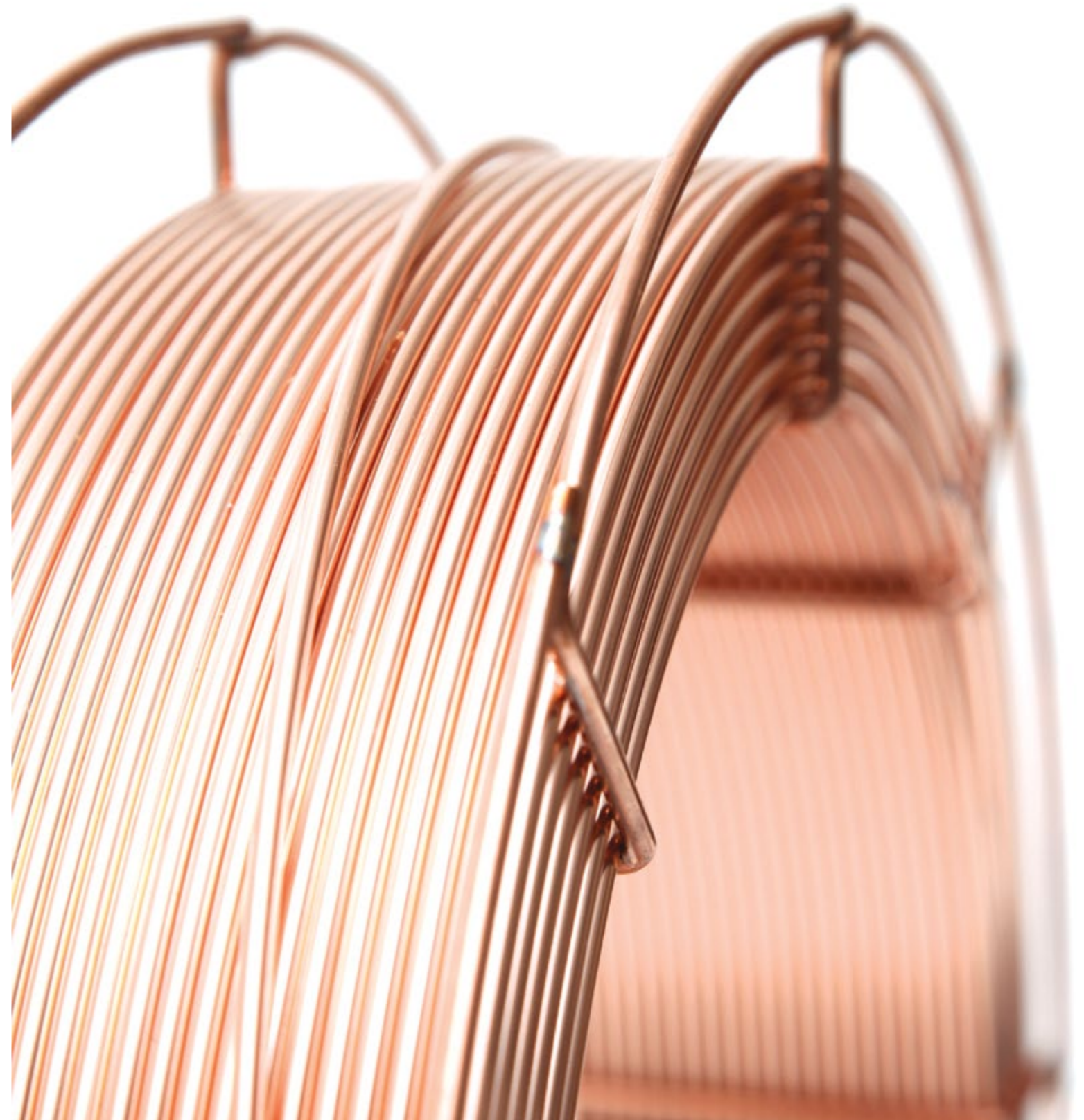


Please visit our website for detailed information



GeKa Flux Cored Welding Wires					Chemical Composition of Welding Wire % (Typical)									Mechanical Properties	Diameter x Length inch (mm)		
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Nb	V	Fe	Hardness (as welded)	0,047" (1,20)	1/16" (1,60)	7/64" (2,80)
Hardfacing	HARDCOR 600 G	EN 14700:06 T Fe 6	D.C.(+)	F, H	0,40	0,70	0,6	9,0	-	-	-	-	rest	600 (HB)	+	+	-
	HARDCOR 41 NiMo G	EN 14700:06 T Fe 7	D.C.(+)	F, H	0,14	1,0	1,0	13,0	3,5	1,2	0,2	0,1	rest	43-45 (HRC)	-	+	-
	HARDCOR 600 O	DIN 8555 MF 6-GF-60-GP	D.C.(+)	F, H	0,80	1,20	1,4	8,0	-	-	-	-	rest	58 (HRC)	+	+	+

GeKa Flux Cored Welding Wires					Chemical Composition of Welding Wire % (Typical)										Mechanical Properties	Diameter x Length inch (mm)			
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	C	Si	Mn	Cr	Ni	Mo	Nb	W	V	Fe	Hardness (as welded)	0,047" (1,20)	1/16" (1,60)	3/32" (2,40)	7/64" (2,80)
Hardfacing	HARDCOR 14 Mn G	EN 14700:06 T Fe 9	D.C.(+)	F, H	0,55	0,1	12,8	-	2,5	-	-	-	-	rest	170-200 (HB)	+	+	-	-
	HARDCOR 63 O	EN 14700:06 T Z Fe 15	D.C.(+)	F, H	5,0	1,5	1,3	27,0	-	-	-	-	-	rest	60-64 (HRC)	-	+	-	+
	HARDCOR 65 O	EN 14700:06 T Fe 16	D.C.(+)	F, H	5,2	1,0	0,4	21,0	-	7,0	7,0	2,0	1,0	rest	63-65 (HRC)	-	+	+	+



Please visit our website for detailed information



GeKa Submerged Arc Welding Wires					Chemical Composition of Welding Wire % (Typical)								Mechanical Properties		Diameter x Length inch (mm)	
Group	Product Name	Standard & Classification	Current Type	Position	C	Si	Mn	Cr	Ni	Mo	V	Nb	Hardness		3/32" (2,40 mm)	7/64" (2,80 mm)
													Single Pass	3 Pass		
Submerged	SUBCOR 430	EN 14700:06 T Fe 7	D.C.(+)	F, V-down, OH, H	0,05	0,7	2,0	17	-	-	-	-		200 (HV)	+	+
	SUBCOR 41 NiMO-LH	AWS A5.23: ~EC 410 Ni Mo	D.C.(+)	F, V, OH, H	0,07	0,35	1,5	12,5	2,2	1,0	0,2	-	350 (HV)	400 (HV)	+	+
	SUBCOR 41 NiMO-MH	AWS A5.23: ~EC 410 Ni Mo	D.C.(+)	F, V, OH, H	0,13	1,00	2,0	12,5	2,5	1,0	0,2	0,15	40 (HRC)	45 (HRC)	+	+

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)			Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)			
Wires Name	Flux Name	Standard & Classification AWS A5.17:97	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elong. (%)	Charpy V-Notch J (ft-lbf)			
									0 °C (32 °F)	-20 °C (-4 °F)	-30 °C (-22 °F)	-40 °C (-40 °F)
S 2	ELIFLUX BAR	F6 AZ-EL 12 F6 PZ-EM12	0,07	0,60	1,35	400 (58)	500 (73)	30	60 (44)	-	-	-
	ELIFLUX BFB	F7 A4-EM12	0,07	0,35	1,50	460 (67)	525 (76)	30	-	70 (52)	55 (41)	50 (37)
	ELIFLUX BFF	F7 A4-EM12	0,05	0,20	1,00	410 (59)	520 (75)	24	-	-	70 (52)	60 (44)
	ELIFLUX BBR-AG	F7 A2-EM12	0,10	0,35	1,20	410 (59)	490 (71)	32	50 (37)	50 (37)	50 (37)	-
	ELIFLUX BMS	F6 A0-EM12	0,04	0,45	1,27	390 (57)	485 (70)	30	-	69 (51)	-	-
	ELIFLUX PIPE	F7 A4-EM12	0,07	0,40	1,35	460 (67)	550 (80)	26	-	75 (55)	-	50 (37)

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)			Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)		
Wires Name	Flux Name	Standard & Classification AWS A5.17:97	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elong. (%)	Charpy V-Notch J (ft-lbf)		
									0 °C (32 °F)	-20 °C (-4 °F)	-30 °C (-22 °F)
S 1	ELIFLUX BAR	F6 AZ-EL 12	0,07	0,50	1,10	360 (52)	460 (54)	26	47 (35)	-	-
	ELIFLUX BFB	F6 A2-EL 12	0,06	0,25	1,20	380 (55)	480 (70)	28	-	55 (41)	47 (35)
	ELIFLUX BMS	F6 AZ-EL 12	0,05	0,80	1,10	395 (57)	475 (69)	24	38 (28)	-	-
	ELIFLUX BBR-AG	F6 A0-EL 12	0,06	0,30	0,90	370 (54)	480 (70)	30	60 (44)	50 (37)	-

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)			Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)		
Wires Name	Flux Name	Standard & Classification AWS A5.17:97	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elong. (%)	Charpy V-Notch J (ft-lbf)		
									-20 °C (-4 °F)	-30 °C (-22 °F)	-40 °C (-40 °F)
S2 Si	ELIFLUX BFB	F7 A2-EM12K F7 P2-EM12K	0,05	0,40	1,25	430 (62)	530 (77)	28	80 (59)	70 (52)	-
	ELIFLUX BFF	F7 A4-EM12K F7 P4-EM12K	0,06	0,30	1,10	450 (65)	540 (78)	23	-	-	65 (48)
	ELIFLUX BAB-S	F7 A4-EM12K	0,07	0,45	1,60	440 (64)	550 (80)	28	100 (74)	-	65 (48)
	ELIFLUX BBR-AG	F7 A0-EM12K	0,07	0,40	1,30	420 (61)	510 (74)	29	50 (37)	-	-

Please visit our website for detailed information



Please visit our website for detailed information



GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)				Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)	
Wires Name	Flux Name	Standard & Classification AWS A5.23:07	C	Si	Mn	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	-20 °C (-4 °F)	-40 °C (-40 °F)
S2 Mo	ELIFLUX BFB	F8 A4-EA2-A2	0,06	0,40	1,40	0,50	490 (71)	600 (87)	26	90 (66)	60 (44)
	ELIFLUX BFF	F8 A4-EA2-A2 F8 P5-EA2-A2	0,07	0,25	1,15	0,45	480 (70)	570 (83)	27	-	70 (52)
	ELIFLUX BAB-S	F8 A4-EA2-A3	0,07	0,55	1,70	0,50	500 (73)	600 (87)	26	-	60 (44)
	ELIFLUX PIPE	F7 A4-EA2-A2	0,06	0,40	1,40	0,50	510 (74)	640 (93)	25	-	60 (44)

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)					Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)		
Wires Name	Flux Name	Standard & Classification AWS A5.23:07	C	Si	Mn	Mo	Ti	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	0 °C (32 °F)	-20 °C (-4 °F)	-30 °C (-22 °F)
S2 Mo TiB	ELIFLUX BFF	F8 A0-EG-G	0,06	0,65	1,85	0,50	0,06	550 (80)	650 (94)	21	60 (44)	45 (33)	-
	ELIFLUX BFB	F9 A2-EG-G	0,06	0,50	1,70	0,50	0,06	580 (84)	660 (96)	28	-	-	60 (44)



Please visit our website for detailed information



GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)			Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)	
Wires Name	Flux Name	Standard & Classification AWS A5.17:97	C	Si	Mn	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	0 °C (32 °F)	-40 °C (-40 °F)
S3 Si	ELIFLUX BFF	F7 A4-EH 12K	0,10	0,35	1,65	490 (71)	580 (84)	26	100 (74)	70 (52)
	ELIFLUX BFB	F7 A4-EH 12K	0,07	0,40	1,80	460 (67)	550 (80)	27	-	60 (44)
	ELIFLUX BAB-S	F7 A4-EH 12K	0,07	0,60	1,70	545 (79)	645 (94)	26	-	60 (44)

GeKa Gas Welding Rods					Chemical Composition of Welding Wire % (Typical)				Mechanical Properties			Charpy V-Notch J (ft-lbf)	Diameter x Length inch (mm)						
Group	Product Name	Standard & Classification	Flame Adjustment	Position	C	Si	Mn	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (68 °F)	3/64 x 39" (1,20 x 1000)	1/16 x 39" (1,60 x 1000)	5/64 x 39" (2,00 x 1000)	3/32 x 39" (2,40 x 1000)	1/8 x 39" (3,20 x 1000)	5/32 x 39" (4,00 x 1000)	13/64 x 39" (5,00 x 1000)
Gas Welding Rods	ELIGAS 1	AWS A5.2:07 R 45	Neutral Flame	F, V, OH, H	0,07	0,1	0,5	-	>245 (>36)	340-440 (49-64)	>14	>35 (26)	+	+	+	+	+	+	+
	ELIGAS 2	AWS A5.2:07 R 60	Neutral Flame	F, V, OH, H	0,07	0,15	1,0	-	>295 (>43)	440-540 (64-78)	>22	>39 (29)	-	-	-	-	-	-	-
	ELIGAS 4	AWS A5.2:07 R 60-G	Neutral Flame	F, V, OH, H	0,07	0,15	1,0	0,5	>295 (>43)	440-540 (64-78)	>22	>39 (29)	-	-	-	-	-	-	-

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)				Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)	
Wires Name	Flux Name	Standard & Classification AWS A5.23:07	C	Si	Mn	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	0 °C (32 °F)	-40 °C (-40 °F)
S3 Mo	ELIFLUX BFF	F8 A4-EA4-A4	0,07	0,50	1,75	0,50	540 (78)	630 (91)	27	110 (81)	65 (48)
	ELIFLUX PIPE	F8 A4-EA4-A4	0,06	0,40	1,60	0,45	530 (77)	620 (90)	25	100 (74)	50 (37)

GeKa Welding Electrodes					Diameter x Length inch (mm)						
Group	Product name	Current Type & Polarity	Position	Features and Applications	1/8 x 14" (3,2 x 350)	5/32 x 14" (4,0 x 350)	3/16 x 14" (5,0 x 350)	15/64 x 12" (6,0 x 305)	5/16 x 12" (8,0 x 305)	25/64 x 12" (10,0 x 305)	15/32 x 12" (12,0 x 305)
Gouging	GROOVE	D.C.(+)	F, V, H, OH	Gouging and removal of old,worn or cracked parts and correction of casting defects. Cleaning defective surfaces and removing faulty welding deposits. Gouging and chamfering all industry metals. Easy striking and restriking, high gouging speed. It burns up impurities,degasses metal, leaving it metalurgically clean operates at all positions, even overhead.	+	+	+	-	-	-	-
Carbon	AIR	D.C.(+)	F, V, H, OH	Cleaning defective surfaces, removing faulty weld deposits,beveling, gouging,elimination of tears,cutting metal parts to required size. Made of copper-plated graphite.Used along with compressed air. Special-type electrode holder is required. Should be held horizontally to work. Able to operate at all positions.	-	-	-	+	+	+	+

GeKa Submerged Arc Welding Wires & Fluxes			Chemical Composition of Weld Metal % (Typical)				Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)	
Wires Name	Flux Name	Standard & Classification AWS A5.23:07	C	Si	Mn	Mo	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	20 °C (68 °F)	-20 °C (-4 °F)
S3 Mo TiB	ELIFLUX PIPE	F8 A0-EA2TiB (mod.)-G	0,06	0,60	1,50	0,40	545 (79)	680 (99)	26	100 (74)	60 (44)

Please visit our website for detailed information



Please visit our website for detailed information



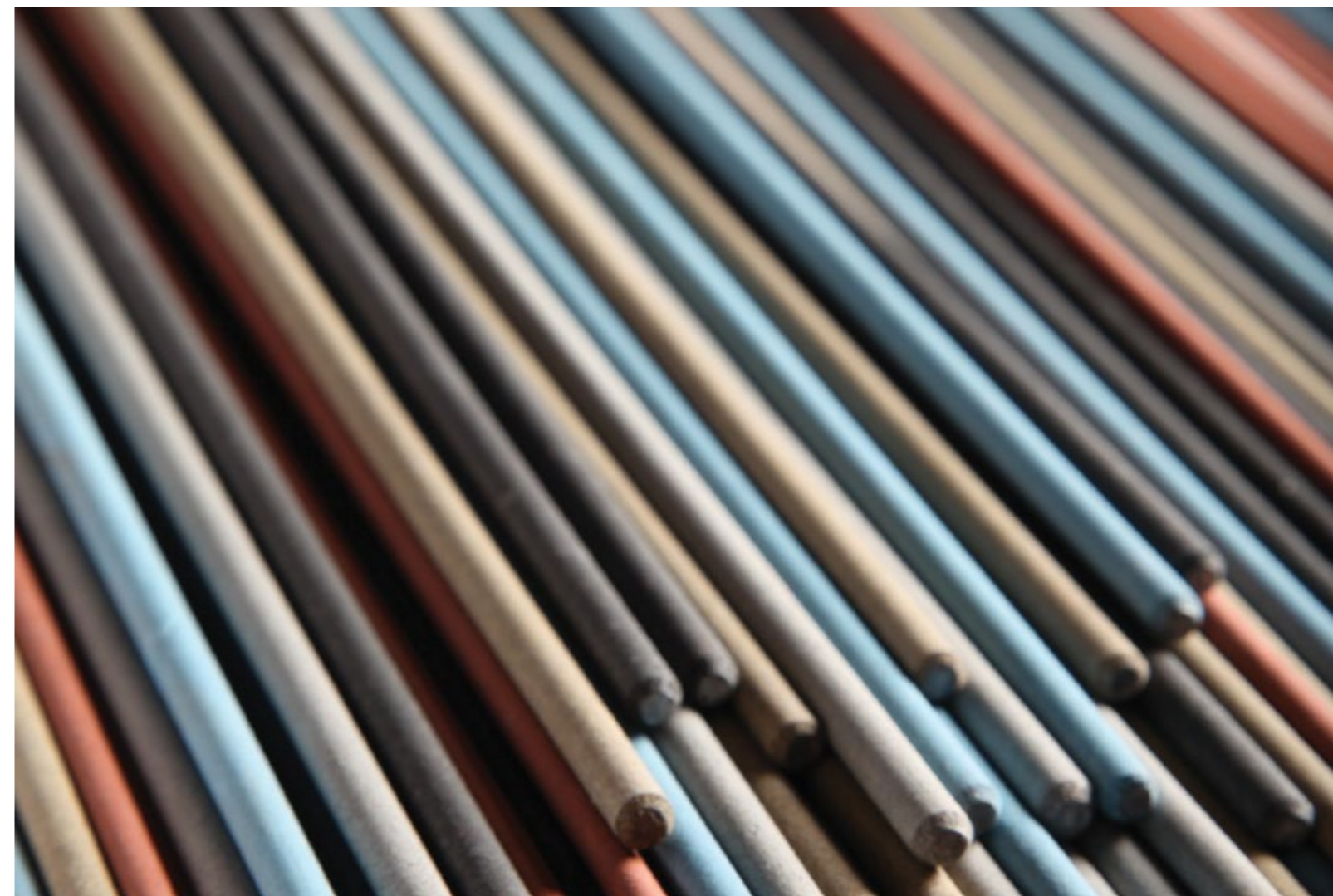
REPAIR & MAINTENANCE AND SPECIAL WELDING PRODUCTS

- Cutting&Gouging Electrodes
- Cast Iron Electrodes
- Steel Electrodes
- Hardfacing Electrodes
- Nonferrous Electrodes
- Nickel-alloyed MIG-TIG Welding Wires
- Titanium-alloyed TIG Welding Rods
- Hardfacing MAG-TIG Welding Rods
- Cobalt Based TIG Welding Rods
- Tungsten Electrodes for TIG Welding
- Welding and Brazing Rods
- Brazing Fluxes



GeKaTec Welding Electrodes					Mechanical Properties			Diameter x Length inch (mm)		
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	Yield Strength MPa (ksi)	Elong. (%)	Hardness (HB)	3/32 x 12" (2,5 x 300)	1/8 x 12" (3,2 x 300)	5/32 x 16" (4,0 x 400)
Cast Iron	Ni - CAST	AWS A5.15:05 E Ni-CI	D.C.(-)	F	>245 (>36)	5	~170	+	+	+
	Fe - CAST	AWS A5.15:05 E NiFe-CI	D.C.(+)	F, V-up, H	>295 (>43)	>10	~190	-	+	+

Please visit our website for detailed information



GeKaTec Welding Electrodes					Mechanical Properties				Diameter x Length inch (mm)			
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	Hardness (HB)	3/32 x 10" (2,5 x 250)	1/8 x 12" (3,2 x 300)	5/32 x 14" (4,0 x 350)	13/64 x 14" (5,0 x 350)
Steel	ANTI-CRACK 7015	AWS A5.11:05 ~E NiCrFe-3	D.C.(+)	F, V-up, OH, H	>360 (52)	660-715 (96-104)	40 - 45	200	+	+	+	+
	299 SUPER	AWS A5.4:05 ~E 312-26	D.C.(+)	F, V-up, OH, H	>450 (65)	790-860 (115-125)	20 - 25	250 - 300	+	+	+	-

GeKaTec Gas Shielded Welding Wires/Rods					Chemical Composition of Welding Wire % (Typical)							Mechanical Properties (Typical)			Charpy V-Notch J (ft-lbf)		Diameter x Length inch (mm)		
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	C	Fe	Mn	Cr	Nb	Mo	Ni	Yield Strength MPa (ksi)	Tensile Strength MPa (ksi)	Elon. (%)	+20 °C (+68 °F)	-196 °C (-320 °F)	1/16 x 39" (1,6 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,4 x 1000)
Nickel Alloyed MIG-TIG	7015 SG	AWS A5.14 ER NiCr-3	MIG D.C.(+) TIG D.C.(-)	F, V-up, OH, H	0,02	4,0	3,0	20,0	2,5	-	rest	400 (58)	650 (94)	40	150 (111)	-	+	+	+
	625 SG	AWS A5.14 ER NiCrMo 3	D.C.(+)	F	0,02	1,0	0,20	22,0	3,50	9,00	rest	540 (78)	800 (116)	38	140 (103)	75 (55)	+	+	+

GeKaTec Repair & Maintenance Products					Mechanical Properties		Diameter x Length inch (mm)		
Group	Product Name	Standard & Classification	Current Type & Polarity	Position	Hardness (HRC)		1/8 x 14" (3,20 x 350)	5/32 x 14" (4,00 x 350)	3/16 x 14" (5,00 x 350)
					Pass 1	Pass 2			
Hardfacing	FAZER 63 HD	AWS A5.13:00 ~E FeCr-A8	D.C.(+/-)	F, OH, H	62 - 64		+	+	+
	FAZER 65 B	EN 14700:06 E Fe 16	D.C.(+) A.C.	F, V-up	61-65	64-68	+	+	-
Tool Steel	TOOL 60	AWS A5.13:00 E Fe5-A	D.C.(+) A.C.	F, OH, H	60 - 62*		+	-	-

* After working hardness

GeKaTec Brazing Rods				Chemical Composition of Welding Wire % (Typical)					Mechanical Properties (Typical)					Diameter x Length inch (mm)					
Group	Product Name	Standard & Classification	Welding Method	Cu	Ni	Sn	Si	Zn	Density Kg/dm ³ (lbm/in ³)	Tensile Strength MPa (ksi)	Elon. (%)	Melting Range °C (°F)	Hardness (HB)	1/16 x 39" (1,5 x 1000)	5/64 x 39" (2,0 x 1000)	3/32 x 39" (2,5 x 1000)	1/8 x 39" (3,0 x 1000)	5/32 x 39" (4,0 x 1000)	13/64 x 39" (5,0 x 1000)
Welding & Brazing Rods	S2	EN ISO 17672: Cu 681	Gas Welding TIG Welding	59,0	-	1,8	0,2	rest	8,4 (0,303)	430 (62)	30	870 - 890 (1598-1634)	110	+			+	+	
	S21	EN ISO 17672: Cu 470	Gas Welding TIG Welding	60,0	-	0,5	0,2	rest	8,4 (0,303)	400 (58)	30	875 - 895 (1607-1643)	100	+	+	+	+	+	+
	S3	EN ISO 17672: ~Cu 773	Gas Welding TIG Welding	52,0	7,0	-	0,3	rest	8,7 (0,314)	690-785 (100-114)	15	890 - 920 (1634-1688)	130	-	+	-	+	+	-

Please visit our website for detailed information



Please visit our website for detailed information



WELDING MACHINES

- MIG-MAG Welding Machines
- Welding Rectifiers
- Mechanical Controlled MMA Welding Machines
- Inverter MMA Welding Machines
- Inverter DC-Pulse MIG-MAG Welding Machines
- Inverter AC/DC – Pulse MIG-MAG Welding Machines
- Inverter DC-TIG Welding Machines
- Inverter AC/DC – TIG Welding Machines
- Submerged Arc Welding Machines
- Plasma Cutting Machines



Gedik Welding succeeded in being the leading organization in our country in the field of the production of welding machines since 1986. Being the first gas metal arc welding machine producing company in Turkey, Gedik Welding experiences the proper proud of providing its customers with quality service with the advantage of possessing the widest network of sales and services throughout the country.

With the acceleration by its quarter of a century long experience in the production of conventional welding machines, Gedik Welding continues also the production of MMA, MIG-MAG, TIG and submerged arc welding machines with the latest inverter technology with the brand of GeKaMac.

Having attained the success of an accomplished sales chart not only in Turkey but also at an international level with its range of products, GeKaMac continues its operations that would increase the quality and the range of its products with the existing Ar-Ge support, continuing to receive positive reactions thanks to its superior quality.



Technical Specs.		PoWer ARC 200 PFC
Input Voltage	V	50/60 Hz, 220 V - %10
Installed Power	kVA	7
Fuse (delayed action)	A	32
Open Circuit Voltage	V	66
Current Range	A	10 - 200
Duty Cycle at (40 °C)	100% 40%	135A 200A
Standards		EN 60974-1 / EN 60974-10
Protection Class	IP	23
Insulation Class		H
Dimensions (L*W*H)	mm	410/146/278
Weight	kg	7

Technical Specs.		PoWer ARC 250
Input Voltage	V	3 Phase, 50/60 Hz 380 V ±%10
Installed Power	kVA	11,6
Fuse (delayed action)	A	16
Open Circuit Voltage	V	95
Current Range	A	30 - 250
Duty Cycle at (40 °C)	100% 60% 45%	180 200 250
Standards		EN 60974-1 / EN 60974-10
Protection Class	IP	21
Insulation Class		F
Dimensions (L*W*H)	mm	410/180/350
Weight	kg	15



Please visit our website for detailed information



Please visit our website for detailed information

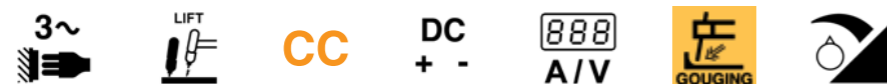


Technical Specs.		RKM 350	RKM 450	RKM 650	RKM 800
Input Voltage	V	3 Phase, 50/60 Hz, 380 V	3 Phase, 50/60 Hz, 380 V	3 Phase, 50/60 Hz, 380 V	3 Phase, 50/60 Hz, 380 V
Installed Power	kVA	15	32	39	51
Fuse (delayed action)	A	42	63	63	80
Open Circuit Voltage	V	38	82	82	85
Current Range	A	5-300	5-450	50-650	5-800
Duty Cycle at (40 °C)	100%	180	270	390	460
	60%	230	350	500	600
	45%	300	450	650	800
Standards		EN 60974-1 EN 60974-10	EN 60974-1 EN 60974-10	EN 60974-1 EN 60974-10	EN 60974-1 EN 60974-10
Protection Class	IP	23	23	23	23
Insulation Class		H	H	H	H
Dimensions (L*W*H)	mm	680/510/460	980/760/660	980/760/660	980/760/660
Weight	kg	101	209	265	297

Technical Specs.		PoWerTECH 4000 Vision Pulse	PoWerTECH 5000 Vision Pulse
Input Voltage	V	3 Phase, 50/60 Hz, 400 ± 20 V	
Installed Power	kVA	25.5	32
Fuse (delayed action)	A	30	40
Open Circuit Voltage	V	70	70
Current Range	A	10-400	10-500
Duty Cycle at (40 °C)	100%	330	380
	60%	370	460
	50%	400	500
Standards		EN 60974-1 / EN 60974-5 / EN 60974-10 / S	
Protection Class	IP	23 S	
Insulation Class		H	
Usable Wire Diameters	ø mm	0.6-1.6	
Dimensions (L*W*H)	mm	660/290/515	660/290/515
Weight	kg	40	44



Please visit our website for detailed information



Please visit our website for detailed information



Technical Specs.		PoWer TIG 200 DC Pulse	
		TIG	MMA
Input Voltage	V	1 Phase 50/60 Hz, 230 V	
Installed Power	kVA	8.5	9.0
Fuse (delayed action)	A	20	20
Open Circuit Voltage	V	88	88
Current Range	A	5-200	5-160
Duty Cycle at (40 °C)	100%	110	105
	60%	130	125
	20%	200	(%30) 160
Standards		EN 60974-1 / EN 60974-3 / EN 60974-10	
Protection Class	IP	23 S	
Insulation Class		F	
Dimensions (L*W*H)	mm	390/135/300	
Weight	kg	7.5	

Technical Specs.		PoWer TIG 400 AC / DC Pulse	
		TIG	MMA
Input Voltage	V	3 Phase 50/60 Hz, 400 V	
Installed Power	kVA	15.3	19.9
Fuse (delayed action)	A	16	16
Open Circuit Voltage	V	65	65
Current Range	A	5-400	5-400
Duty Cycle at (40 °C)	100%	250	250
	60%	320	320
	35%	400	400
Standards		EN 60974-1 / EN 60974-3 / EN 60974-10 / S	
Protection Class	IP	23 S	
Insulation Class		H	
Dimensions (L*W*H)	mm	670/290/525	
Weight	kg	49	



Please visit our website for detailed information



Please visit our website for detailed information



Technical Specs.		GKM 350-G
Input Voltage	V	3 Phase, 50/60 Hz, 380 V
Installed Power	kVA	15.6
Fuse (delayed action)	A	32
Open Circuit Voltage	V	18-47
Current Range	A	30-350
Duty Cycle at (40 °C)	100%	230
	60%	300
	40%	350
Standards		EN 60974-1 / EN 60974-5 / EN 60974-10 / S
Usable Wire Diameters	mm	0.8 - 1.0 - 1.2
Protection Class	IP	23
Insulation Class		H
Dimensions (L*W*H)	mm	930/480/900
Weight	kg	125

Technical Specs.		GKM 420-2W	GKM 500-2W
Input Voltage	V	3 Phase, 50/60 Hz, 380 V	3 Phase, 50/60 Hz, 380 V
Installed Power	kVA	17.6	27.5
Fuse (delayed action)	A	42	63
Open Circuit Voltage	V	13-43	16-57
Current Range	A	30-420	40-500
Duty Cycle at (40 °C)	100%	280	390
	60%	360	500
	45%	420	
Standards		EN 60974-1 / EN 60974-5 / EN 60974-10 / S	EN 60974-1 / EN 60974-5 / EN 60974-10 / S
Protection Class	IP	23	23
Isolation Class		H	H
Dimensions (L*W*H)	mm	1075 / 500 / 800	1100 / 510 / 1440
Weight	kg	162	211
Wire Feeder Unit			
Usable Wire Diameters		0.8 / 1.0 / 1.2	0.8 / 1.0 / 1.2 / 1.6
Wire Types	ø mm	Fe / FC	Fe / FC
Wire Feeding Speed		22 max	22 max
Dimensions (L*W*H)	m/min	630/460/230	630/460/230
Weight	kg	15	15



Please visit our website for detailed information



Please visit our website for detailed information



Technical Specs.		PoWer MIG GPS 270 C
Input Voltage	V	3 Phase, 50/60 Hz, 400 ±15 V
Installed Power	kVA	13.6
Fuse (delayed action)	A	32
Open Circuit Voltage	V	81
Current Range	A	30-300
Current Tension Range	V	12-30
Duty Cycle at (40 °C)	100% 60% 40%	170 220 270
Standards		EN 60974-1 / EN 60974-5 / EN 60974-10 / S
Usable Wire Types		Fe / Al / SS / Cu
Usable Wire Diameters	ø mm	0.8/0.9/1.0/1.2
Protection Class	IP	23
Isolation Class		H
Dimensions (L*W*H)	mm	640/300/600
Weight	kg	49

Technical Specs.		PoWer MIG GPS WB 400	
Input Voltage	V	3 Phase, 50/60 Hz, 400 ±15 V	
Installed Power	kVA	19.2	
Fuse (delayed action)	A	27.6	
Open Circuit Voltage	V	70	
Current Range	A	30-400	
Current Tension Range	V	12-34	
Duty Cycle at (40 °C)	50%	400	
Standards		EN 60974-1 / EN 60974-5 / EN 60974-10 / S	
Protection Class	IP	23	
Isolation Class		H	
Dimensions (L*W*H)	mm	395 / 710 / 592	
Weight	kg	62	
Wire Feeder Unit			
Wire Feeder Units		CM-7401	CMA-7401
Wire Types		Fe / FC	Al
Usable Wire Diameters	ø mm	0.8/0.9/1.0/1.2/1.4/1.6	1.0/1.2/1.6
Wire Feeding Speed	m/min	22 max.	
Dimensions (L*W*H)	mm	207/588/372	
Weight	kg	17	



Please visit our website for detailed information



Please visit our website for detailed information



Technical Specs.		PoWer CUT 61	PoWer CUT 100	PoWer CUT 150
Input Voltage	V	3 Phase 50/60 Hz, 400 V, + 15% -20%	3 Phase 50/60 Hz, 400 V, ± 20%	3 Phase 50/60 Hz, 400 V, ± 20%
Installed Power	kVA	7.5	14.1	29
Delayed Fuse	A	10	16	32
Current Range	A	20-60	20-100	20-150
Cutting Capacity	mm	Severence : 20 Quality : 15	Severence : 30 Quality : 25	Severence : 50 Quality : 40
Duty Cycle at (40 °C)	100% 60% 40%	40 50 60	70 85 100	100 120 150
Standards		EN 60974-1 / IEC 60974-3 / EN 60974-7 / EN 60974-10 / S		
Protection Class	IP	23 S	23 S	23 S
Insulation Class		H	H	H
Dimensions (L*W*H)	mm	540/220/425	610/220/425	670/290/520
Weight	kg	23	32	48

Technical Specs.		TKM 1250 Carriage
Welding Current	A	1250
Control Voltage	V/Hz	42 AC / 50
Input Current	A	3
Applicable Wire Diameter	mm	2.4 – 4.8
Wire Feed Speed	cm/min	34 – 340
Tractor Speed	cm/min	15 – 125
Height Adj. (H x W)	mm	100 / 120
Column Swivel Range	Degree	360°
Welding Head Inclination	Degree	45° (both sides)
Flux Capacity	Lt	8
Wire Reel Capacity	kg	25
Weight	kg	68
Dimensions (L*W*H)	mm	900/520/850

Technical Specs.	Power Source
Model	TKM 1250
Input Voltage	3 x 380 V +-10 % 50 Hz
Installed Power %100 D.C.	88 kVA
Fuse	125 A
Welding Current Voltage Range	250 A/30 V - 1250 A/44 V
Duty Cycle at %100	1250 A
Open Circuit Voltage	72 V
Protection Class	IP 21 S
Weight	510 kg
Dimensions (L*W*H) mm	980/670/1000

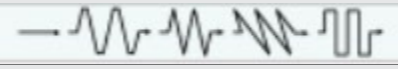


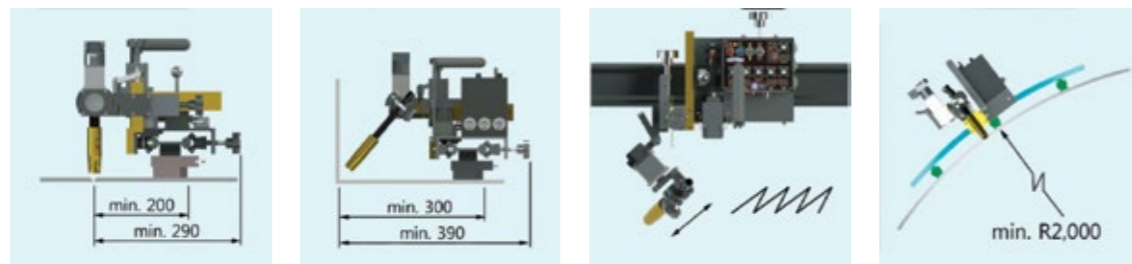
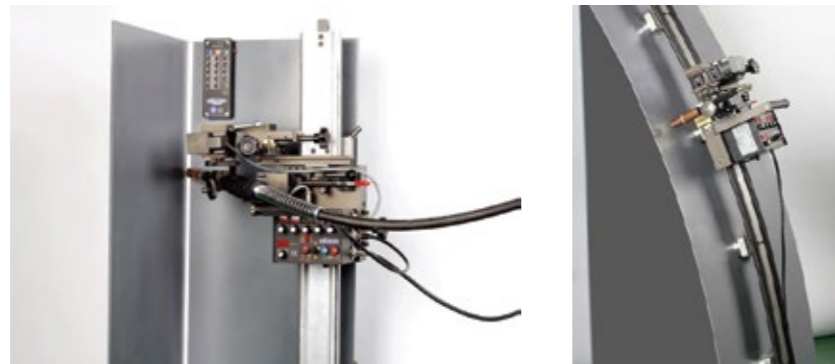
Please visit our website for detailed information



Please visit our website for detailed information

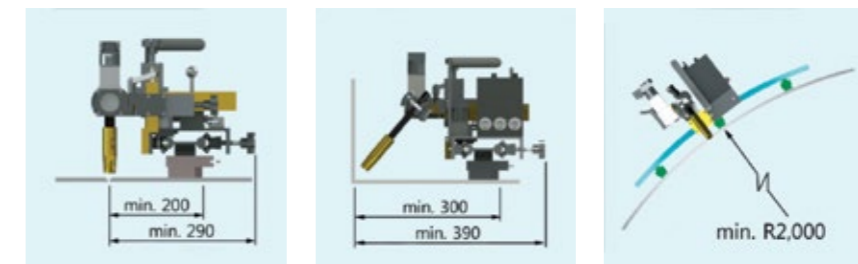
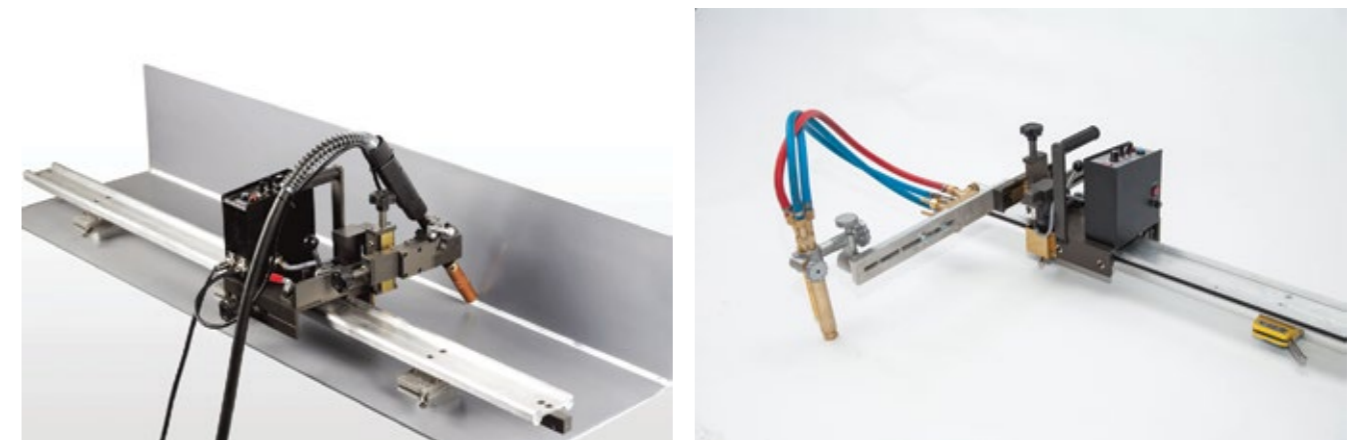


Technical Specs.		Automat M11
Input Voltage	V	AC 110-230V 50/60 Hz, 1 Phase
Travel Speed	mm/min	0-750
Travel Mechanism		Rack-Pinion, Geared Motor
Motor Type	v, w, rpm	DC 24V, 12W, 5000
Reducer		1:400
Torch Adjustable Angle	mm	0-50
X-Y Slide Stroke	mm	0-50
Extended Torch X-Y Slide Stroke	mm	0-150
Weaving Motor Type	v, w, rpm	DC 24V, 12W, 5000
Weaving Reduce Rate		1:1000
Weaving Speed	rpm	0-5
Weaving Width Angle		Max. 15j
Weaving Left / Right Stop Time	Second	0-9.9
Weaving Mode		
Dimensions (L*W*H)	mm	284/330/240
Weight	kg	7



Please visit our website for detailed information

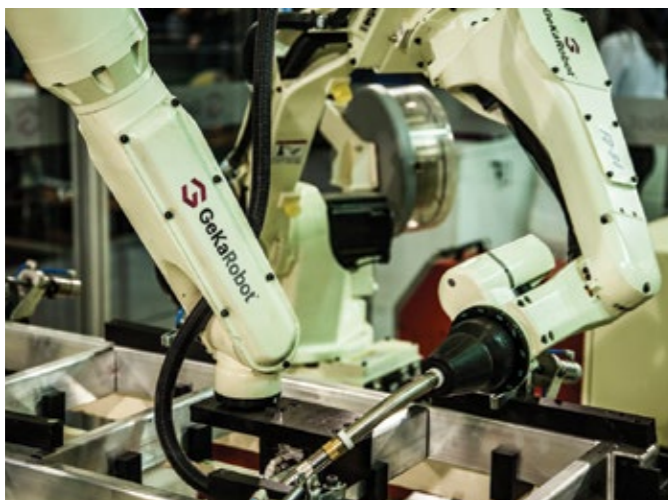
Technical Specs.		Automat M12
Input Voltage	V	AC 110-230V 50/60 Hz, 1 Phase
Travel Speed	mm/min	0-750
Travel Mechanism		Rack-Pinion, Geared Motor
Motor Type	v, w, rpm	DC 24V, 12W, 5000
Reducer		1:400
X-Y Slide Stroke	mm	0-50
Extended Torch X-Y Slide Stroke	mm	0-50
Rapid slide stroke	mm	0-150
Gear Clutch		Manuel Moving Clutch
Dimensions (L*W*H)	mm	284/330/240
Weight	kg	6



Please visit our website for detailed information



















Leading Technology in Robotic Welding and Automation...

GeKaRobotics which is established in 2008 provides robotic automation and application in several industrial fields in Turkey. Along with the R&D activities GeKaRobotics has become a successful robot integrator company.



ROBOT INTEGRATION

- Field Survey
- Design and Simulation
- Robotic Application
- Robotic MIG-TIG Welding
- Robot Welding Training

-  GL : Germanisher Lloyd
-  DB : Deutsche Bundes Bahn
-  ABS : American Breau of Shipping
-  TL : Turkish Lloyd
-  RS : Russian Maritime Register of Shipping
-  LRS : Lloyd's Register of Shipping
-  BV : Breau Veritas
-  DNV : Det Norske Veritas
-  CWB : Canadian Welding Breau
-  ISCIR : Romania Certification
-  TSE : TSE Document
-  RINA : Registro Italiano Navale
-  CLASS NK : Nippon Kaiji Kyokai
-  TÜV : VD TUV Certificate
-  ARAMCO : Saudi Arabian Approval Authority
-  NACE : National Association of Corrosion Engineers
-  GOST-R : Russian Quality Certificate
-  UkrSEPRO : Ukraine Russia Federation

Double Major Diploma from Gedik...

Gedik Educational Foundation (GEV) provides regular education and training programmes for;

- International Welding Engineers (IWE)
- International Welding Technicians (IWT)
- International Welding Inspectors (IWIP)

JOIN US TO ADD ONE NEW EXPERTISE AND DIPLOMA...



GEV - Associated Member of IIW and EWF in Turkey



www.gedikegitimvakfi.org.tr

Istanbul Gedik University

Starting point
of your career...



FACULTY OF ARCHITECTURE AND FINE ARTS

- Architecture
- Fashion and Textile Design
- Interior Architecture and Environmental Design
- Visual Communication Design

FACULTY OF ECONOMICS ADMINISTRATIVE AND SOCIAL SCIENCES

- Political Sciences and Public Administration
- International Relations
- International Trade and Finance

FACULTY OF ENGINEERING

- Electrical-Electronics Engineering
- Mechanical Engineering
- Mechatronics Engineering
- Metallurgical and Material Engineering

FACULTY OF SPORT SCIENCES

- Coaching Education
- Physical Education and Sports Education
- Sports Management

VOCATIONAL SCHOOL PROGRAMS

- | | | |
|-------------------------------------|------------------|----------------------------------|
| - Accounting and Tax Applications | - Electricity | - Medical Imaging Technologies |
| - Banking and Insurance | - Foreign Trade | - Non-Destructive Testing |
| - Biomedical Equipment Technologies | - Graphic Design | - Occupational Health and Safety |
| - Chemical Technologies | - Justice | - Public Relations and Publicity |
| - Civil Aviation Cabin Services | - Mechanics | - Welding Technology |
| - Computer Programming | - Mechatronics | |

FOREIGN LANGUAGES VOCATIONAL COLLEGE

JOIN US FOR BETTER EDUCATION AND RESEARCH...

www.gedik.edu.tr

Your Certificate of Expertise from Gedik...

Gedik Test Center offers destructive and non destructive tests in the fields of pipeline production, shipbuilding, steel construction, energy and automotive industries.

Participants of training and certification programs receive TS-EN ISO 9712 international non-destructive expertise certificate approved by TURKAK with accreditation according to TS EN ISO / IEC 17024 standards.



www.gediktest.com

Metal finds its form at Gedik Casting...

Gedik Casting and Valves

operates since 1967 in the fields of

- Sand Casting
- Investment Casting
- Production of Valves

The valve division has production capacity of approx. 250.000 pieces of various sizes and types of valves per year under the brand name of TERMO®.

The valves are used for heating, ventilation, steam, hot water, hot oil, natural gas and all kinds of chemical fluids in industrial plants, power plants, chemical, petrochemical and shipbuilding industries.



www.gedikdokum.com

Gedik Welding

Gedik Kaynak Sanayi ve Tic. A.Ş.
Ankara Caddesi No:306 Şeyhli 34906 Pendik - İstanbul / Turkey
P +90 216 378 50 00 F +90 216 378 20 44 info@gedikwelding.com
www.gedikwelding.com

Gedik Casting and Valve

Gedik Döküm ve Vana San. ve Tic. A.Ş.
Ankara Caddesi No:306 Şeyhli 34906 Pendik - İstanbul / Turkey
P +90 216 307 12 62 F +90 216 307 28 68-69 termo@gedikdokum.com.tr
Manufacturing Plant
Sakarya 2.OSB 11 No'lu Yol No: 6 54300 Hendek - Sakarya / Turkey
P +90 264 290 12 00 F +90 264 290 12 21 dokum@gedikdokum.com.tr
www.gedikdokum.com

Gedik Educational Foundation

Gedik Eğitim ve Sosyal Yardımlaşma Vakfı
Ankara Caddesi No:306 Şeyhli 34906 Pendik - İstanbul / Turkey
P +90 216 452 45 85-86-87 F +90 216 595 21 55 gev@gedikegitimvakfi.org.tr
www.gedikegitimvakfi.org.tr

Gedik Test Center

Gedik Test Merkezi
Ankara Caddesi No:306 Şeyhli 34906 Pendik - İstanbul / Turkey
P +90 216 378 79 41 F +90 216 378 20 44 info@gediktest.com
www.gediktest.com

İSTANBUL Gedik University

İstanbul Gedik Üniversitesi
Cumhuriyet Mahallesi, İlbahar Sokak No: 1 34876 Yakacık-Kartal-İstanbul / Turkey
P +90 216 452 45 85 F +90 216 452 87 17 info@gedik.edu.tr
www.gedik.edu.tr



Gedik Welding

Joining Since 1963...

Gedik Welding Inc.

Ankara Caddesi No: 306 Şeyhli 34906 Pendik - İstanbul / Turkey

P +90 216 378 50 00 F +90 216 378 20 44

www.gedikwelding.com gedik@gedik.com.tr