

SARMA PLINA

SOLID WIRE



Tipuri de role

Bobine din material plastic

Bobinele plastice sunt notate: S 200 - S 300 (diametru: 200 mm sau 300 mm) Cantitatea de sarma este mentinuta de doua flansi rigide sustinute de mai multe raze si un butuc.

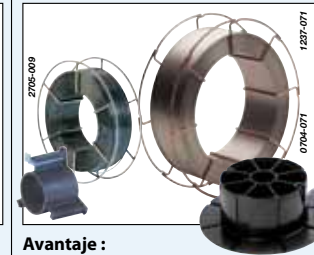


Avantaje:

- suport rigid pentru o excelenta mentinere a cantitatii de sarma,
- nu necesita adaptor.

Bobine metalice

Bobine standard: B 200 sau B 300 (diametru: 200 mm sau 300 mm) Cantitatea de sarma este mentinuta de doua flansi nerigidizate central.



Avantaje :

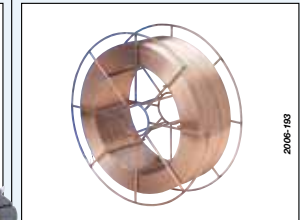
- reciclabil, deci ecologic,
- economic. Necesita un adaptor.

Adaptor pentru B 200 **S1090-4555**

Adaptor pentru B 300 **S1090-4556**

Bobine metalice cu butuc: BS 300

Cantitatea de sarma este mentinuta de doua flansi rigidizate cu un butuc.



Avantaje :

- o mai buna mentinere a sarmei,
- reciclabil, deci ecologic,
- nu necesita adaptor,
- posibilitatea de a fixa un clips metalic de antrenare.

Cele doua tipuri de bobinare a sarmei:

Bobinare SS („spira langa spira”)

Risc de tensionare a spirelor acoperite, provocat de acumularile de presiune rezultate intre toleranta geometrica a sarmei si largimea rolei de sarma.

Bobinare SR (spire „ordonate”)

Caracterul aleatoriu al infasurarii spirelor provoaca o incrucisare a acestora si permite acoperirea celor de mai jos. Devidajul este astfel mai fiabil.

Butoaie

Butoi cilindric ENDURO



Butoi dreptunghiular PACKMATIC



CLASIFICARE / STANDARDS

AWS A5.18-93:	ER70S-6
EN ISO 14341-A:	G423 C G3Si1
EN ISO 14341-A:	G424 M G3Si1

AUTORIZARI / APPROVALS

TÜV:	G42 2(M)G 3Si1	GL:	3YS
DB:	42.116.01	RINA:	SG42-52A3
ABS:	3SA-3YSA	BV:	SA3M-SA3YM

CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitile. Se utilizeaza ca gaz de protectie Ar/CO₂, Ar/CO₂/O₂ sau CO₂. Indicat pentru sudarea intr-o singura sau mai multe treceri a otelurilor nealiate, cu rezistenta de rupere la tractiune pana la 560 N/mm² (tip SG55J2G3 EN 10025 FE 510/St52 sau similar). Arc electric stabil, stropire redusa, aspect estetic al cordonului.

MAIN FEATURES

Copper coated solid wire for GMAW welding in all position. To be used with Ar/CO₂, Ar/CO₂/O₂, or CO₂ shielding gas. Suitable for single pass or multipass welding of non alloy steels, with tensile strength up to 560 N/mm², type SG55J2G3 EN 10025 (FE 510/St 52) and similar. Stable electric arc, good extetical bead, very low spatters.

DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica); Industria constructoare de masini; Constructii metalice; Fabricarea tevilor; Constructia autovehiculelor si aplicatii electrocasnice; Constructii feroviare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry); Industrial machinery construction; Metal working industry; Pipes fabrication; Car, bus production and electro-domestic appliances; Coachbuilders.

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂ - Ar / CO₂ / O₂ - CO₂ M2, M3, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cu				
0.06 - 0.13	1.3 - 1.6	0.70 - 1.00	≤ 0.025	≤ 0.025	0.25				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -30°C	Kv J -40°C
Ar/CO ₂ (M21)	Stare sudată/As welded	510 - 560	≥ 430	≥ 24	≥ 70	≥ 47
CO ₂	Stare sudată/As welded	510 - 560	≥ 430	≥ 24	≥ 47	

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm							
		0.6	0.8	1.0	1.2	1.6			
B 300	16 kg	W000282634	W000282640	W000282651	W000282660	W000282669			
B 300/SS	16 kg		W000282641	W000282652	W000282661	W000282670			
S 300	15 kg		W000282638	W000282649	W000282658	W000282667			
S 300/SS	15 kg		W000282639	W000282650	W000282659	W000282668			
S 200	5 kg	W000282632	W000282636	W000282647					
SQPA	250 kg		W000282645	W000282656	W000282665				
Drum	200 kg					W000282673			
Drum	400 kg		W000282644	W000282655	W000282664				

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

CLASIFICARE / STANDARDS

AWS A5.18-93:	ER70S-6
EN ISO 14341-A:	G463 C G4Si1
EN ISO 14341-A:	G464 M G4Si1

AUTORIZARI / APPROVALS

TÜV:	SG 3C 5732
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CARACTERISTICI PRINCIPALE

Sarma plina cuprata pentru sudare in mediu de gaz protector in toate pozitile. Se utilizeaza ca gaz de protectie Ar/CO₂, Ar/CO₂/O₂ sau CO₂. Indicat pentru sudare intr-o singura sau mai multe treceri a otelurilor nealiate, pentru oteluri carbon si pentru oteluri cu granulatie fina, cu rezistenta de rupere la tractiune pana la 590 N/mm² (tip S355J2G3 EN 10025 FE 510/St52 sau similar). Continutul mai mare de Si-Mn imbunatateste caracteristicile mecanice si deoxidarea metalului depus, ceea ce conduce la o puritate mai mare a metalului si reduce efectul impuritatilor.

MAIN FEATURES

Copper coated solid wire to be used for GMAW welding in all position. To be used with Ar/CO₂, Ar/CO₂/O₂ or CO₂ shielding gas. Suitable for single pass or multipass welding of non alloy steels, for C-Mn steels and for fine grain steels, with tensile strength up to 590 N/mm² (type S355J2G3 EN 10025 FE 510/St52 and similar). The higher Si-Mn content improves high mechanic characteristic and a moderately deoxidizer deposit and so less sensible to defectiveness derivables from possible presence of mill scale or other impurities in the parent metal.

DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica); Industria constructoare de masini; Constructii metalice; Fabricarea tevilor; Constructia autovehiculelor si aplicatii electrocasnice; Constructii feroviare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry); Industrial machinery construction; Metal working industry; Pipes fabrication; Car, bus production and electro-domestic appliances; Coachbuilders; Rolling stock construction.

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂ - Ar / CO₂ / O₂ - CO₂ M2, M3, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cu				
0.06 - 0.10	1.61 - 1.75	0.80 - 1.00	≤ 0.025	≤ 0.025	≤ 0.24				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -30°C	Kv J -40°C
Ar/CO ₂ (M21)	Stare sudată/As welded	530 - 650	≥ 460	≥ 24	≥ 80	≥ 70
CO ₂	Stare sudată/As welded	530 - 650	≥ 460	≥ 24	≥ 47	

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm						
		0.8	1.0	1.2	1.6			
B 300	16 kg	W000282797	W000282804	W000282811				
B 300/SS	16 kg	W000282798	W000282805	W000282812				
Drum	300 kg	W000282801	W000282808	W000282815				

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CLASIFICARE / STANDARDS

AWS A5.28-96: ER90S-G
EN ISO 16834-A: G 55 2 M Mn 3 Ni Cr Mo

AUTORIZARI / APPROVALS

DB: 42.116.28

CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliata cu Ni-Cr-Mn, pentru sudare in mediu de gaz protector in toate pozitiile de sudare. Se recomanda a se utiliza in amestec de gaze (Ar/CO₂) dar poate fi utilizata si in mediu de CO₂. Poate fi utilizata pentru sudarea otelurilor slab aliata, cu limita de curgere de 550 N/mm² si cu o rezistenta la rupere de 750 N/mm² (tip T1, N.A.ETRA, VELDOX sau similare). Poate fi utilizata si cand sunt necesare inalte caracteristici de tenacitate la temperaturi scazute. Pentru a fi obtinute cele mai bune rezultate se recomanda sudarea cu o energie liniara cat mai mica.

MAIN FEATURES

Copper coated low alloy wire with Ni-Cr-Mn, for GMAW welding in all positions. To be used preferably with Ar/CO₂ shielding gas, but it can be used with CO₂ too. Suitable for single pass or multipass welding of low alloy steels, with minimum yield strength of 550 N/mm² and with tensile strength up to 750 N/mm² (type T1, N.A.ETRA, VELDOX and similar). It can be used also when good toughness characteristic in low temperature are required. To obtain the best result, the use with low heat input is advised. Good extetical bead and low spatters.

DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica); Industria constructoare de masini; Constructii metalice.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry); Industrial machinery construction; Metal working industry.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂-CO₂ (M2) (C1) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
≤ 0.12	1.30 - 1.80	0.60 - 0.80	≤ 0.018	≤ 0.015	0.50 - 0.60	0.40 - 0.60	0.15 - 0.30	0.30	

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -40°C
Ar/CO ₂ (M21)	Stare sudată/As welded	650 - 750	≥ 600	≥ 16	≥ 50

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm				
		1.0	1.2	1.6	2.0	
B 300/SS	16 kg	W000282917	W000282919			
Drum	300 kg	W000282918	W000282920			

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CLASIFICARE / STANDARDS

AWS A5.28-96: ER100S-G
EN ISO 16834-A: G 69 4 M Mn 3 Ni 1 Cr Mo

AUTORIZARI / APPROVALS

DB: 42.116.20

CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliata cu Ni-Cr-Mn, pentru sudarea in mediu de gaz protector. Se recomanda a se utiliza de preferinta in mediu de Ar/CO₂ dar poate fi utilizata de asemenea si in mediu de CO₂. Poate fi utilizata pentru sudarea otelurilor slab aliata, cu limita de curgere de 650 N/mm² si cu o rezistenta la rupere de 850 N/mm² (tip T1, T1A, T1B, N.A.ETRA65-70, VELDOX700, HY80, HY90, BH65-70, S690 Q(EN 10132-2) sau similare). Poate fi utilizata si cand sunt necesare inalte caracteristici de tenacitate la temperaturi scazute. Pentru a fi obtinute cele mai bune rezultate se recomanda sudarea cu o energie liniara cat mai mica.

MAIN FEATURES

Copper coated low alloy wire with Ni-Cr-Mn, for GMAW welding in all positions. To be used preferably with Ar/CO₂ shielding gas, but it can be used with CO₂ too. Suitable for single pass or multipass welding of low alloy steels, with minimum yield strength of 650 N/mm² and with tensile strength up to 850 N/mm² (type T1, T1A, T1B, N.A.ETRA65-70, VELDOX700, HY80, HY90, BH65-70, S690 Q(EN 10132-2) and similar). It can be used also when good toughness characteristic in low temperature are required. To obtain the best result, the use with low heat input is advised. Good extetical bead and low spatters.

DOMENII DE APLICATIE

Constructii navale, boilere (inclusiv cele din industria petrochimica); Industria constructoare de masini; Constructii metalice; Platforme marine.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry); Industrial machinery construction; Metal working industry; Off-shore fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂-CO₂ (M2) (C1) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
≤ 0.12	1.40 - 1.80	0.40 - 0.70	≤ 0.015	≤ 0.015	1.40 - 1.60	0.20 - 0.30	0.20 - 0.30	≤ 0.35	0.07 - 0.130

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -40°C
ArCO ₂	Stare sudată/As welded	750 - 850	≥ 690	≥ 17	≥ 50

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm				
		1.0	1.2			
B 300/SS	16 kg	W000282931	W000282933			
Drum	300 kg	W000282932	W000282934			

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CLASIFICARE / STANDARDS

AWS A5.28-96: ER 80S-Ni 1
EN 440: G 46 6 M G3 Ni

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Sarma plina cuprata, slab aliata cu Ni recomandata pentru sudarea otelurilor cu granulatie fina si rezistente la temperaturi scazute. Se sudeaza in protectie de gaz Ar/CO₂.

MAIN FEATURES

Copper coated low alloy wire with Ni, for welding alloy steels requiring good toughness at low temperature. To be used preferably with Ar/CO₂ shielding gas.

DOMENII DE APLICATIE

Vase sub presiune, boilere;
Industria chimica si petrochimica;
Fabricarea tevilor;
Platforme marine.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication;
Off-shore work.

POZITII DE SUDARE / WELDING POSITIONS

CURENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂ (80%Ar+20%CO₂)
(M2) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.05 - 0.12	1.00 - 1.25	0.50 - 0.80	≤ 0.020	≤ 0.020	0.80 - 1.10	≤ 0.15	≤ 0.15	≤ 0.03	≤ 0.35

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -60°C
Ar/CO ₂	Stare sudată/As welded	≥ 550	≥ 470	≥ 20	≥ 27

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
B 300/SS	16 kg	W000283680	W000283682		

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CLASIFICARE / STANDARDS

AWS A5.28-96: ER 70S-A1
EN 440-94: G2Mo
EN ISO 21952-A: G Mo Si

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Sarma plina cuprata, aliata cu 0,50 % Mo, pentru oteluri rezistente la 450°C utilizate in centrale termice si instalatii petrochimice, destinata de asemenea reconditionarii prin sudare a pieselor. Destinata sudarii otelurilor cu compozitie chimica similara cum ar fi table tip ASTM 204 si tevi A335-P1. Se poate utiliza ca gaz de protectie CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated solid wire, 0,50 % Mo alloyed, for heat resisting steels, up to 450°C, used in thermal or thermic and petrochemical applications: Suitable also for facing on casting, for casting repairs. Suitable for heat resisting steels, such as plate ASTM 204 e pipe A335-P1 or casting with same composition. Can be used with Ar/CO₂ Mix or CO₂ shielding gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica, petrochimica;
Fabricarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS

CURENT / CURRENT: DC+

GAZ / GAS: Ar / CO₂-CO₂
M2, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAZ	C	Mn	Si	S	P	Mo	Ni	Cu	Cr
Mix/CO ₂	≤ 0.12	0.70 - 1.30	0.50 - 0.70	≤ 0.020	≤ 0.020	0.40 - 0.60	≤ 0.15	≤ 0.35	0.20

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -20°C
Mix	Stare sudată/As welded	≥ 560	≥ 460	≥ 22	≥ 47
Mix	Dupa/After 620°C x 1h	≥ 515	≥ 400	≥ 24	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
B 300/SS	16 kg	W000282953	W000282954		

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FILCORD 36 E

SARMA PLINA CUPRATA / COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

EN ISO 21952-A:	G Cr Mo 1 Si
AWS A5.28-96:	ER 80S-G

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina cuprata, aliata cu 1,25% Cr - 0,50% Mo, pentru oteluri rezistente pana la 550°C utilizate in instalatii termice si petrochimice, putand fi utilizata si pentru reconditionarea prin sudare a pieselor. Indicata pentru sudarea otelurilor termorezistente de compozitie chimica similara, ca A335-P11. Poate fi utilizata si pentru sudarea otelurilor Cr-Mo cu oteluri carbon si sudarea otelurilor de tip 13 Cr Mo 44. Se poate utiliza ca gaz de protectie CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated solid wire, 1,25% Cr - 0,50% Mo alloyed, for heat resisting steels, up to 550° C, used in thermal or thermic and petrochemical applications. Suitable also for facing on casting, for casting repairs. Suitable for heat resisting steels, such as A335-P11 or casting with same composition. Suitable for Cr-Mo vs Carbon steel dissimilar joint and for welding of steel type 13 Cr Mo 44. Can be used with Ar/CO₂ Mix or CO₂ shielding gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica, petrochimica;
Fabricarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+
GAZ / GAS: Ar / CO₂-CO₂
M2, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAZ	C	Mn	Si	S	P	Cr	Mo	Cu	Ni
Mix/CO ₂	0.08 - 0.14	0.80 - 1.20	0.50 - 0.80	≤ 0.020	≤ 0.020	0.90 - 1.30	0.40 - 0.65	≤ 0.30	0.30

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -20°C
Mix	Dupa/After 620°C x 1h	≥ 510	≥ 420	≥ 20	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
B 300/SS	16 kg	W000282961	W000282962		

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILCORD 37 E

SARMA PLINA CUPRATA / COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

EN ISO 21952-A:	G Cr Mo 2 Si
AWS A5.28-96:	ER 90S-G

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina cuprata, aliata cu 2,25% Cr - 1,00% Mo, pentru oteluri rezistente pana la 600° C utilizate in instalatii termice si petrochimice, putand fi utilizata si pentru reconditionarea prin sudare a pieselor. Indicata pentru sudarea otelurilor rezistente la temperatura, de compozitie chimica similara, ca A335-P22. Se poate utiliza ca gaz de protectie CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated solid wire, 2,25% Cr - 1,00% Mo alloyed, for heat resisting steels, up to 600° C, used in thermal or thermic and petrochemical applications. Suitable also for facing on casting, for casting repairs. Suitable for heat resisting steels, such as A335-P22 or casting with same composition. Can be used with Ar/CO₂ Mix or CO₂ shielding gas.

DOMENII DE APLICATIE

Cazangerie;
Industria chimica, petrochimica;
Fabricarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication;
Chemical, petrochemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+
GAZ / GAS: Ar / CO₂-CO₂
M2, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAZ	C	Mn	Si	S	P	Cr	Mo	Cu	Ni
Mix/CO ₂	0.04 - 0.12	0.80 - 1.20	0.50 - 0.80	≤ 0.020	≤ 0.020	2.30 - 3.00	0.90 - 1.20	≤ 0.30	0.30

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -20°C
Mix	Dupa/After 720°C x 1h	≥ 580	≥ 500	≥ 20	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
B 300/SS	16 kg	W000282965	W000282966		

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

CLASIFICARE / STANDARDS

AWS A 5.28-96:	ER80S-G
EN ISO 14341:	G 46 2 M G0

AUTORIZARI / APPROVALS

TÜV:	ER80S-G (AWS A5:28)
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CARACTERISTICI PRINCIPALE

Sarma plina cuprata slab aliată pentru sudare GMAW a oțelurilor rezistente la coroziune atmosferică (tip Corten, Itacor, Patinax, Resista). Datorită conținutului de Cu-Cr-Ni garantează o sudură cu bune caracteristici de rezistență la coroziune atmosferică similară celei a materialului de bază sudat. De asemenea se recomandă la sudarea structurilor metalice externe ca poduri, macarale, instalații și tubulaturi de fum. Se poate utiliza ca gaz de protecție CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated wire low-alloyed for GMAW welding of self protective steels (type Corten, Itacor, Patinax, Resista). The Cu-Cr-Ni content ensures a welding with good resistance to atmospheric corrosion such as to parents metal. Also suitable for external applications as bridges, cranes, fumes installations and pipes. To be used with Ar/CO₂ Mix or CO₂ shielding gas.

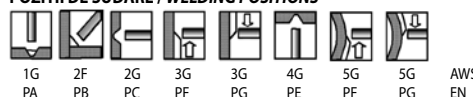
DOMENII DE APLICATIE

Cazangerie (inclusiv industria chimică și petrochimică);
Industria constructoare de mașini;
Construcții metalice.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Industrial machinery construction;
Metal working industry.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+
GAZ / GAS: Ar / CO₂ - Ar / CO₂/O₂ - CO₂
M2, M3, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAZ	C	Mn	Si	S	P	Cu	Ni	Cr
Mix	0.05 - 0.12	1.20 - 1.80	0.70 - 0.90	≤ 0.025	≤ 0.025	0.30 - 0.65	0.70 - 0.90	0.15

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -20°C
Ar/CO ₂ (M21)	Stare sudată/As welded	550 - 650	≥ 420	≥ 24	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
B 300/SS	16 kg	W000282869	W000282872		
Drum	300 kg	W000282870			

Datele menționate pot fi modificate fără o notificare prealabilă. / The above data may change without prior notice.

CLASIFICARE / STANDARDS

AWS A5.9-93:	ER 307
EN ISO 14343-A:	G 18 8 Mn

AUTORIZARI / APPROVALS

DB:	43.116.05
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CARACTERISTICI PRINCIPALE

Sarma plina aliată cu Ni-CR-Mn, destinate sudării MIG a oțelurilor de tip AISI 307, a realizării îmbinărilor între oțeluri carbon și oțeluri inox sau a oțelurilor austenitice manganoase. Poate fi folosită de asemenea pentru sudarea oțelurilor greu sudabile, a oțelurilor cu un procent de 13% Mn, și a altor tipuri de oțeluri. Este de asemenea recomandată și pentru realizarea primelor straturi în cazul încărcărilor. Metalul depus este pur austenitic, cu o mare rezistență la abraziune. Se recomandă a se utiliza în amestec de gaz (Ar/1-2%O₂).

MAIN FEATURES

Solid wire Ni-Cr-Mn alloyed for MIG welding of AISI 307, for carbon steels with stainless steels, and austenitic manganese steels. Also suitable for welding hard steels, 13% Mn steels, armour and ballistic steels. It can be used for the first layer before the cladding. Pure austenitic bead with very good resistance to abrasion. To be used with Ar/1-2% O₂ shielding gas.

DOMENII DE APLICATIE

Recipienți (inclusiv industria chimică și petrochimică);
Industria constructoare de mașini;
Încărcări/Placări;
Sudarea oțelurilor placate.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Industrial machinery construction;
Hardfacing/cladding;
Welding of armour steels.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+
GAZ / GAS: Ar/ 2%O₂
(M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.07 - 0.12	5.10 - 8.00	0.65 - 0.90	≤ 0.03	≤ 0.03	17.00 - 20.00	7.00 - 10.00	≤ 0.50	≤ 0.30

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C	Kv J -20°C
Ar/2%O ₂	Stare sudată/As welded	≥ 600	≥ 420	≥ 30	≥ 50	≥ 40

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
BS 300	15 kg	W000283112	W000283113		

Datele menționate pot fi modificate fără o notificare prealabilă. / The above data may change without prior notice.

FILINOX 308 L

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 308 L
EN ISO 14343-A: G 19 9 L

AUTORIZARI / APPROVALS

DB: 43.116.10

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea otelurilor inoxidabile austenitice cu compozitie chimica similara, in particular a tipului AISI 304 si 304L. Continutul scazut de carbon reduce riscul aparitiei coroziunii intergranulare. Poate fi utilizata de asemenea si pentru sudarea otelurilor stabilizate cu Ti sau Nb, pentru temperaturi de lucru ce nu depasesc 400°C.

MAIN FEATURES

Solid wire for austenitic stainless steel welding in all position with similar chemical composition, in particular type AISI 304 and 304 L. Low carbon reduces the possibility of intergranular corrosion. It may be used for welding stabilized steels(e.g. AISI 321-AISI 347) with working temperatures not exceeding 400°C.

DOMENII DE APLICATIE

Recipienti, inclusiv cei din industria petrochimica;
Constructia autovehiculelor, aplicatii electrice;
Industria constructoare de masini;
Fabricarea tevilor.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Metal working industry;
Car, bus production and electro-domestic appliances;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.025	1.20 - 2.00	0.30 - 0.65	≤ 0.020	≤ 0.025	19.5 - 21.0	9.0 - 11.0	≤ 0.75	≤ 0.30

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 580	≥ 400	≥ 35	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000282990	W000282991	W000282992	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 308 L Si

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 308 L Si
EN ISO 14343-A: G 19 9 LSi

AUTORIZARI / APPROVALS

DB: 43.116.11
TÜV: SG-X2 CrNi 19 9

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea otelurilor inoxidabile austenitice cu compozitie chimica similara, in particular a tipului AISI 304 si 304L. Continutul scazut de carbon reduce riscul aparitiei coroziunii intergranulare. Poate fi utilizata de asemenea si pentru sudarea otelurilor stabilizate cu Ti sau Nb, pentru temperaturi de lucru ce nu depasesc 400°C. Continutul marit de Si imbunatateste stabilitatea arcului si sudabilitatea. Aceasta conduce la un aspect regulat al cordonului de sudura, in mod special cand se utilizeaza un transfer de tip scurt-circuit, ceea ce duce la reducerea porozitatii si a stropilor.

MAIN FEATURES

Solid wire for austenitic stainless steel welding in all position with similar chemical composition, in particular type AISI 304 and 304 L. Low carbon reduces the possibility of intergranular corrosion. It may be used for welding stabilized steels(e.g. AISI 321-AISI 347) with working temperatures not exceeding 400°C. The higher silicon content improves the arc stability and weldability. This gives a good attractive bead and, especially in the short-arc transfer, reduces porosity and spatters.

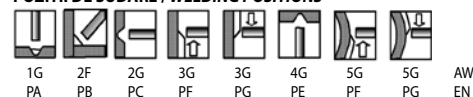
DOMENII DE APLICATIE

Recipienti, inclusiv cele din industria petrochimica;
Constructia autovehiculelor, aplicatii electrice;
Industria constructoare de masini;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication (including the chemical petrochemical industry);
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.025	1.20 - 2.00	0.65 - 1.00	≤ 0.020	≤ 0.025	19.5 - 21.0	9.0 - 11.0	≤ 0.30	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 580	≥ 400	≥ 35	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000283021	W000283022	W000283023	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 309 L SI

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 309 L Si
EN ISO 14343-A: G 23 12 L Si

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG in toate pozitiile a otelurilor inoxidabile austenitice cu compozitie chimica similara si pentru sudarea materialelor disimilare sau dificil sudabile, ca imbinarile intre oteluri carbon si otelurile inoxidabile. Continutul scazut de carbon conduce la cresterea rezistentei la coroziune intergranulara. Poate fi utilizata si pentru realizarea straturilor tampon pe otelurile carbon inainte de a suda cu tipul AISI 304 sau 304L. Continutul ridicat de siliciu imbunatateste stabilitatea arcului si sudabilitatea. Aceasta conduce la obtinerea unor suduri cu aspect regulat, dar mai ales reduce pericolul aparitiei stropilor si porozitatii atunci cand se foloseste transferul de tip short-arc.

MAIN FEATURES

Solid wire for MIG welding, in all positions, of austenitic stainless steel of similar composition and for different welding materials with difficult saldability like carbon steel with stainless steel. The low carbon content increases resistance to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L. The higher silicon content improves the arc stability and weldability. This gives a good attractive bead and, especially in short-arc transfers, reduces porosity and spatters.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.20 - 2.50	0.65 - 1.00	≤ 0.03	≤ 0.03	23.0 - 25.0	12.0 - 14.0	≤ 0.75	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 580	≥ 420	≥ 30	≥ 27

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000283096	W000283097	W000283098	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 309 L Mo

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 309 L Mo
EN ISO 14343-A: G 23 12 L L

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG in toate pozitiile a otelurilor inoxidabile austenitice cu compozitie chimica similara si pentru sudarea materialelor disimilare sau dificil sudabile, ca imbinarile intre oteluri carbon si otelurile inoxidabile. Continutul scazut de carbon conduce la cresterea rezistentei la coroziune intergranulara. Poate fi utilizata si pentru realizarea straturilor tampon pe otelurile carbon inainte de a suda cu tipul AISI 304 sau 304L. Continutul ridicat de molibden imbunatateste considerabil rezistenta la coroziune si rezistenta la fisurare la cald.

MAIN FEATURES

Solid wire for MIG welding, in all positions, of austenitic stainless steel of similar composition and for different welding materials with difficult saldability like carbon steel with stainless steel. The low carbon content increases resistance to intergranular corrosion. It can be used as buffer layer on carbon steel before welding with stainless steels type 304 and 304 L. The higher molybdenum content improves pitting corrosion and resistance to hot cracking.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor;
Constructii navale.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication;
Shipbuilding.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	23.0 - 25.0	12.0 - 14.0	2.0 - 3.0	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 620	≥ 450	≥ 35	≥ 27

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2	1.4	
BS 300	15 kg	W000283102	W000283103	W000283104	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 310

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 310
EN ISO 14343-A: G 25 20

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG a otelurilor inoxidabile cu compozitie chimica similara. Se utilizeaza amestec de gaze Ar/2%O₂ (1-2%). Se caracterizeaza printr-o buna rezistenta la coroziune in aplicatiile cu temperatura pana la 1100°C. Indicata pentru incarcarea otelurilor carbon si otelurilor slab aliate, cand se cere o placare cu 25Cr/20Ni.

Recomandata pentru mediu de lucru la temperaturi inalte (~1100°C) si mediu sulfuros, oxidant sau reductor.

MAIN FEATURES

Solid wire for MIG welding of stainless steels with similar chemical composition, designed for Ar/2%O₂ (1-2%) shielding gas. Good resistance to corrosion also at high temperature application (up to 1100°C). Especially suitable for facing on carbon steels and low alloyed steels, when 25% Cr - 20% Ni are required. Suitable also for high temperature works (~ 1100°C) and where solforous, oxidizing or reducing atmosphere.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication, including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
0.08 - 0.14	1.00 - 2.50	0.30 - 0.65	≤ 0.03	≤ 0.03	25.0 - 27.0	20.0 - 22.5	≤ 0.75	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 550	≥ 390	≥ 35	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.0	1.2		
BS 300	15 kg	W000283117	W000283118		

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 316 L

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 316 L
EN ISO 14343-A: G 19 12 3 L

AUTORIZARI / APPROVALS

DB: 43.116.13

CARACTERISTICI PRINCIPALE

Sarma plina cu continut scazut de carbon pentru sudarea MIG a otelurilor AISI 316 si similare. Recomandata pentru buna rezistenta la coroziune intergranulara. Indicata pentru temperaturi pana la 400°C. Se utilizeaza in Ar/1÷2 O₂.

MAIN FEATURES

Solid wire with low carbon content for MIG welding of AISI 316 stainless steels and similars and/or stabilized steels. Good resistance to the intergranular corrosion. Suitable for project temperature up to 400°C. To be used with Ar/1÷2 O₂ shielding gas.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.030	1.20 - 2.50	0.30 - 0.65	≤ 0.020	≤ 0.025	18.0 - 20.0	11.0 - 14.0	2.50 - 3.00	≤ 0.25

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 600	≥ 400	≥ 40	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm		
		0.8	1.0	1.2
BS 300	15 kg	W000283048	W000283049	W000283050

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 316 L Si

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 316 L Si
EN ISO 14343-A: G 19 12 3 L Si

AUTORIZARI / APPROVALS

DB: 43.116.14

CARACTERISTICI PRINCIPALE

Sarma plina cu continut scazut de carbon pentru sudarea MIG a otelurilor AISI 316 si similare. Recomandata de buna rezistenta la coroziune intergranulara, se utilizeaza in Ar/1÷2 O₂. Procentul ridicat de Si amelioreaza stabilitatea arcului si sudabilitatea. Aceasta permite obtinerea de cordoane cu aspect regulat, dar mai ales, cand este utilizat transferul de tip short-arc, se reduce considerabil numarul de stropi si se elimina porozitatea.

MAIN FEATURES

Solid wire with low carbon content for MIG welding of AISI 316 stainless steels and similars and/or stabilized steels. Good resistance to the intergranular corrosion. To be used with Ar/1÷2, shielding gas. The high silicon content improves arc stability and weldability. This gives a good attractive bead and, especially in short arc transfer, reduces porosities and spatters.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petroliera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.03	1.20 - 2.50	0.65 - 1.00	≤ 0.02	≤ 0.03	18.0 - 20.0	11.0 - 14.0	2.50 - 3.00	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 600	≥ 400	≥ 30	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000283078	W000283079	W000283080	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 318

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 318
EN ISO 14343-A: G 19 1 2 3 Nb

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea otelurilor inoxidabile austenitice stabilizate cu Nb sau Ti, cu compozitie chimica tip Cr 18%, Ni 12%, Mo 3%. Recomandata pentru sudarea lui AISI 316 Ti. Continutul de Nb creste rezistenta la coroziune intergranulara la aplicatiile la temperatura inalta (400°C).

MAIN FEATURES

Solid wire for welding of stainless steels Nb/Ti stabilized with chemical composition like Cr 18%, Ni 12%, Mo 3%. Suitable for welding of AISI 316 Ti. The Nb content increases the intergranular corrosion resistance at high temperature service (400°C).

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petroliera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
≤ 0.07	1.20 - 2.00	0.30 - 0.65	≤ 0.015	≤ 0.02	18.5 - 20.0	11.0 - 13.0	2.50 - 3.00	≤ 0.30	12x C - 0.9

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 600	≥ 430	≥ 30	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.02			
BS 300	15 kg	W000283647			

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 347

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 347
EN ISO 14343-A: G 199 Nb

AUTORIZARI / APPROVALS

TÜV: 01148.04
DB: 43.116.01

CARACTERISTICI PRINCIPALE

Sarma plina cu 20Cr-10Ni stabilizata cu niobiu. Recomandata pentru sudarea otelurilor inoxidabile stabilizate cu titan sau cu niobiu, ca AISI 347 si AISI 321. Prezenta continutului de Nb creste rezistenta la coroziune intergranulara. Sarma pentru aplicatii la temperaturi mai mari de 400°C.

MAIN FEATURES

Solid wire with 20Cr-10Ni content, niobium stabilized. Suitable for stainless steels titanium or niobium stabilized, like AISI 347 and AISI 321. The Nb content increase the resistance to the intergranular corrosion. Fit for project temperature exceeding 400°C.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb
≤ 0.08	1.00 - 2.50	0.30 - 0.65	≤ 0.015	≤ 0.020	19.0 - 21.0	9.0 - 11.0	≤ 0.75	≤ 0.75	10xC-1%

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 550	≥ 400	≥ 30	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000283037	W000283038	W000283039	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILINOX 410

SARMA PLINA PENTRU OTELURI INOXIDABILE /
SOLID WIRE FOR STAINLESS STEEL

CLASIFICARE / STANDARDS

AWS A5.9-93: ER 410
EN ISO 14343-A: G 13

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina autoturificanta pentru sudare MIG a otelurilor martensitice cu compozitie chimica similara. Recomandata pentru placari pe otel carbon, cu rezistenta la coroziune, eroziune si abraziune. Se utilizeaza cu amestec de gaze Ar/O₂. Sudarea cu aceasta sarma impune preincalzirea pieselor de sudat si tratamentul termic dupa sudare.

MAIN FEATURES

Selfharding solid wire for MIG welding of martensitic steels with similar chemical composition. Suitable for weldoverlay on carbon steels. It allows to realize a bead resistant to corrosion, erosion and abrasion. To be used with Ar/O₂ shielding gas. Welding with this wire requires preheat and postheat.

DOMENII DE APLICATIE

Industria constructoare de masini;
Industria de automobile si electrocasnice;
Cazangerie inclusiv ind. chimica/petrolifera;
Fabricarea tevilor.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances;
Vessels, boilers fabrication including for chemical industry;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT: DC+

GAZ / GAS: MIX: (98% Ar - 2% O₂) - (99% Ar - 1% O₂)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Ni	Mo	Cu
≤ 0.12	≤ 0.60	≤ 0.50	≤ 0.03	≤ 0.03	11.5 - 13.5	≤ 0.60	≤ 0.75	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J +20°C
MIX	Stare sudată/As welded	≥ 520	≥ 400	≥ 20	≥ 47

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		1.2			
BS 300	15 kg	W000283128			

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

LEXAL G 22.9.3 N

SARMA MIG / MIG WIRE

CLASIFICARE / STANDARDS

AWS A5.9: ER 2209
W Nr: 1.4462
EN ISO 14343-A: G 22 9 3 NL

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma MIG destinata sudarii otelurilor inoxidabile Duplex care contin 22% Cr, 9% Ni si 3% Mo. Rezistenta optima la coroziunea intergranulara, continut scazut de carbon. Sudabilitate excelenta. Bune caracteristici mecanice la temperatura mai mica de -50°C. Aceasta sarma se foloseste cu gaz special cu continut de Azot pentru compensarea pierderii de Azot din timpul sudarii.

MAIN FEATURES

MIG wire suitable for welding of Duplex stainless steels having 22% Cr, 9% Ni and 3% Mo. Good resistance to intergranular corrosion, low carbon content. Excellent weldability. Good mechanical characteristics down to -50°C. This wire could use a specific gas containing Nitrogen which compensates the loss of Nitrogen from the weld pool.

DOMENII DE APLICATIE

Constructii navale;
Cazangerie inclusiv industria chimica si petrolifera;
Fabricarea tevilor;
Constructii off-shore.

MAIN APPLICATIONS

Shipbuilding;
Vessels, boilers fabrication (including for chemical and petrochemical industry);
Pipes fabrication;
Off-shore fabrication.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: Ar (11) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Ni	Cr	Mo	N	Fe% Vol.
≤ 0.025	0.5-2.0	≤ 1.20	≤ 0.012	≤ 0.025	7.5 ÷ 9.5	21.5 ÷ 23.5	2.5 ÷ 3.5	0.10 ÷ 0.20	25 ÷ 65

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rs N/mm ²	E % 5d	Kv J -20°C
Ar	Stare sudată/As welded	≥ 810	≥ 620	≥ 22	≥ 65

Pitting Corrosion Test (according to ASTM G48 Method A / condition test: 24h exposure at +20°C)

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm			
		0.8	1.0	1.2	
BS 300	15 kg	W000283140	W000283141	W000283142	

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILALU AL 99.5

SARMA PLINA DE ALUMINIU / ALUMINIUM SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.10-92: ER 1100
BS 2901 Pt 4: 1050 A
EN ISO 18273-A: S Al 1450

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG a aluminiului pur si a aliajelor sale care contin pana la 0,5% elemente de aliere. Destinata sudarii aliajelor de tipul 1050 A si 1100. Gaz de protectie: argon.

MAIN FEATURES

Solid wire for MIG welding of pure aluminium and its alloys up to maximum 0.5% alloying elements. Suitable for welding of commercial alloys 1050A and 1100. Shielding gas: argon.

DOMENII DE APLICATIE

Constructii, feroviare si civile;
Productia de automobile si aparate electrocasnice.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: Ar (11) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Al	Si	Fe	Mn	Ti	Mg	Zn	Cu
≥ 99.5	≤ 0.25	≤ 0.40	≤ 0.05	0.10-0.20	≤ 0.05	≤ 0.07	≤ 0.05

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d
Ar (11)	Stare sudată/As welded	180 - 230	150 - 200	≥ 19

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm		
		1.0	1.2	1.6
BS 300	7 kg	W000283180	W000283181	W000283182

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILALU AL Si 5

SARMA PLINA DE ALUMINIU / ALUMINIUM SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.10-92: ER 4043
BS 2901 Pt 4: 4043 A
EN ISO 18273-A: S Al 4043

AUTORIZARI / APPROVALS

DB: 61.116.02

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea aluminiului si a aliajelor de aluminiu cu un continut de siliciu pana la 7%. Destinata sudarii aliajelor de Al - Mg - Si serie 6000 si imbinari eterogene ca 6000/1000 si 6000/3000. Continutul inalt de siliciu imbunatateste fluiditatea materialului depus.

MAIN FEATURES

Solid wire for welding of aluminium and aluminium alloys with a silicon content up to 7%. Suitable for Al - Mg - Si alloys serie 6000 and for mixed welding like 6000/1000 and 6000/3000. The high silicon content improves the low characteristics.

DOMENII DE APLICATIE

Constructii, feroviare si civile;
Productia de automobile si aparate electrocasnice.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: Ar (I1) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Al	Mn	Si	Mg	Fe	Cu	Ti	Zn		
≥ 93	≤ 0.05	4.50 - 6.00	≤ 0.05	≤ 0.80	≤ 0.30	≤ 0.20	≤ 0.10		

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d		
Ar (I1)	Stare sudată/As welded	≥ 120	≥ 40	≥ 8		

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm						
		1.0	1.2	1.6				
BS 300	7 kg	W000283186	W000283187	W000283188				

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILALU AL Mg 5

SARMA PLINA DE ALUMINIU / ALUMINIUM SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.10-92: ER 5356
EN ISO 18273-A: S Al 5356

AUTORIZARI / APPROVALS

DB: 61.116.05

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG a aluminiului si a aliajelor de aluminiu cu un continut de mangan pana la 5%. Destinata sudarii aliajelor de aluminiu comerciale, de asemenea constructiilor metalice.

MAIN FEATURES

Solid wire for MIG welding of aluminium and aluminium alloys with manganese content up to 5%. Suitable for welding of all commercial aluminium alloys, also in structural works. Good mechanical properties and high resistance to corrosion as well marine corrosion.

Caracterizata prin proprietati mecanice bune si rezistenta inalta la coroziune si coroziune marina.

DOMENII DE APLICATIE

Constructii, feroviare si civile;
Productia de automobile si aparate electrocasnice.

MAIN APPLICATIONS

Metal working industry;
Car, bus production and electro-domestic appliances.

POZITII DE SUDARE / WELDING POSITIONS



1G 2F 2G 3G 3G 4G 5G 5G AWS
PA PB PC PF PG PE PF PG EN

CURENT / CURRENT: DC+

GAZ / GAS: Ar (I1) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Al	Mn	Si	Mg	Fe	Cu	Cr	Zn	Ti	
≥ 93	0.05 - 0.20	≤ 0.25	4.50 - 5.60	≤ 0.40	≤ 0.10	0.05 - 0.20	≤ 0.10	0.06 - 0.20	

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d		
Ar (I1)	Stare sudată/As welded	≥ 240	≥ 110	≥ 17		

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm						
		0.8	1.0	1.2	1.6			
BS 300	7 kg	W000283232	W000283235	W000283238	W000283241			
S 200	2 kg		W000283233	W000283236				

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

NERTALIC 210

SARMA PLINA UNS N06082 / UNS N06082 SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.14: ER NiCr-3

AUTORIZARI / APPROVALS

TÜV: 07205.02

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea GMAW a aliajelor nichel-crom-fier de tip UNS N06600 (ASTM B163, B166, B167, B168). Recomandata pentru imbinari eterogene intre aliaje de nichel si otel, otel inox si otel carbon. Utilizat special pentru placarea otelurilor carbon si otelurilor slab aliate. Buna rezistenta la coroziune pana la 1100°C in aer.

MAIN FEATURES

Solid wire for GMAW welding of nickel-chromium-iron alloys type UNS N06600 (ASTM B163, B166, B167, B168). Suitable for dissimilar joints between nickel alloys and steels or stainless steels and carbon steels. Used often for cladding of carbon and low alloys steels. Good corrosion resistance til 1100°C in air.

DOMENII DE APLICATIE

Cazangerie, inclusiv industria chimica si petrochimica;
Fabricarea tevilor;
Constructii off-shore;
Placare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+

GAZ / GAS: Ar (I1) EN 439

Ar / 2% O₂ (M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Fe	Ni	Nb + Ta	Ti
≤ 0.10	2.5 - 3.5	≤ 0.50	≤ 0.015	≤ 0.030	18.0 - 22.0	≤ 3.0	≥ 67	2.0 - 3.0	≤ 0.75

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d	Kv J -196°C
Ar (I1)	Stare sudată/As welded	≥ 600	≥ 360	≥ 25	≥ 55

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm							
		1.0	1.2						
BS 300	15 kg	W000283164	W000283165						

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

NERTALIC 625

SARMA PLINA UNS N06625 / UNS N06625 SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.14: ER NiCrMo-3

AUTORIZARI / APPROVALS

TÜV: 07205.03

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea GMAW a aliajelor nichelul-crom-molibden de tip UNS N06625 (ASTM B443, B444, B446). Recomandata pentru imbinari eterogene intre aliaje de nichel si otel, sau diferite aliaje de nichel. Utilizat special pentru placarea otelurilor carbon si otelurilor slab aliate. Destinata pentru temperaturi de la -196°C pana la 1100°C. Excelenta rezistenta la coroziune tip pitting si coroziune fisuranta sub tensiune coroziv. Buna rezistenta la diferite tipuri de acizi minerali si organici.

MAIN FEATURES

Solid wire for GMAW welding of nickel-chromium-molibdenum alloys type UNS N06625 (ASTM B443, B444, B446). Suitable for dissimilar joints between nickel alloys and steels or different nickel alloys. Used often for cladding of carbon and low alloys steels. Suitable for design temperatures from -196°C to 1100°C. Excellent resistance to pitting corrosion and tenso-corrosion. Good resistance to many types of mineral and organic acid.

DOMENII DE APLICATIE

Cazangerie, inclusiv industria chimica si petrochimica;
Fabricarea tevilor;
Constructii off-shore;
Placare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

POZITII DE SUDARE / WELDING POSITIONS



CURENT / CURRENT:

DC+

GAZ / GAS: Ar (I1) EN 439

Ar / 2% O₂ (M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

C	Mn	Si	S	P	Cr	Fe	Ni	Nb + Ta	Mo
≤ 0.10	≤ 0.50	≤ 0.50	≤ 0.015	≤ 0.020	20.0 - 23.0	≤ 5.0	≥ 58	3.15 - 4.15	8.0 - 10.0

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E % 5d
Ar (I1)	Stare sudată/As welded	≥ 760	≥ 420	≥ 25

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm							
		1.0	1.2						
D 300	15 kg	W000283174	W000283175						

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

FILCORD Cu

SARMA PLINA PENTRU CUPRU SI ALIAJE DE CUPRU /
SOLID WIRE FOR COPPER AND COPPER ALLOYS

CLASIFICARE / STANDARDS

AWS A5.7: ER Cu
DIN 1736: SG- Cu Sn

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea MIG a cuprului si aliajelor de cupru. Buna umectare. Recomandata pentru cresterea rezistentei la uzura. Este necesara preincalzirea materialului de baza pentru grosimi mai mari de 3 mm.

MAIN FEATURES

Solid wire for MIG welding of copper and copper alloys. Good sliding. Usable for wear-resistant surfacing. Is necessary pre-heating the base material in case thickness higher than 3 mm.

DOMENII DE APLICATIE

Productia de automobile si aparate electrocasnice;
Incarcare;
Fabricarea tevilor.

MAIN APPLICATIONS

Car, bus production and electro-domestic appliances;
Surfacing;
Pipes fabrication.

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT:

DC+
Ar (I1) EN 439
Ar + 2% O₂ (M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Mn	Si	S	P	Cu	Sn	Al	Pb		
≤ 5.0	≤ 5.0	≤ 0.02	≤ 0.015	≥ 98.0	≤ 1.0	≤ 0.01	≤ 0.20		

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	HB		
Ar (I1)	Stare sudată/As welded	210 - 245	60 - 80		

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm							
		1.2							
BS 300	15 kg	W000283242							

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

ALIN G 70Cu

SARMA PLINA PENTRU ALIAJE CUPRU-NICHEL /
CUPRONICHEL SOLID WIRE

CLASIFICARE / STANDARDS

AWS A5.7: ER Cu Ni

AUTORIZARI / APPROVALS

CARACTERISTICI PRINCIPALE

Sarma plina pentru sudarea GMAW a aliajelor cupru nichel de tip: 90/10 si 70/30 si pentru suduri eterogene Cu/Ni cu Ni/Cu. Buna rezistenta la coroziune in mediu marin si salin. Bune proprietati mecanice.

MAIN FEATURES

Solid wire for GMAW welding of copper/nickel alloys, type: 90/10 and 70/30 and for heterogeneous weld Cu/Ni with Ni/Cu. Good resistance to sea corrosion and in saline environments. Good mechanical properties.

DOMENII DE APLICATIE

Cazangerie, inclusiv industria chimica si petrochimica;
Fabricarea tevilor;
Constructii off-shore;
Placare.

MAIN APPLICATIONS

Vessels, boilers fabrication (including the chemical petrochemical industry);
Pipes fabrication;
Off-shore fabrication;
Cladding.

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT:

DC+
Ar (I1) EN 439
Ar + 2% O₂ (M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Mn	Si	P	Cu	Fe	Ni	Ti	C		
≤ 1.00	≤ 0.15	≤ 0.02	REM	0.40 - 0.75	29.0 - 32.0	0.20 - 0.50	0.10		

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	E % 5d		
Ar (I1)	Stare sudată/As welded	≥ 350	≥ 22		

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm							
		0.8	1.0	1.2					
BS 300	15 kg	W000289160	W000289161	W000289162					

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.

CLASIFICARE / STANDARDS

AWS A5.7: ER Cu A 1 - A 1
DIN 1733: SG-Cu A1 8

AUTORIZARI / APPROVALS
CARACTERISTICI PRINCIPALE

Aliaj de cupru aluminiu (Al 8%) pentru sudarea cuprului. Ideal pentru incarcarea otelului carbon si pentru lucrari artistice. Inalta rezistenta la corozie in mediu marin.

MAIN FEATURES

Copper aluminium alloy (Al 8%) for copper welding. Ideal for surfacing on carbon steel (weld overlay), for fusion of steels and for artistic works.
High resistance to saline corrosion.

DOMENII DE APLICATIE

Construcia de nave;
Industria chimica;
Productia de automobile;
Incarcari.

MAIN APPLICATIONS

Shipbuilding;
Chemical industry;
Car, bus production;
Surfacing.

POZITII DE SUDARE / WELDING POSITIONS


1G PA 2F PB 2G PC 3G PF 3G PG 4G PE 5G PF 5G PG AWS EN

CURRENT / CURRENT: DC+

GAZ / GAS: Ar (I1) EN 439
Ar +2%(M13) EN 439

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

Al	Mn	Si	Cu	Zn	Pb				
6.0 - 8.5	≤ 0.50	≤ 0.10	REM	≤ 0.20	≤ 0.02				

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Tratament termic/Heat treatment	Rm N/mm ²	E % 5d	HB		
Ar (I1)	Stare sudată/As welded	390 - 450	≥ 45	80 - 110		

AMBALARE STANDARD / STANDARD PACKING

Ambalare / Packaging	Greutate / Weight	Diametru mm / Diameter mm					
		1.0	1.2				
BS 300	15 kg	W000283263	W000283266				

Datele mentionate pot fi modificate fara o notificare prealabila. / The above data may change without prior notice.