

CONSUMABLES CATALOG

# 2024



## Over 70 years of experience in the field of welding

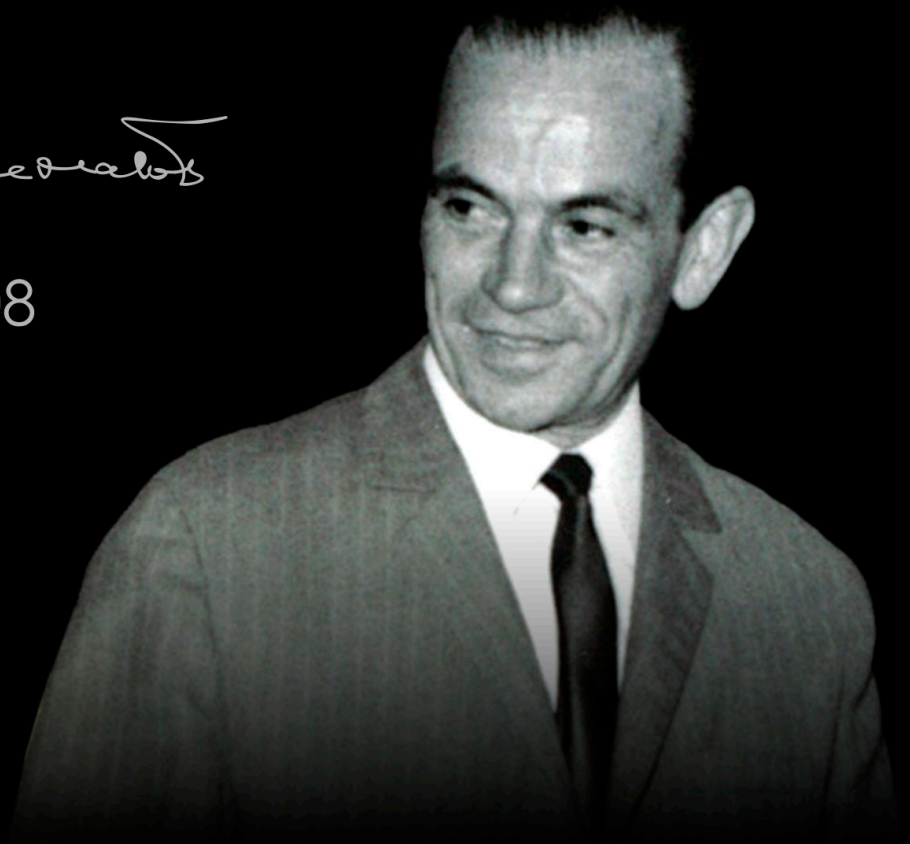
When João Rodrigues de Matos conceived the first welding equipment in 1946, it was far from imagining the importance and the repercussion that the Electrex brand currently has around the globe. Over 70 years, Electrex maintains a worldwide presence in the most diverse markets with great influence in the welding world. The accuracy and trust that characterize relationships with our customers are the key to seven decades of success.



**WELDING SINCE**  
**1946**

*Joseph P. ...*

1917 - 2008



# OVER 70 YEARS OF EXPERIENCE IN THE FIELD OF WELDING

## A CUSTOMER ORIENTED BRAND



Electrex places all its commitment and effort in satisfying the needs of its customers, offering solutions that are flexible and tailored to each one. Each order is executed with the utmost care and rigor to satisfy the needs of our customers.

## HUMAN RESOURCES



The most valuable resource of a company is on the people who place their commitment into the organization every day. Electrex is aware of this value and therefore strives to meet the needs of its employees by providing them with the best possible working conditions in order to maintain a healthy and motivating work environment.

## SUPPLIERS



Our suppliers are key components in the great gear that is Electrex and are carefully selected, from the moment of goods ordering to products arrival in the hands of our customers. They are the suppliers that help the organization to meet deadlines and objectives, so that the products are produced quickly and with quality, meeting the demand of our customers.

## INOVATION



Electrex seeks to offer its customers more and better every day, and therefore it is requested the constant search for more innovative production processes in order to develop products of high demand and quality that satisfy the needs of our customers.

## SUSTAINABILITY

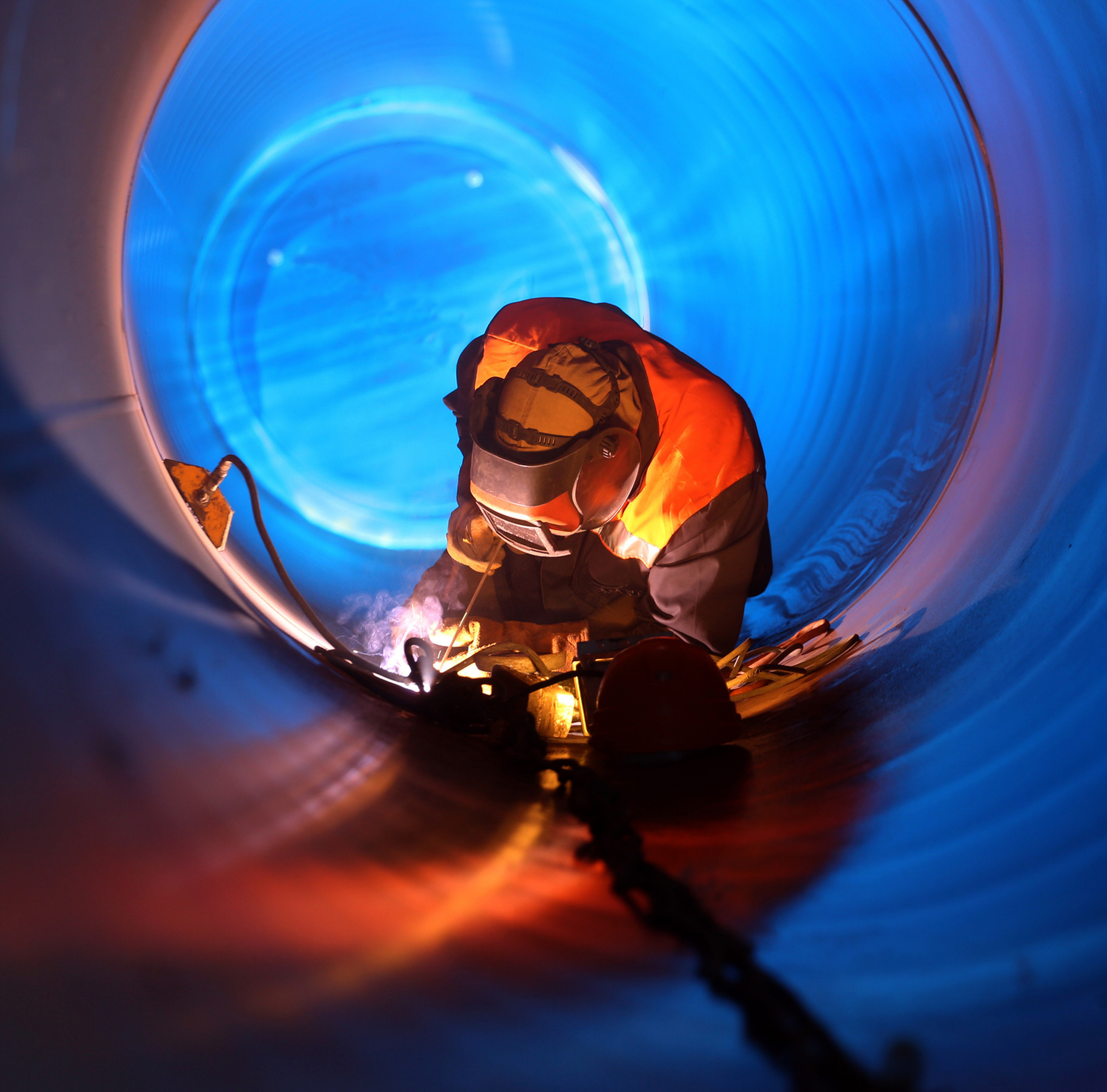


Electrex is committed to keeping the planet free of pollution so that future generations can inhabit it in the same way. Electrex complies with all environmental and safety standards imposed by its competent authorities, both at European and global level

## FUTURE CHALLENGES



An investment in the production area and commitment to the latest production processes are some of the challenges that Electrex proposes, so that it can offer its customers the best welding equipment available in the market. Electrex takes its work as a welding equipment manufacturer very seriously and briefly intends to diversify its export markets and consolidate its presence in the existing ones.



João R. Matos S.A. reserves the right to change the technical specifications without prior notice, non-contractual images



# CONTENTS

## MMA ELECTRODES

P. 14	Low and medium carbon steels
P. 17	Steel resistant to atmospheric conditions
P. 18	Low temperature steels
P. 19	Steels with high elastic strength
P. 21	Temperature resistant steels
P. 23	Stainless steel
P. 27	Special applications
P. 30	Nickel based steels
P. 32	Cast iron
P. 34	Copper alloys
P. 36	Hardfacing
P. 43	Aluminum alloys
P. 44	Cut and bevel

## TIG RODS

P. 50	Low and medium carbon steels
P. 52	Steel resistant to atmospheric conditions
P. 53	Temperature resistant steels
P. 57	Stainless steel
P. 64	Special applications
P. 67	Nickel based steels
P. 69	Cast iron
P. 70	Titanium
P. 71	Copper alloys
P. 74	Hardfacing
P. 75	Aluminum alloys

## OXY-GAS RODS / BRAZING

P. 82	Low and medium carbon steels
P. 83	Copper alloys
P. 86	Deoxidizing copper alloy
P. 87	Deoxidizing silver alloys
P. 88	Deoxidizing aluminum alloys

## MIG/MAG SOLID WIRES

P. 94	Low and medium carbon steels
P. 96	Steel resistant to atmospheric conditions
P. 97	Steels with high elastic strength
P. 99	Temperature resistant steels
P. 102	Stainless steel
P. 106	Special applications
P. 108	Nickel based steels
P. 109	Cast iron
P. 110	Copper alloys
P. 113	Hardfacing
P. 114	Aluminum alloys

## FLUX CORED WIRES MIG/MAG

P. 120	Low and medium carbon steels
P. 124	Stainless steel
P. 126	Special applications
P. 128	Hardfacing

## SAW SOLID WIRES

P. 134	Carbon and low alloy steels
P. 136	Stainless steel

## SAW FLUX

P. 140	Carbon and low alloy steels
P. 142	Stainless steel

P. 144	Electrex services
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# GLOSSARY

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## POLARITY/VOLTAGE CODES

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Alternating current



Direct current connected to the positive pole



Direct current connected to the negative pole



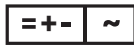
Direct current connected to the positive or negative pole



Direct current connected to the positive pole and alternating current can also be used



Direct current connected to the negative pole and alternating current can also be used



Direct current connected to the positive or negative pole and alternating current can also be used

## ABBREVIATIONS

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$R_m$ (N/mm <sup>2</sup> )	Tensile Strength
$R_{p0.2}$ (N/mm <sup>2</sup> )	Yield Strength
$A_5$ (%)	Elongation
ISO - V (J)	Impact Energy
HB	Hardness
RT	Room Temperature







**MMA ELECTRODES** 

## LOW AND MEDIUM CARBON STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 6010SP	AWS/ASME SFA-5.1: E 6010   EN ISO 2560-A: E 38 3 C 21   EN 499: E 38 E C 21	14
xARC 6013S	AWS/ASME SFA-5.1: E 6013   EN ISO 2560-A: E 38 0 RC 11	14
xARC 7018S	AWS/ASME SFA-5.1: E 7018-1 H4   EN ISO 2560-A: E 42 5 B 32 H5   EN 499: E 42 5 B 32 H5	15
xARC 7016S	AWS/ASME SFA-5.1: E 7016-1   EN ISO 2560-A: E 42 5 B 1 2 H5   EN 499: E 42 5 B 1 2 H5	15
xARC 7024	AWS/ASME SFA-5.1: E 7024   EN ISO 2560-A: E 42 0 RR 73	16
xARC 7028	AWS/ASME SFA-5.1: E 7028   EN ISO 2560-A: E 42 2 B 83	16

## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC CORTEN	AWS/ASME SFA-5.5: E 8018-W2	17

## LOW TEMPERATURE STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC 8018 C2	AWS/ASME SFA-5.5: E 8018-C2   EN ISO 2560-A: E 50 6 3Ni B 42 H5	18

## STEELS WITH HIGH ELASTIC STRENGTH

DESIGNATION	CLASSIFICATION	PAG.
xARC 9018	AWS/ASME SFA-5.5: E 9018-G	19
xARC 10018	AWS/ASME SFA-5.5: E 10018-G H4   EN 757: E 69 6 Mn2NiCrMo B 42 H5	19
xARC 11018	AWS/ASME SFA-5.5: E 11018-G H4   EN 757: E 69 6 Mn2 NiCrMo B 42 H5	20
xARC 12018	AWS/ASME SFA-5.5: E 12018-G H4   EN ISO 18275-A: E 79 5 Mn2Ni1CrMo B 42 H5	20

## TEMPERATURE RESISTANT STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC MO	AWS/ASME SFA-5.5: E 7018-A1   DIN 8575: E Mo B 10+   DIN EN 1599: E Mo B 42	21
xARC 8018 B2	AWS/ASME SFA-5.5: E 8018-B2   EN 1599: E CrMo1 B 42 H5   EN ISO 3580-A: E CrMo1 B 42 H5	21
xARC 9018 B3	AWS/ASME SFA-5.5: E 9018-B3   EN 1599: E CrMo2 B 42 H5   EN ISO 3580-A: E CrMo2 B 42 H5	22
xARC 9018 B91	AWS/ASME SFA-5.5: E 9018-B91   EN 1599: E CrMo91 B 42 H5	22

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 308L	AWS/ASME SFA-5.5: E 308L-16   DIN EN ISO 3581-A: E 19 9 LR 12   DIN EN 1600: E 19 9 LR 12	23
xARC 316L	AWS/ASME SFA-5.4: E 316L-16   DIN EN ISO 3581-A: E 19 12 3 LR 12   DIN EN 1600: E 19 12 3 LR 12	23
xARC 310	AWS/ASME SFA-5.4: E 310-16   DIN 8556: E 25 20 R 23   DIN EN 1600: E 25 20 R 12   MAT. N° 1.4842	24
xARC 318	AWS/ASME SFA-5.4: E 318-16   EN ISO 3581-A: E 19 12 3 Nb R 12   EN 1600: E 19 12 3 Nb R 12	24
xARC 347	AWS/ASME SFA-5.4: E 347-16   DIN 8556: E 19 9 Nb R 23   DIN EN 1600: E 19 9 Nb R 32	25
xARC DUPLEX	AWS/ASME SFA-5.4: E 2209-16	25
xARC SUPER DUPLEX	AWS/ASME SFA-5.4: E 2594-15   EN ISO 3581-A: 25 9 4 N LB 22   MAT. N° 1.4463	26
xARC 385	AWS/ASME SFA-5.4: E 385-16   DIN 8556: E 20 25 5 Cu LR 23   DIN EN 1600: E 20 25 5 Cu LR 32	26

## SPECIAL APPLICATIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC EXTRACTION	-	27
xARC 307	AWS/ASME SFA-5.4: ~ E 307-16   DIN 8556: E 18 8 Mn R 26   DIN EN 1600: E 18 8 Mn R 12	27
xARC 309L	AWS/ASME SFA-5.4: E 309L-16   DIN EN ISO 3581-A: E 23 12 LR 12   DIN EN 1600: E 23 12 LR 12	28
xARC 309L MO	AWS/ASME SFA-5.4: E 309MoL-16   DIN 8556: E 23 13 2 LR 23   DIN EN 1600: E 23 13 2 LR 12	28
xARC 312	AWS/ASME SFA-5.4: E 312-16   DIN EN ISO 3581-A: E 29 9 R 12	29

## NICKEL BASED STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC NICKEL 3	AWS/ASME SFA-5.11: E Ni Cr Fe-3	30
xARC NICKEL MO 3	AWS/ASME SFA-5.11: E Ni Cr Mo-3   EN ISO 14172: E Ni 6625 (NiCr 22 Mo 9 Nb)	30
xARC NICKEL CU 7	AWS/ASME SFA-5.11: E Ni Cu-7   EN ISO 14172: E Ni 4060	31

## CAST IRON

DESIGNATION	CLASSIFICATION	PAG.
xARC NICKEL	AWS/ASME SFA-5.15: E Ni-CI	32
xARC NICKEL EC	AWS/ASME SFA-5.15: E Ni-CI	32
xARC NIFE	AWS/ASME SFA-5.15: E NiFe-C1   DIN 8573: E NiFe-1 BG11	33
xARC NICKEL B	AWS/ASME SFA-5.11: E Ni-1   EN ISO 14172: E Ni 2061 (NiTi3)	33

## COPPER ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC COBRE	AWS/ASME SFA-5.6: E Cu	34
xARC BRONZE	AWS/ASME SFA-5.6: E Cu Sn-C	34
xARC BRONZE EC	AWS/ASME SFA-5.6: E Cu Sn-C   DIN 1733: EL Cu Sn-7	35
xARC CUAL 8	AWS/ASME SFA-5.6: E Cu Al-A2	35

## HARDFACING

DESIGNATION	CLASSIFICATION	PAG.
xARC DUR MN	AWS/ASME SFA-5.13: E FeMn-B   DIN 8555: E 7 UM-200-K	36
xARC DUR 350	DIN 8555: E 1-UM-350	36
xARC DUR 2/600	DIN 8555: E 2-UM-60-GP	37
xARC DUR 600	DIN 8555: E 6-UM-60-P	37
xARC DUR 650	DIN 8555: E 6-UM-60-P	38
xARC DUR 10/600	DIN 8555: E 10-UM-60-GR	38
xARC DUR 750	DIN 8555: E 10-UM-60-GR	39
xARC DUR 65	DIN 8555: E 10-UM-65-GRZ	39
xARC DUR FAST STEELS	DIN 8555: E 4-UM-60-ST	40
xARC DUR FAST STEELS SPECIAL	DIN 8555: E 4-UM-65-ST	40
xARC DUR COBALT 1	AWS/ASME SFA-5.13: E Co Cr-C   DIN 8555: E 20-UM-55-CTZ	41
xARC DUR COBALT 6	AWS/ASME SFA-5.13: E Co Cr-A   DIN 8555: E 20-UM-45-CTZ	41
xARC DUR COBALT 12	AWS/ASME SFA-5.13: E Co Cr-B   DIN 8555: E 20-UM-50-CTZ	42

## ALUMINUM ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC AL SI5	AWS/ASME SFA-5.3: E 4043   DIN 1732: EL Al Si5	43
xARC AL SI12	AWS/ASME SFA-5.3: E 4047   DIN 1732: EL Al Si12	43

## CUT AND BEVEL

DESIGNATION	CLASSIFICATION	PAG.
xARC CUT	-	44
xARC GOUGE	-	44
xARC CARBON	-	45

## LOW AND MEDIUM CARBON STEEL

**xARC 6010SP** AWS/ASME SFA-5.1: E 6010 | EN ISO 2560-A: E 38 3 C 21 | EN 499: E 38 E C 21

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.20 Mn = 0.60	470 R <sub>m</sub> (N/mm <sup>2</sup> ) 400 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%) -30°C 47 ISO - V (J)	=+	 PA PB	2.50 x 350	40-70	CS113471
			 PC PG	3.25 x 350	70-100	CS113472
			 PF PE	4.00 x 350	100-140	CS113473

### APPLICATIONS

- Deep penetration cellulose coated electrode for welding pipes and ducts in all positions.
- It is characterised by a deeply penetrating, vigorous, spray-type arc.
- It is suitable for welding root passes, filler passes and cover passes.

### BASE MATERIALS

- L210 - L360, X42 - X52, API Grades A25 A & B.

**xARC 6013S** AWS/ASME SFA-5.1: E 6013 | EN ISO 2560-A: E 38 0 RC 11

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.20 Mn = 0.50 P = 0.03 S = 0.03	470-540 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥380 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥24 A <sub>5</sub> (%) 0°C ≥60 ISO - V (J)	=+- ~	 PA PB	2.00 x 350	-	CS113475
			 PA PB	2.50 x 350	60-85	CS113476
			 PC PG	3.25 x 350	90-130	CS113477
			 PC PG	4.00 x 350	140-180	CS113478
			 PF PE	5.00 x 350	180-240	CS113479


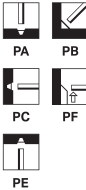
### APPLICATIONS

- General-purpose rutile-cellulose electrode with a medium coating for structural steelwork, welding in metalwork and maintenance, especially suitable for vertical downward welding and dripping.
- Good ignition and rescorching of the electrode.
- It can be used on galvanised, primed and lightly rusted parts.
- In assembly welding, this electrode can be used with practically the same parameters in all positions.
- Smooth, slightly concave welds with easy fusion to the base metal.
- The slag, in most cases, is self-releasing.

### BASE MATERIALS

- S(P)235 to S(P)355; GP240-GP280.

## xARC 7018S AWS/ASME SFA-5.1: E 7018-1 H4 | EN ISO 2560-A: E 42 5 B 32 H5 | EN 499: E 42 5 B 32 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.30 Mn = 1.40 P = 0.025 S = 0.020	550-620 R <sub>m</sub> (N/mm <sup>2</sup> ) 450 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%) -45°C 80 ISO - V (J)			2.00 x 300	-	CS113480
				2.50 x 350	60-80	CS113481
				3.25 x 350	110-135	CS113482
				3.25 x 450	110-135	CS113483
				4.00 x 350	140-180	CS113484
				4.00 x 450	140-180	CS113485
				5.00 x 450	180-230	CS113486


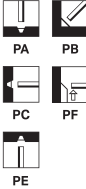
### APPLICATIONS

- Heavy-coated basic electrode for producing tough, crack-free welded joints, even in steels with a carbon content of up to 0.40 per cent.
- Good operating characteristics in positional welding. The weld metal has good resistance properties down to -50°C.
- Mechanical properties in group 7018-1. Suitable for cushion layers.

### BASE MATERIALS

- S(P)235-S(P)420; GP240-GP280; L245-L360.

## xARC 7016S AWS/ASME SFA-5.1: E 7016-1 | EN ISO 2560-A: E 42 5 B 1 2 H5 | EN 499: E 42 5 B 1 2 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.30 Mn = 1.40 P = 0.025 S = 0.020	550-620 R <sub>m</sub> (N/mm <sup>2</sup> ) 450 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%) -45°C 70 ISO - V (J)			2.50 x 350	60-80	CS113487
				3.25 x 350	100-130	CS113488
				3.25 x 450	100-130	CS113489
				4.00 x 350	140-170	CS113490
				4.00 x 450	140-170	CS113491
				5.00 x 450	180-220	CS113492



### APPLICATIONS

- Electrode with basic coating and low hydrogen content for producing resistant, crack-free welded joints. Good operating characteristics in positional welding.
- Excellent for joint access, making the electrodes suitable for root joint welding.
- The weld metal has good resistance properties up to -50°C. Suitable for the offshore, petrochemical and power and energy engineering industries.

### BASE MATERIALS

- S(P)235-S(P)420; GP240-GP280; L245-L360.



## xARC 7024 AWS/ASME SFA-5.1: E 7024 | EN ISO 2560-A: E 42 0 RR 73

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.8 Mn = 1.00	570 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) 0°C 50 ISO - V (J)			3.25 x 450	130-160	CS113494
				4.00 x 450	160-240	CS113495
				5.00 x 450	240-340	CS113496

### APPLICATIONS

- Heavy coated rutile type welding electrode, with high efficiency and depositing a high tensile strength steel alloyed with Mn.
- Suitable for welding at an angle or overlapping joints.
- Smooth melting, no spatter loss, instant tapping and self-lifting slag. Smooth bead appearance with fine ripple deposit.
- Suitable for the manufacture of medium section steel, boiler and tank construction, shipyards and, in general, where high speed welding is required.

## xARC 7028 AWS/ASME SFA-5.1: E 7028 | EN ISO 2560-A: E 42 2 B 83

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.50 Mn = 1.20	530 R <sub>m</sub> (N/mm <sup>2</sup> ) 430 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%) -20°C 60 ISO - V (J)			3.25 x 450	120-170	CS113498
				4.00 x 450	170-240	CS113499
				5.00 x 450	220-340	CS113500


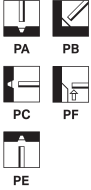
### APPLICATIONS

- Basic type electrode with high efficiency heavy coating.
- Suitable for flat and angled welding, smooth melting without spatter loss, easy slag removal, smooth and good appearance.
- Suitable for the manufacture of medium section steel, tank construction, shipyards and, in general, where high speed welding is required.



## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

### xARC CORTEN AWS/ASME SFA-5.5: E 8018-W2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.50 Cu = 0.50 Mn = 1.00 Cr = 0.60 Ni = 0.60 P = 0.025 S = 0.015	560-650 R <sub>m</sub> (N/mm <sup>2</sup> ) >480 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >21 A <sub>5</sub> (%) -20°C >47 ISO - V (J)			2.50 x 350	60-90	CS113501
				3.25 x 350	100-140	CS113502
				4.00 x 350	140-180	CS113503

#### APPLICATIONS





- Low-alloy corrosion-resistant and humidity-resistant electrode.
- Corrosion-resistant electrode for low-alloy, weather-resistant structural steels.
- Excellent weldability in all positions. Easy slag removal, smooth weld bead.

#### BASE MATERIALS

- ASTM A 242 and A 588.

## LOW TEMPERATURE STEELS

**xARC 8018 C2** AWS/ASME SFA-5.5: E 8018-C2 | EN ISO 2560-A: E 50 6 3Ni B 42 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.04 Si = 0.3 Mn = 0.6 Ni = 3.4	600 R <sub>m</sub> (N/mm <sup>2</sup> ) 500 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 27 A <sub>5</sub> (%) -60°C 90 ISO - V (J) -75°C 80 ISO - V (J)		 PA PB	2.50 x 350	70-90	CS113504
			 PC PF	3.25 x 450	90-140	CS113505
			 PE	4.00 x 450	120-180	CS113506

### APPLICATIONS

- Welding electrode with basic coating, suitable for welding steels with a 3.5% Ni alloy for service at cryogenic temperatures.
- Suitable for positional welding, except vertical down, spatter-free fusion, stable arc.
- Mainly used for welding low-alloy steel, for the construction of components used at low temperatures.
- Excellent results in X-ray tests and excellent values in impact tests at low temperatures.
- Mainly used in chemical, petrochemical and cryogenic installations, etc...

## STEELS WITH HIGH ELASTIC STRENGTH

### xARC 9018 AWS/ASME SFA-5.5: E 9018-G

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06 Si = 0.40 Mn = 1.50 Mo = 0.40 Ni = 1.00 P = 0.022 S = 0.016	650-720 R <sub>m</sub> (N/mm <sup>2</sup> ) >560 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >20 A <sub>5</sub> (%) -50°C >47 ISO - V (J)			2.50 x 300	60-90	CS113507
				3.25 x 450	100-140	CS113508
				4.00 x 450	140-180	CS113509

#### APPLICATIONS

- Basic type electrode, moisture resistant and with low hydrogen content, for high tension, fine grain structural steels, excellent weldability in all positions.
- Electrode with 0.4% Mo and 1% Ni content in the weld metal, suitable for 16Mo3 steel. Also designed for earthmoving equipment, boilers, power station construction, oil refineries, pipelines, HSLA steels.

#### BASE MATERIALS

- Fine grain steel EN 10113-2: S 275, S 355, S 420  
EN 10112-3: S 275, S 355, S 420
- Boiler steel EN 10028-2: P 235, P 265, P 295, P 355 16  
Mo 3, 13CrMo 4-5
- Steel pipe EN 10216-1: P 235, P 275  
EN 10217-1: P 355
- Cast steel EN 10213-2: GP 240 R, G 20 Mo 5, G17  
CrMo 5-5

### xARC 10018 AWS/ASME SFA-5.5: E 10018-G H4 | EN 757: E 62 6 Mn2NiMo B 3 2 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06 Si = 0.50 Mn = 1.40 Mo = 0.40 Ni = 2.50 P = 0.020 S = 0.015	760-850 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥680 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥18 A <sub>5</sub> (%) -60°C ≥47 ISO - V (J)			2.50 x 350	65-95	CS113510
				3.25 x 350	90-140	CS113511
				4.00 x 450	140-185	CS113512

#### APPLICATIONS

- Coated electrode based on low hydrogen iron powder of the LMA type that produces strong, crack-free welded joints.
- The electrode has a stable, concentrated arc, very easy slag removal, a smooth weld bead and is excellent for positional welding.
- The welds have an X-ray quality.
- Welding of high-strength steels, earth-moving equipment, heavy structures subject to dynamic loads and mechanical constraints.

#### BASE MATERIALS

- S620-S690, P690, L415-L555, BH65

## xARC 11018 AWS/ASME SFA-5.5: E 11018-G H4 | EN 757: E 69 6 Mn2NiCrMo B 3 2 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06 Si = 0.40 Cr = 0.35 Mn = 1.70 Mo = 0.40 Ni = 2.20 P = 0.025 S = 0.016	>780 R <sub>m</sub> (N/mm <sup>2</sup> ) >720 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >16 A <sub>5</sub> (%) -60°C >47 ISO - V (J)		 PA PB PC PF PE	2.50 x 350	60-90	CS113513
				3.25 x 350	100-140	CS113514
				4.00 x 450	140-180	CS113515

### APPLICATIONS

- Extra-low hydrogen electrode with basic coating of moisture-resistant iron powder.
- Suitable for welding fine-grained steels with high tensile strength. Stable, concentrated arc, suitable for welding in all positions. Seams with fine undulations, little spatter, easy slag removal. Joints without cracks. Welds have X-ray quality.
- Suitable for joining many high-strength steels, heat-treated fine grain steel N-A-XTRA 70, Hy 80/Hy100, ASTM 517 GrF, VSS T-1 steels, gantries, heavy earthmoving equipment, etc.

### BASE MATERIALS

- Fine-grained steel EN 10113-2: S 275, S 355, S 420  
EN 10112-3: S 275, S 355, S 420  
StE 500 - StE 690
- Boiler steel EN 10028-2: P 235, P 265, P 295, P 355 16  
Mo 3, 13CrMo 4-5
- Steel pipe EN 10216-1: P 235, P 275  
EN 10217-1: P 355

## xARC 12018 AWS/ASME SFA-5.5: E 12018-G H4 | EN ISO 18275-A: E 79 5 Mn2Ni1CrMo B 42 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.5 Cr = 0.9 Mn = 1.8 Mo = 0.5 Ni = 2.3	950 R <sub>m</sub> (N/mm <sup>2</sup> ) 850 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 18 A <sub>5</sub> (%) -50°C 50 ISO - V (J)		 PA PB PC PF PE	2.50 x 300	70-90	CS113516
				3.25 x 450	90-140	CS113517
				4.00 x 450	140-180	CS113518

### APPLICATIONS

- Basic coated welding electrode with low hydrogen content.
- Good weldability, stable arc, easy slag removal.
- Suitable for welding steels with tensile strengths up to 830 N/mm<sup>2</sup>.
- During use, adopt preheating, interpass temperature and post-weld treatment as required by the base material.
- Used in heavy industry for boilers and pressure vessels, structural components subject to high stresses, pipework, etc...

## TEMPERATURE RESISTANT STEELS

**xARC MO** AWS/ASME SFA-5.5: E 7018-A1 | DIN 8575: E Mo B 10+ | DIN EN 1599: E Mo B 42

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06 Si = 0.40 Mn = 0.80 Mo = 0.50 P = 0.020 S = 0.016	550-650 R <sub>m</sub> (N/mm <sup>2</sup> ) >470 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 24 A <sub>5</sub> (%) 20°C 100 ISO - V (J)			2.50 x 350	60-90	CS113519
				3.25 x 350	100-140	CS113520
				4.00 x 450	140-180	CS113521

### APPLICATIONS

- Moisture-resistant, hydrogen-controlled, basic type iron powder electrode for boilers, for the construction of boilers, storage tanks and pipework, for operating temperatures up to 525°C.
- Excellent electrode for all creep-resistant positions of 0.50% Mo and 1% Cr- 0.50% Mo steels. Specially designed for 16Mo3- steel.
- Strong, reliable welds with X-ray quality on cast steels, low alloys, high-strength steels, pressure vessels, pipes, cement kilns, heavy equipment, machine frames and chassis.

### BASE MATERIALS

- Construction steel EN 10025: S 235, S 275, S 355
- Ship steel A - E, A 32 - E 32, A 36 - E 36, A 40 - E 40
- Fine grain steels EN 10113-2: S 275, S 355, S 420, S 460  
EN 10113-3: S 275, S 355, S 420, S 460
- Boiler steel EN 10028-2: P 235, P 265, P 295, P 355, 16Mo3
- Steel pipe EN 10216-1: P 235, P 275
- Cast steel EN 10217-1: P 355  
EN 10213-2: GP 240 R, G20Mo5

**xARC 8018 B2** AWS/ASME SFA-5.5: E 8018-B2 | EN 1599: E CrMo1 B 42 H5 | EN ISO 3580-A: E CrMo1 B 42 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.5 Cr = 1.3 Mn = 0.8 Mo = 0.6	620 R <sub>m</sub> (N/mm <sup>2</sup> ) 550 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 21 A <sub>5</sub> (%) +20°C 140 ISO - V (J) -20°C 60 ISO - V (J)			2.50 x 350	65-90	CS113522
				3.25 x 450	90-140	CS113523
				4.00 x 450	130-250	CS113524

### APPLICATIONS

- Basic coated electrode with low hydrogen content for welding alloyed steels with 1% Cr and 0.5% Mo.
- Suitable for positional welding, excluding vertical downward welding, stable arc, low spatter fusion and easy slag removal.
- Suitable for welding medium alloy steels, resistant to high temperatures up to 550°C.
- Used for the construction of pressure vessels, pipe installations, heat exchangers and cladding on carburized steels. During welding, maintain the interpass temperature between 150 - 250°C.

## xARC 9018 B3 AWS/ASME SFA-5.5: E 9018-B3 | EN 1599: E CrMo2 B 42 H5 | EN ISO 3580-A: E CrMo2 B 42 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.6 Cr = 2.3 Mn = 0.7 Mo = 1.1	640 R <sub>m</sub> (N/mm <sup>2</sup> ) 530 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 18 A <sub>5</sub> (%) +20°C 120 ISO - V (J) -20°C 50 ISO - V (J)		 PA PB	2.50 x 350	65-90	CS113525
			 PC PF	3.25 x 450	90-140	CS113526
			 PE	4.00 x 450	125-160	CS113527

### APPLICATIONS

- Basic coated electrode designed for welding Cr-Mo alloy steels.
- Suitable for positional welding, excluding vertical down, excellent weldability, stable arc and easy slag removal.
- During the solidification process, the deposit remains crack-free.
- Suitable for welding creep-resistant steels with an alloy of 2.25% Cr and 1% Mo, and operating temperatures up to 600°C.

## xARC 9018 B91 AWS/ASME SFA-5.5: E 9018-B91 | EN 1599: E CrMo91 B 42 H5






CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.3 Cr = 9.5 Cu = 0.2 Al = 0.02 Mn = 0.6 Mo = 1.00 Ni = 0.6 Nb = 0.05 N = 0.04 V = 0.2	>650 R <sub>m</sub> (N/mm <sup>2</sup> ) >530 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >17 A <sub>5</sub> (%) 20°C >70 ISO - V (J)		 PA PB	2.50 x 300	65-90	CS113528
			 PC PF	3.25 x 350	90-130	CS113529
			 PE	4.00 x 450	130-180	CS113530

### APPLICATIONS

- Basic electrode with low hydrogen content developed for welding heat-resistant steels up to 650°C, alloyed with 9% to 12% Cr.
- Good weldability and arc stability, easy slag removal.
- Used mainly in the oil industry.
- Welding should be carried out with a short arc and low feed speed.
- Maintain an interpass of 200 - 300°C during welding.

## STAINLESS STEEL






**xARC 308L** AWS/ASME SFA-5.5: E 308L-16 | DIN EN ISO 3581-A: E 19 9 LR 12 | DIN EN 1600: E 19 9 LR 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.02 Si = 0.80 Cr = 19.0 Mn = 0.90 Ni = 10.0 P = 0.015 S = 0.010	610 R <sub>m</sub> (N/mm <sup>2</sup> ) 40 A <sub>5</sub> (%) RT 70 ISO - V (J)		 PA PB	1.60 x 250	-	CS113531
			 PA PB	2.00 x 300	-	CS113532
			 PC PF	2.50 x 350	50-80	CS113533
			 PE	3.25 x 350	70-110	CS113534
			 PE	4.00 x 350	100-150	CS113535

### APPLICATIONS

- Austenitic stainless steel electrode with extra low carbon rutile-basic coating with controlled ferrite of around 8% for maximum resistance to cracking and corrosion.
- Very low moisture absorption coating. Smooth spatter-free fusion, very easy slag removal, exceptional weld bead appearance, easy cleaning.
- Excellent resistance to corrosion and scaling up to 800°C. Applied to all 18/8 stainless steels at operating temperatures from -120°C to +350°C in pipes, tanks, heat exchangers, boilers, reactors and turbines, pipework systems.

**xARC 316L** AWS/ASME SFA-5.4: E 316L-16 | DIN EN ISO 3581-A: E 19 12 3 LR 12 | DIN EN 1600: E 19 12 3 LR 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.026 Si = 0.90 Mn = 0.75 Mo = 2.40 Ni = 12.00 P = 0.025 S = 0.010	590 R <sub>m</sub> (N/mm <sup>2</sup> ) 37 A <sub>5</sub> (%) RT 60 ISO - V (J)		 PA PB	1,60 x 250	-	CS113536
			 PA PB	2.00 x 300	50-80	CS113537
			 PC PF	2.50 x 350	50-80	CS113538
			 PE	3.25 x 350	80-100	CS113539
			 PE	4.00 x 350	110-150	CS113540

### APPLICATIONS

- Low carbon austenitic stainless steel electrode coated with rutile and Mo, with around 5-9% ferrite.
- Very low moisture absorption coating. Smooth melting, no spattering, very easy slag removal, exceptional bead appearance, easy cleaning.
- For welding and coating Cr-Ni-Mo austenitic stainless steels and coated sheets.
- Applied at operating temperatures from -120°C to +400°C in the chemical and petrochemical industries, refineries, the food industry and shipbuilding for welding pipes, tanks, heat exchangers, etc.

## xARC 310 AWS/ASME SFA-5.4: E 310-16 | DIN 8556: E 25 20 R 23 | DIN EN 1600: E 25 20 R 12 | MAT. Nº 1.4842

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.70 Cr = 27.00 Mn = 2.0 Ni = 21.00 P = 0.020 S = 0.012	$\geq 550 R_m$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) RT $\geq 60$ ISO - V (J)		 PA PB	2.50 x 350	60-90	CS113541
			 PC PF	3.25 x 350	80-110	CS113542
			 PE	4.00 x 350	100-140	CS113543

### APPLICATIONS

- Rutile-basic electrode with high-temperature austenitic stainless steel deposit.
- Resistant to corrosion and oxidation up to 1200°C, good resistance to hot cracking, easy removal of slag and pleasant appearance of the bead.
- Construction of steam boilers, chemical plants, gas industry, furnaces, thermal equipment.

## xARC 318 AWS/ASME SFA-5.4: E 318-16 | EN ISO 3581-A: E 19 12 3 Nb R 12 | EN 1600: E 19 12 3 Nb R 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.90 Cr = 18.50 Mn = 0.80 Mo = 2.60 Ni = 12.00 Nb = 0.40 P = 0.020 S = 0.010	$590 R_m$ (N/mm <sup>2</sup> ) $450 R_{p0.2}$ (N/mm <sup>2</sup> ) $35 A_5$ (%) 20°C 65 ISO - V (J)		 PA PB	2.50 x 350	50-80	CS113544
			 PC PF	3.25 x 350	70-110	CS113545
			 PE	4.00 x 350	110-150	CS113546

### APPLICATIONS

- Electrode with rutile-basic coating for welding stabilised austenitic steels, Cr-Ni-Mo stainless steels and cast steels at working temperatures up to +400°C.
- Good fusion of the joint faces, no spattering, finely corrugated bead surface, very easy slag removal.



## xARC 347 AWS/ASME SFA-5.4: E 347-16 | DIN 8556: E 19 9 Nb R 23 | DIN EN 1600: E 19 9 Nb R 32

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.04 Si = 0.80 Cr = 19.0 Mn = 1.10 Ni = 10.0 Nb = 0.45 P = 0.020 S = 0.015	590 R <sub>m</sub> (N/mm <sup>2</sup> ) 40 A <sub>5</sub> (%) RT 60 ISO - V (J)		 PA PB	2.50 x 350	50-80	CS113547
			 PC PF	3.25 x 350	80-110	CS113548
			 PE	4.00 x 350	110-150	CS113549

### APPLICATIONS

- ▶ Electrode for welding joints in unstabilised austenitics, stabilised austenitics and chemical-resistant austenitics, at working temperatures up to 400°C, for corrosion-resistant Cr steels and similar alloy coatings.

### BASE MATERIALS

- ▶ UNS: S30400, S30403, S32100, S34700.
- ▶ Metall alloy: 304, 304L, 321, 347.
- ▶ EN 10088: X5CrNi18-10, X2CrNi19-11, X6CrNiTi18-10, X6CrNiNb18-10.
- ▶ Material N<sup>a</sup>: 1.4301, 1.4306, 1.4541, 1.4550.
- ▶ UGINE: UGINOX 18-9, BD, E; UGINOX 18-10 L; UGINOX 18-10 T

## xARC DUPLEX AWS/ASME SFA-5.4: E 2209-16

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.025 Si = 0.85 Cr = 22.50 Mn = 0.80 Mo = 3.00 Ni = 9.00 N = 0.14 P = 0.012 S = 0.006	>700 R <sub>m</sub> (N/mm <sup>2</sup> ) >500 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >25 A <sub>5</sub> (%) RT >50 ISO - V (J)		 PA PB	2.50 x 350	40-60	CS113550
			 PC PF	3.25 x 350	70-100	CS113551
			 PE	4.00 x 350	110-150	CS113552

### APPLICATIONS

- ▶ Basic rutile electrode type 22-9-3-N for welding joints in corrosion-resistant duplex steels.
- ▶ Excellent resistance to intergranular corrosion and stress corrosion.
- ▶ Low carbon content, excellent weldability, spatter-free arc, very smooth bead appearance.

## xARC SUPER DUPLEX AWS/ASME SFA-5.4: E 2594-15 | EN ISO 3581-A: 25 9 4 N LB 22 | MAT. N° 1.4463

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.40 Cr = 25.00 Mn = 1.70 Mo = 4.00 Ni = 10.00 N = 0.25 P = 0.015 S = 0.010	$\geq 760 R_m$ (N/mm <sup>2</sup> ) $\geq 650 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 20 A_5$ (%) -50°C $\geq 60$ ISO - V (J)		 PA PB	2.50 x 350	40-70	CS113553
			 PC PF	3.25 x 350	70-110	CS113554
			 PE	4.00 x 350	120-150	CS113555

### APPLICATIONS

- Basic coated electrode type 25-10-4-N for welding super-duplex stainless steels type 2507 UNS S32750 (forged) and UNS J93404 (cast) and similar compositions.
- Excellent corrosion and crevice resistance (PREN >40). The deposited weld metal has very high ductility down to -50°C.

### BASE MATERIALS

- SAF 2507; UNS S32750; UNS J93404; ASTM A 182 F53; Uranus 47N

## xARC 385 AWS/ASME SFA-5.4: E 385-16 | DIN 8556: E 20 25 5 Cu LR 23 | DIN EN 1600: E 20 25 5 Cu LR 32

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C < 0.03 Si = 0.80 Cr = 20.50 Cu = 1.50 Mn = 1.0 Mo = 4.50 Ni = 25.00 P = 0.021 S = 0.015	$> 570 R_m$ (N/mm <sup>2</sup> ) $> 370 R_{p0.2}$ (N/mm <sup>2</sup> ) $> 35 A_5$ (%) 20°C $> 70$ ISO - V (J)		 PA PB	2.50 x 350	50-80	CS113556
			 PC PF	3.25 x 350	80-110	CS113557
			 PE	4.00 x 350	100-150	CS113558

### APPLICATIONS

- Coated rutile-basic electrode for welding fully austenitic and highly corrosion-resistant stainless steels (904L, B6). Good weldability in all positions except vertical downward, stable arc, good slag removal, regular and finely corrugated weld seams.
- Due to its alloy composition, high Mo and Cu content, the weld metal is suitable against phosphoric and sulphuric acid attacks. It has a high resistance to corrosion and stress corrosion in chloride-containing media.
- It is used at operating temperatures of up to 400°C.
- Special applications are: pulp and paper industry, transport containers, chemical industry plants.

## SPECIAL APPLICATIONS

### xARC EXTRACTION

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
-	-		 PA PB	2.00 x 300	-	CS113560
-	-		 PC PD	2.50 x 300	-	CS113561
-	-		 PE PF	3.25 x 350	-	CS113562
-	-		 PG			

#### APPLICATIONS

- Specially coated electrode developed for extracting bolts, screws and other special applications.

### xARC 307 AWS/ASME SFA-5.4: ~ E 307-16 | DIN 8556: E 18 8 Mn R 26 | DIN EN 1600: E 18 8 Mn R 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.12 Si = 0.50 Cr = 19.0 Mn = 5.10 Mo = 0.50 Ni = 9.00 P = 0.015 S = 0.012	>550 R <sub>m</sub> (N/mm <sup>2</sup> ) >35 A <sub>5</sub> (%) RT >75 ISO - V (J)		 PA PB	2.50 x 300	60-90	CS113563
			 PC PF	3.25 x 350	80-120	CS113564
			 PE	4.00 x 350	100-150	CS113565

#### APPLICATIONS

- Austenitic (non-magnetic) rutile coated electrode for joining and overlaying steels for manganese applications (up to 14% Mn) and steels with a high sulphur and phosphorus content, as well as for joining dissimilar steels, construction steels and stainless steels, for cushion layers before hardfacing.
- Repair of parts subjected to shocks or friction wear. Excellent machinability, easy slag removal, good bead appearance.
- For construction, railways, cement works (screening steels, excavation buckets, crushing jaws...)

#### BASE MATERIALS

- Austenitic steels with Mn: type Z 120 M 12, X 120 Mn 12. 1.3401
- Spring steel: 45 Cr 4, 1.7035, 46 Si 7, 1.5024, 51 Si 7, 1.5025. 56 Si 7, 1.5026 (\*)

## xARC 309L AWS/ASME SFA-5.4: E 309L-16 | DIN EN ISO 3581-A: E 23 12 LR 12 | DIN EN 1600: E 23 12 LR 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C < 0.03 Si = 0.90 Cr = 23.0-25.0 Mn = 0.90 Ni = 12.50-14.00 P = 0.025 S = 0.010	600 R <sub>m</sub> (N/mm <sup>2</sup> ) 35 A <sub>5</sub> (%) RT 80 ISO - V (J)		 PA PB	2.50 x 300	50-80	CS113566
			 PC PF	3.25 x 350	70-110	CS113567
			 PE	4.00 x 350	100-150	CS113568

### APPLICATIONS

- Low carbon rutile-basic coated electrode with an austenitic stainless steel deposit for welding dissimilar steels such as stainless steel to low alloy steels.
- Suitable for welding high-temperature steels and as cushion layers before hardfacing.
- Repair of machine parts for civil engineering.

### BASE MATERIALS

- UNS: S30900, S30453, S30908.
- Metal alloy: 309, 304LN, 3098.
- EN: X15CrNiSi 20-12, X2CrNiN 18-10, X12CrNi23-13, X10CrSiG, X10CrA1 18.
- Material Na: 1.4828, 1.4311, 1.4833, 1.4712, 1.4742.
- UGINE: UGNINOX R20-12, UGINOX R24-13S.

## xARC 309L MO AWS/ASME SFA-5.4: E 309MoL-16 | DIN 8556: E 23 13 2 LR 23 | DIN EN 1600: E 23 13 2 LR 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.90 Cr = 23.50 Mn = 1.00 Mo = 2.50 Ni = 13.10 P = 0.015 S = 0.012	600 R <sub>m</sub> (N/mm <sup>2</sup> ) 35 A <sub>5</sub> (%) RT 65 ISO - V (J)		 PA PB	2.50 x 350	50-80	CS113569
			 PC PF	3.25 x 350	80-110	CS113570
			 PE	4.00 x 350	100-140	CS113571





### APPLICATIONS

- 23Cr 12Ni 2Mo stainless steel electrode with low carbon rutile-basic coating, used for welding AISI 309 and 316L stainless steels and for dissimilar joints between construction, mild and stainless steels.
- Intermediate layer for a type 316L coating.  
Due to its high level of delta ferrite, approximately 15-25, it is also used as a universal repair electrode in maintenance welding.
- Highly resistant to cracks. Smooth melting, good appearance of the strand, the slag rises on its own.

### BASE MATERIALS

- AISI : 316 L. 316 Ti. 316 Cb, 309, 309 Cb
- N.º of reference: 1.4401. 1.4404. 1.4571

## xARC 312 AWS/ASME SFA-5.4: E 312-16 | DIN EN ISO 3581-A: E 29 9 R 12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.90 Cr = 29.0 Mn = 1.0 Ni = 9.50 P = 0.015 S = 0.010	$\geq 800 R_m$ (N/mm <sup>2</sup> ) $\geq 500 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 20 A_5$ (%)		 PA PB	2.50 x 350	50-80	CS113572
			 PC PF	3.25 x 350	70-110	CS113573
			 PE	4.00 x 350	140-190	CS113574

### APPLICATIONS

- Versatile high-alloy rutile-basic coated electrode with around 40% ferrite for welding dissimilar and repair joints. The ferritic-austenitic weld metal is stainless and corrosion resistant.
- Used for welding high-strength joints, difficult-to-weld steels, hardened and tool steels, spring and die steels, dissimilar steels, cast steels, cushion layers before hardfacing, etc.
- Superior weldability for all steels. Smooth, spatter-free fusion, self-releasing slag, smooth weld bead, very easy ignition and annealing.

## NICKEL BASED STEELS

### xARC NICRFE 3 AWS/ASME SFA-5.11: E Ni Cr Fe-3

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPLERAGE	REF.
C = 0.04 Si = 0.50 Cr = 16.50 Mn = 7.00 Fe = 7.00 Nb = 2.00 P = 0.02 S = 0.010	700 R <sub>m</sub> (N/mm <sup>2</sup> ) 420 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 43 A <sub>5</sub> (%) RT ≥ 90 ISO - V (J) -196°C ≥ 47 ISO - V (J)		 PA PB PC PF PE	2.50 x 350	50-70	CS113575
				3.25 x 350	70-95	CS113576
				4.00 x 350	90-120	CS113577

#### APPLICATIONS

- All-position electrode for welding inconel, nickel, monel, nickel-chromium-iron alloys, H K alloys and dissimilar steels such as carbon steels, stainless steels, nickel and nickel alloys.
- Welding deposits are resistant to fouling at high temperatures and corrosion at normal temperatures, as well as at high temperatures.




### xARC NICRMO 3 AWS/ASME SFA-5.11: E Ni Cr Mo-3 | EN ISO 14172: E Ni 6625 (NiCr 22 Mo 9 Nb)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPLERAGE	REF.
C = 0.04 Si = 0.25 Cr = 22.0 Mn = 0.40 Mo = 9.0 Fe = 2.50 Nb = 3.5 P ≤ 0.015 S ≤ 0.015	>760 R <sub>m</sub> (N/mm <sup>2</sup> ) >420 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >30 A <sub>5</sub> (%) RT ≥ 90 ISO - V (J) -196°C ≥ 47 ISO - V (J)		 PA PB PC PF PE	2.50 x 350	50-70	CS113578
				3.25 x 350	80-100	CS113579
				4.00 x 350	100-140	CS113580

#### APPLICATIONS

- Nickel-based electrode for welding joints and cladding nickel-chromium-molybdenum and nickel-chromium-like steels, Cr and CrNi (Mo, N) steels (heat-resistant) and nickel-alloyed steels for cold-resistant pressure vessels.
- Usable at working temperatures between -196°C and 1000°C (in the case of a sulphurous atmosphere, only up to 500°C).
- The fully austenitic weld metal is chemically stable, cold-resistant, heat-resistant, resistant to fouling up to 1000°C and resistant to embrittlement.
- High resistance to corrosive media.

## xARC NICU 7 AWS/ASME SFA-5.11: E Ni Cu-7 | EN ISO 14172: E Ni 4060

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.40 Mn = 3.80 Fe = 2.00 Ni = 65.0 P = 0.015 S = 0.010	$\geq 490 R_m$ (N/mm <sup>2</sup> ) $\geq 230 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 140-170 HB		 PA PB	2.50 x 350	40-60	CS113581
			 PC PF	3.25 x 350	80-100	CS113582
			4.00 x 350	110-130	CS113583	

### APPLICATIONS

- Basic type electrode specially designed for welding or coating monel 400, R 405, K 500 alloys and coated monel steels. Excellent mechanical properties.
- The weld metal is porosity-free and resistant to corrosion by seawater, salts and reducing acids.
- Suitable for dissimilar welding applications - welding applications for Monel include joints between monel, nickel-copper alloys and carbon steel, low-alloy steel, copper and copper-nickel alloys.
- Suitable working temperature from -196°C to +450°C.

## CAST IRON

### xARC NICKL AWS/ASME SFA-5.15: E Ni-CI

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1.00 Si = 0.50 Mn = 0.35 Ni = 97.50	450 R <sub>m</sub> (N/mm <sup>2</sup> ) 165 HB			2.50 x 300	50-70	CS113584
				3.25 x 350	70-90	CS113585
				4.00 x 350	100-130	CS113586

#### APPLICATIONS

- Nickel electrode for welding grey cast iron, malleable iron, cast iron and for welding worn castings. For grinding castings.
- Provides perfect welding results even at low amperages. The arc is smooth and intense, with little spatter and easy slag removal.
- The weld is smooth and workable, including the fusion zone.

### xARC NICKL EC AWS/ASME SFA-5.15: E Ni-CI

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C ≤ 2.0 Si ≤ 2.5 Mn ≤ 1.0 Fe ≤ 8.0 Ni ≥ 90 S ≤ 0.03	-			2.50 x 300	-	CS114073
				3.25 x 350	95-120	CS114074

#### APPLICATIONS

- A pure nickel electrode designed for welding normal quality cast iron.
- The weld metal is soft and easily worked, the deposition is carried out cold or slightly preheated.
- It is suitable for joining cast irons, grinding castings and repairing broken parts.



## xARC NIFE AWS/ASME SFA-5.15: E NiFe-C1 | DIN 8573: E NiFe-1 BG11

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Ni = 56 Fe remaining	>480 R <sub>m</sub> (N/mm <sup>2</sup> ) 190 HB	=+- ~		2.50 x 350	60	CS113587
				3.25 x 350	80	CS113588
				4.00 x 350	120	CS113589

### APPLICATIONS

- Graphite-based coated electrode with an iron-nickel alloy deposit for joining and repairing nodular cast iron.
- Homogeneous deposit and very resistant to cracks.
- Particularly recommended for dissimilar welding of cast iron to steel and cast iron constructions.
- Defects in foundries, repair of engine blocks, machine tools, gearboxes, reduction parts, pump bodies, castings, valve bodies.

### BASE MATERIALS

- ASTM : A48 class 25B to 60B  
: A536 Grade 60-80
- DIN : GG-15 to GG-40  
: GGG-40 to GGG-60  
: GTS-35 to GTS-65
- NFA : FLG 150 to FLG 400  
: FGS 400-12 to FGS 600-3  
: MN350-10 to MN650-3

## xARC NICU B AWS/ASME SFA-5.11: E Ni-1 | EN ISO 14172: E Ni 2061 (NiTi3)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.02 Si = 0.9 Mn = 0.6 Ti = 2.00 Fe = 0.3	>410 R <sub>m</sub> (N/mm <sup>2</sup> ) >250 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >28 A <sub>5</sub> (%) 20°C >130 ISO - V (J)	=+		2.50 x 300	60-80	CS113590
				3.25 x 350	90-120	CS113591
				4.00 x 350	110-150	CS113592

### APPLICATIONS

- Coated basic electrode, welds in all positions except vertical downwards, stable arc.
- Suitable for welding pure nickel and nickel-steel and nickel-copper alloys.
- It is used for undercoating carbon steels for subsequent special bonding.
- It is used in the chemical industry for the production of soda, soaps, fluoride chlorides, in the food and pharmaceutical industries.

## COPPER ALLOYS

### xARC COBRE AWS/ASME SFA-5.6: E Cu

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Cu = 99	>180 R <sub>m</sub> (N/mm <sup>2</sup> ) >20 A <sub>5</sub> (%)	=+		2.50 x 300	70-90	CS113593
				3.25 x 350	90-110	CS113594

#### APPLICATIONS

- Electrode with special coating and pure copper core.
- Developed for oxygen-free copper welding and refilling steels and cast irons.
- Preheating to 550°C is recommended for very thick parts.



### xARC BRONZE AWS/ASME SFA-5.6: E Cu Sn-C

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 8.00 P = 0.08 Cu remaining	> 300 R <sub>m</sub> (N/mm <sup>2</sup> ) 110 HB	=+		2.50 x 350	60-90	CS113596
				3.25 x 350	90-120	CS113597

#### APPLICATIONS

- Electrode with a special base coating, particularly suitable for welding and refilling phosphor bronze or similar, brass and for refilling cast iron and carbon steel.
- It is used for the construction of pump blades, turbines, for rebuilding worn parts or for filling new parts subject to wear, such as slide guides, sliders, valve seats.
- It is also used to repair casting defects and to coat seawater-resistant steel.



## xARC BRONZE EC AWS/ASME SFA-5.6: E Cu Sn-C | DIN 1733: EL Cu Sn-7

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Al = 0.01 Sn = 7-9 Pb = 0.02 Fe = 0.25 P = 0.05-0.35	-			2.50 x 350	75-95	CS114075
				3.25 x 350	100-130	CS114076

### APPLICATIONS

- The ECuSn-C (Phos-Bronze C) welding electrode is excellent for joining copper-based alloys not only to themselves, but also to stainless steel, cast iron and steels.
- This electrode can be used in alternating current and as an electric brazing rod.
- Typical applications: joining copper to itself as well as to stainless steel, cast iron and steel.

## xARC CUAL 8 AWS/ASME SFA-5.6: E Cu Al-A2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.5 Fe = 1.2 Al = 8	440 R <sub>m</sub> (N/mm <sup>2</sup> ) 190 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >20 A <sub>5</sub> (%) 130HB			2.50 x 300	60-90	CS113599
				3.25 x 350	100-130	CS113600

### APPLICATIONS

- Electrode with a basic coating and regular fusion.
- It is mainly used for welding and recharging aluminium, brass, bronze, silicon or manganese bronzes and cast irons.
- Suitable for friction-resistant metal refilling and corrosion in acidic or marine environments.
- Also used for joining different metals.
- Due to its characteristics, it is widely used in the mechanical and naval industries for refilling shafts, sliding guides, gear teeth, runners, bearing housings, etc.

## HARDFACING

### xARC DUR MN AWS/ASME SFA-5.13: E FeMn-B | DIN 8555: E 7 UM-200-K

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.8 Si = 0.6 Mn = 14.00 Mo = 1.00	200-250 HB	=+	 PA PB	2.50 x 350	-	CS113602
			 PC PF	3.25 x 350	100-140	CS113603
			 PC	4.00 x 350	140-180	CS113604
			 PE	5.00 x 450	180-240	CS113605

#### APPLICATIONS

- Basic-coated electrode with good weldability.
- The deposit is resistant to shocks that cause rapid work hardening of the surface.
- Suitable for charging components made of 14% Mn steel and carbon steels subjected to high impact and compression, such as milini hammers, excavator teeth, dredges for aggregate extraction, rail parts, etc.

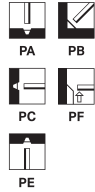
### xARC DUR 350 DIN 8555: E 1-UM-350

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.25 Si = 0.30 Cr = 3.2 Mn = 0.60 Fe remaining	37-38 HRc	=+ ~	 PA PB	2.50 x 350	-	CS113606
			 PA PB	3.25 x 350	90-120	CS113607
			 PC	4.00 x 350	140-170	CS113608
			 PC	5.00 x 350	180-220	CS113609

#### APPLICATIONS

- Well-functioning hardfacing electrode for chromium and manganese alloy deposits to resist moderate abrasion and impact.
- Recommended for rollers, traction wheels, crane wheels, gears, shafts, plough shears, brake pads, traction sprockets, etc.
- The welding tank is workable with good cutting tools.


## xARC DUR 2/600 DIN 8555: E 2-UM-60-GP

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.7 Cr = 2.00 Si = 0.5 Mn = 2.5	59 HRc	=+		2.50 x 300	60-90	CS113610
			3.25 x 450	100-135	CS113611	
			4.00 x 450	130-160	CS113612	
			5.00 x 450	150-220	CS113613	

### APPLICATIONS

- Base coated electrode.
- The deposited metal has good resistance to cracking, abrasion, impact, compression and is not workable.
- It finds applications in industry in general, particularly in the quarrying, mineral extraction and cement sectors for recharging mechanical parts, shovel teeth, crushing hammers, mills, etc.

## xARC DUR 600 DIN 8555: E 6-UM-60-P

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.50 Si = 1.0 Cr = 9.0 Mn = 0.50 Mo = 0.80 V = 0.60	57-60 HRc	=+- ~		2.50 x 350	-	CS113614
			3.25 x 350	90-120	CS113615	
			4.00 x 350	140-180	CS113616	
			5.00 x 350	180-240	CS113617	

### APPLICATIONS

- Hardfacing electrode for hard, impact-resistant and abrasive coating on unalloyed and low-alloyed materials with increased tensile strength.
- Recommended for recharging machine parts, dredger teeth, beater bars, scrapers, rock drills, augers, coal cutting blades, excavator teeth, screw conveyors, mill hammers, mixer arms, crusher jaws, cones, etc.

## xARC DUR 650 DIN 8555: E 6-UM-60-P

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.50 Si = 1.00 Cr = 7.00 Mn = 1.00 Fe remaining	57-61 HRc			2.50 x 350	-	CS113618
				3.25 x 350	100-140	CS113619
				4.00 x 350	140-180	CS113620
				5.00 x 350	180-240	CS113621

### APPLICATIONS

- Basic coating electrode with low hydrogen content for hard coating - hard, impact-resistant and abrasion-resistant on unalloyed and low-alloyed materials.
- Not sensitive to cracking and therefore the deposit does not need any additional protection.  
The weld metal can only be machined by grinding.
- Recommended for coating machine parts, dredger teeth, beater bars, scrapers, rock drills, drill bits, coal cutting blades, excavator teeth, conveyor augers, mill hammers, mixer arms, crusher jaws, cones, etc.



## xARC DUR 10/600 DIN 8555: E 10-UM-60-GR

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 2.7 Si = 1.2 Cr = 31.00 Mn = 1.00	60 HRc			2.50 x 350	90-110	CS113622
				3.25 x 350	100-140	CS113623
				4.00 x 350	150-200	CS113624

### APPLICATIONS

- High-performance rutile-basic coated electrode containing filler alloying elements.
- Chromium carbide deposit suitable for resisting severe abrasion.
- Regular melting, easy ignition and annealing.
- Due to its characteristics, the deposited alloy is widely used in fillers subject to mineral abrasion, erosion, medium impacts, such as crushing plants, mixers, augers, guides, conveyor rails.



## xARC DUR 750 DIN 8555: E 10-UM-60-GR

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 6.00 Si = 1.7 Cr = 33.00	61 HRc			3.25 x 350	110-140	CS113627
				4.00 x 350	150-180	CS113628

### APPLICATIONS

- High performance basic graphite coated electrode. Regular melting without slagging. To prevent cold cracking, preheating from 300° to 700 °C is recommended, depending on the size of the part. For thin refill thicknesses, a cushion layer with xARC 307 or xARC 312 is required.
- Suitable for applications where high resistance to mineral abrasion is required. Kneading blades, excavator parts, crushers, augers, transport screws and extrusion screws.

## xARC DUR 65 DIN 8555: E 10-UM-65-GRZ

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 4.2 Si = 2.00 Cr = 20.00 Mn = 0.25 Mo = 6.2 Nb = 4.7 V = 0.7 W = 1.3	65 HRc			3.25 x 350	120-160	CS113631
				4.00 x 350	180-210	CS113632

### APPLICATIONS

- Electrode coated with high-performance base graphite containing filler alloy elements.
- Regular melting, practically non-existent slag. High-alloy C-Cr-Mo-W-V-Nb deposit, mainly suitable for refills subjected to heavy abrasive wear with a maximum operating temperature of 600°C.
- It is widely used in refills subjected to strong to extreme mineral abrasion in cold and hot conditions.
- Examples of refills: kiln and cement plant equipment, mixing and agitator blades and knives, conveying and extrusion screws, drilling equipment, scrapers, etc.

## xARC DUR FAST STEELS DIN 8555: E 4-UM-60-ST

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1 Si = 0.8 Cr = 5.00 Mn = 0.4 Mo = 6.5 V = 2.2 W = 2.3	60 HRc		 PA PB	2.50 x 350	60-90	CS113634
			 PC PF	3.25 x 350	80-120	CS113635
			 PE	4.00 x 350	120-160	CS113636

### APPLICATIONS

- Electrode with rutile-basic coating, good weldability, easy slag removal.
- Particularly suitable for edge loading.  
The deposited metal has excellent resistance to abrasion combined with moderate impact up to 550°C and metal-to-metal wear.
- Suitable for the manufacture and repair of cutting tools, cold shear blades, guides, wires, etc.

## xARC DUR FAST STEELS SPECIAL DIN 8555: E 4-UM-65-ST




CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1.1 Si = 1.1 Cr = 3.5 Co = 3.5 Mo = 5.5 V = 2.3 W = 5.00	64 HRc		 PA	2.50 x 300	80-100	CS113638
				3.25 x 350	110-150	CS113639
				4.00 x 450	150-190	CS113640

### APPLICATIONS

- Electrode with rutile-basic coating, good weldability, easy ignition.
- Particularly suitable for edge loading.
- The deposited metal has excellent abrasion resistance combined with moderate impact up to 550°C and metal-to-metal wear.
- Suitable for the manufacture and repair of cutting tools, cold cutting blades, guides, wires, etc.






## xARC DUR COBALT 1 AWS/ASME SFA-5.13: E Co Cr-C | DIN 8555: E 20-UM-55-CTZ

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 2.0 Si = 0.7 Cr = 32.00 Mn = 0.5 Ni = 1.8 Fe = 2.5 W = 12.5	55 HRc			3.25 x 350	90-120	CS113643
				4.00 x 450	120-160	CS113644

### APPLICATIONS

- Rutile coated electrode with good weldability and easy slag removal.
- It is mainly used to recharge parts subject to: strong to very strong metallic abrasion, weak mechanical impact, weak thermal impact, very strong erosion and corrosion, cavitation, high temperature up to 800°C, compression. It is used to recharge rolling guides, pump shafts, extrusion dies, etc.
- The deposit has a tendency to crack, observe a preheating temperature of 300-450°C and make the first pass with xARC DUR COBALT 6 or 12.




## xARC DUR COBALT 6 AWS/ASME SFA-5.13: E Co Cr-A | DIN 8555: E 20-UM-45-CTZ

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.9 Si = 1 Cr = 29 Mn = 0.8 Fe = 3 Ni = 2.5 W = 4.7	42 HRc			3.25 x 350	90-120	CS113646
				4.00 x 450	120-160	CS113647

### APPLICATIONS

- Electrode with rutile-basic coating, good weldability and easy slag removal.
- It is used to recharge parts subjected to: medium abrasion, medium to strong mechanical impacts, medium thermal impact, severe erosion and corrosion, cavitation, high temperature up to 650°C, medium thermal impact, severe erosion and corrosion, cavitation, metal friction, compression.
- It is widely used to load hot shear blades, casting tools, pump valve seats, extrusion screws, etc.

## xARC DUR COBALT 12 AWS/ASME SFA-5.13: E Co Cr-B | DIN 8555: E 20-UM-50-CTZ



CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1.2 Si = 1.2 Cr = 30 Fe = 3.2 Ni = 2.3 W = 8.7	48 HRc		 PA PB	3.25 x 350	90-120	CS113649
			 PC PF	4.00 x 450	120-160	CS113650

### APPLICATIONS

- Rutile coated electrode with good weldability and easy slag removal.
- It is used to recharge parts subjected to: medium to strong abrasion, light to medium mechanical shocks, light to medium thermal shocks, severe erosion and corrosion, cavitation, high temperatures up to 800°C, metal friction, compression.
- Widely used to rebuild the profile of paper, cardboard, wood and plastic cutting tools, grinding knife refills, mixer blades and knives, sliding guides, hot cutting blades, etc.

## ALUMINUM ALLOYS



### xARC AL Si5 AWS/ASME SFA-5.3: E 4043 | DIN 1732: EL Al Si5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 5.2 Cu = 0.20 Al = 93.8 Fe = 0.8	>120 R <sub>m</sub> (N/mm <sup>2</sup> ) >40 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >8 A <sub>5</sub> (%)		 PA PB	2.50 x 350	-	CS113651
				3.25 x 350	-	CS113652

#### APPLICATIONS

- Electrode for welding aluminium and its alloys.

### xARC AL Si12 AWS/ASME SFA-5.3: E 4047 | DIN 1732: EL Al Si12

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 11.8 Fe = 0.8	-		 PA	2.50 x 350	50-80	CS113653
				3.25 x 350	70-120	CS113654

#### APPLICATIONS

- Electrode with a special coating and an aluminium core with 12% Si (ER 4047).
- It is used for welding pure aluminium and alloys AlSi - AlMg - AlMgSi - AlCu.
- Suitable for repairing aluminium parts in all areas and especially aluminium alloys with aluminium alloys with a silicon content of more than 7%.
- It is recommended, especially for large thicknesses (> 10 mm), preheating the base material to around 150 - 250°C is recommended.

## CUT AND BEVEL

### xARC CUT

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
-	-			2.50 x 350	-	CS113655
-	-			3.25 x 350	150-250	CS113656
-	-			4.00 x 450	200-300	CS113657
-	-			5.00 x 450	250-400	CS113658

#### APPLICATIONS

- Electrode for cutting and drilling all types of metals: alloyed and non-alloyed steels, non-ferrous metals, cast iron and cast steels.
- Used for removing defects in castings. Excellent for removing rivets, dismantling work on building sites, cutting unwanted metal in foundries.
- A slight reciprocating motion will help push the molten metal out of the cut.









### xARC GOUGE

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
-	-			2.50 x 350	-	CS113659
-	-			3.25 x 350	200-300	CS113660
-	-			4.00 x 450	250-350	CS113661
-	-			5.00 x 450	350-450	CS113662

#### APPLICATIONS

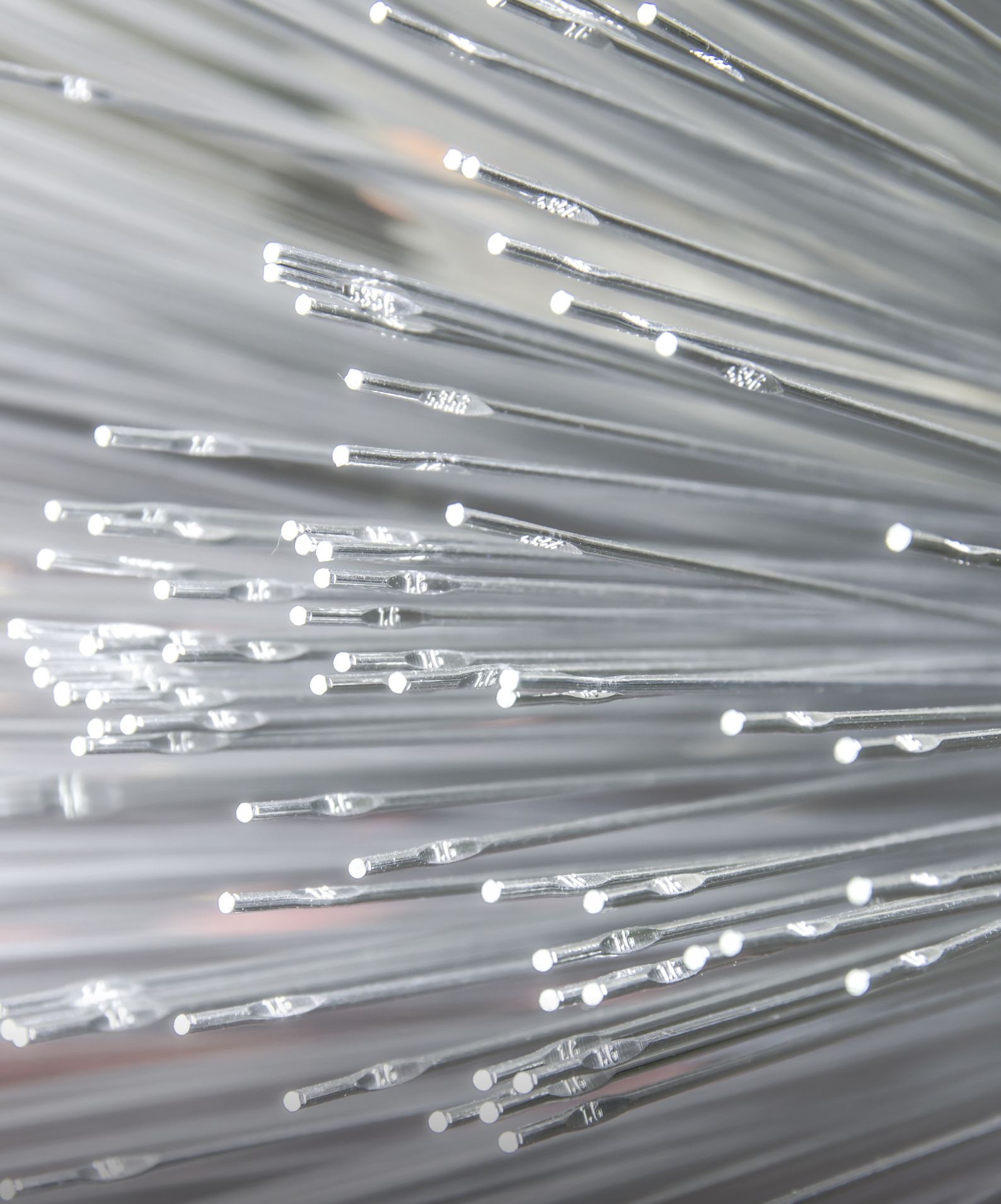
- Special covered electrode for gouging or chamfering all metal materials, including mild steels, low alloy steels, stainless steels, cast iron, copper, bronze and aluminium.
- The super-powerful gouge strikes easily and generates high gas pressure, allowing for a clean gouge.
- Used for removing defects in castings or risers and gates, gouging defective welds, back gouging roots and removing rivets.
- The electrode should be placed on the base material as horizontally as possible.
- The working speed is increased by slight pushing movements in the working direction.

## xARC CARBON

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
-	-		 PA	4.00 x 305	-	CS113663
			 PB	5.00 x 305	-	CS113664
			 PC	6.40 x 305	-	CS113665
			 PD	8.00 x 305	-	CS113666
			 PE	9.50 x 305	-	CS113667
			 PF	12.70 x 305	-	CS113668
			 PG	12.70 x 430	-	CS114107

### APPLICATIONS

- Low conductivity copper-coated carbon electrode suitable for cutting, chamfering and cleaning defective welds on steel, cast iron and non-ferrous metals.
- The depth of the metal to be cut into the workpiece must not exceed the diameter of the electrode.
- In DC (-) it provides greater metal removal speed, and to be used in AC the power supply must have a minimum no-load voltage of 70V.



# TIG RODS



## LOW AND MEDIUM CARBON STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC S3	AWS/ASME SFA-5.18: ER 70 S-3   EN ISO 14341-A: G2 Si   EN ISO 636-A: W2 Si   EN 440: G2 Si	50
xARC SG2	AWS/ASME SFA-5.18: ER 70 S-6   EN ISO 14341-A: G 42 4 M21 3Si1	50
xARC SG3	AWS/ASME SFA-5.18: ER 70 S-6   EN ISO 14341-A: G 46 5 M21 4Si1	51

## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC 80 NI1	AWS/ASME SFA-5.28: ER 80 S-Ni1   EN ISO 14341-A: G3 Ni1   EN ISO 636-A: W3 Ni	52
xARC 80 NI2	AWS/ASME SFA-5.28: ER 80 S-Ni2   EN ISO 14341-A: G2 Ni2   EN ISO 636-A: W3 Ni2	52

## TEMPERATURE RESISTANT STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC MO	AWS/ASME SFA-5.28: ER 70 S-A1   EN ISO 14341-A: G2 Mo   EN ISO 636-A: W2 Mo   EN 440: G2 Mo	53
xARC 80 D2	AWS/ASME SFA-5.28: ER 80 S-D2   EN ISO 14341-A: G4 Mo   EN 440: G4 Mo   MAT. N° 1.5428	53
xARC 80 SG	AWS/ASME SFA-5.28: ER 80 S-G   EN 12070: Cr Mo1 Si   DIN 8575: SG Cr Mo1   MAT. N° 1.7339	54
xARC 80 B2	AWS/ASME SFA-5.28: ER 80 S-B2   EN ISO 21952-B: 1CM	54
xARC 80 B6	AWS/ASME SFA-5.28: ER 80 S-B6   EN 12070: Cr Mo5 Si   EN ISO 21952-A: Cr Mo5 Si	55
xARC 90 SG	AWS/ASME SFA-5.28: ER 90 S-G   EN 12070: Cr Mo2 Si   EN ISO 21952-A: Cr Mo2 Si	55
xARC 90 B3	AWS/ASME SFA-5.28: ER 90 S-B3   EN ISO 21952-B: 2C1M	56
xARC 90 B9	AWS/ASME SFA-5.28: ER 90 S-B9   EN 12070: Cr Mo9 1   EN ISO 21952-A: Cr Mo9 1	56

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 308L SI	AWS/ASME SFA-5.9: ER 308L Si   EN 12072: W 19 9 L Si	57
xARC FLUX 308L	AWS/ASME SFA-5.22: R 308L T1-5	57
xARC 316L SI	AWS/ASME SFA-5.9: ER 316L Si   EN 12072: W 19 12 3 LSi	58
xARC FLUX 316L	AWS/ASME SFA-5.22: R 316L T1-5	58
xARC 310	AWS/ASME SFA-5.9: ER 310   EN 12072: W 25 20	59
xARC 317L	AWS/ASME SFA-5.9: ER 317L   EN 12072: W 19 15 3 L	59
xARC 318	AWS/ASME SFA-5.9: ER 318   EN ISO 14343-A: W 19 12 3 Nb	60
xARC 347	AWS/ASME SFA-5.9: ER 347   EN ISO 14343-A: W 19 9 Nb	60
xARC 385	AWS/ASME SFA-5.9: ER 385   EN 14343-A: W 20 25 5 Cu L	61

DESIGNATION	CLASSIFICATION	PAG.
xARC 410	AWS/ASME SFA-5.9: ER 410   EN ISO 14343- A: G 13	61
xARC 430	AWS/ASME SFA-5.9: ER 430   EN ISO 14343- A: G 17	62
xARC DUPLEX	AWS/ASME SFA-5.9: ER 2209   EN 14343 - A: W 22 9 3 N L	62
xARC SUPER DUPLEX	AWS/ASME SFA-5.9: ER 2594   EN 14343 - A: W 25 9 4 N L	63

## SPECIAL APPLICATIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC 307 SI	AWS/ASME SFA-5.9: ER 307 Si   EN ISO 14343-A: W 18 8 Mn	64
xARC 309L SI	AWS/ASME SFA-5.9: ER 309L Si   EN 12072: W 23 12 LSi	64
xARC FLUX 309L	AWS/ASME SFA-5.22: R 309L T1-5	65
xARC 309L MO	AWS/ASME SFA-5.9: ER 309L Mo   EN 12070: W 23 12 2 L	65
xARC 312	AWS/ASME SFA-5.9: ER 312   EN 12072: W 29 9	66

## NICKEL BASED STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC NICKR 3	AWS/ASME SFA-5.14: ER NiCr-3   EN ISO 18274: W Ni 6082 (NiCr20Mn3Nb)	67
xARC NICKRMO 3	AWS/ASME SFA-5.14: ER NiCrMo-3   EN 18274: S Ni 6625 (NiCr22Mo9Nb)	67
xARC NICKU 7	AWS/ASME SFA-5.14: ER NiCu-7   EN ISO 18274: S Ni 4060   MAT. N° 2.4377	68

## CAST IRON

DESIGNATION	CLASSIFICATION	PAG.
xARC NI 1	AWS/ASME SFA-5.14: ER Ni 1   EN ISO 18274: S Ni 2061   MAT. N° 2.4155	69

## TITANIUM

DESIGNATION	CLASSIFICATION	PAG.
xARC TI 2	AWS/ASME SFA-5.16: ER Ti 2   EN ISO 24034: S Ti 0120   MAT. N° 3.7035	70



## COPPER ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC COBRE	AWS/ASME SFA-5.7: ER Cu   EN ISO 24373: S Cu 1898A-CuSn1MnSi   DIN 1733: W CuSn	71
xARC CUSN 6	AWS/ASME SFA-5.7: ER Cu Sn-A   EN ISO 24373: S Cu 5180A-CuSn6P   DIN 1733: W CuSn6	71
xARC CUSN 12	EN ISO 24373: S Cu 5410   MAT. N° 2.1056	72
xARC CUAL 8	AWS/ASME SFA-5.7: ER Cu-Al-A1   EN ISO 24373: S Cu 6100-CuAl7   DIN 1733: W CuAl8	72
xARC CUSI 3	AWS/ASME SFA-5.7: ER Cu Si-A   EN ISO 24373: S Cu 6560-CuSi3Mn1   DIN 1733: W CuSi3	73
xARC CUNI30	AWS/ASME SFA-5.7: ER Cu Ni   EN ISO 24373-A: S Cu 7158   MAT. N° 2.0837	73

## HARDFACING

DESIGNATION	CLASSIFICATION	PAG.
xARC DUR 600	EN ISO 14700: S Fe8   DIN 8555: WSG 6-GZ-60   MAT. N° 1.4718	74
xARC DUR 3348	AISI: M7   MAT. N° 1.3348	74

## ALUMINUM ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC AL SI5	AWS/ASME SFA-5.10: ER 4043   EN ISO 18273: S Al 4043 (AlSi5)	75
xARC AL SI12	AWS/ASME SFA-5.10: ER 4047A   EN ISO 18273: S Al 4047A (AlSi12(A))	75
xARC AL MG3	AWS/ASME SFA-5.10: ER 5754   EN ISO 18273: S Al 5754 (AlMg3)	76
xARC AL MG5	AWS/ASME SFA-5.10: ER 5356   EN ISO 18273: S Al 5356 (AlMg5Cr(A))	76
xARC AL MG4.5 MN	AWS/ASME SFA-5.10: ER 5183   EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A))	77
xARC AL 99.7	AWS/ASME SFA-5.10: ER 1070   EN ISO 18273: S Al 1070 (Al 99.7)	77
xARC MAGNÉSIO	AWS/ASME SFA-5.19: ~R AZ61 A	78

## LOW AND MEDIUM CARBON STEELS

**xARC S3** AWS/ASME SFA-5.18: ER 70 S-3 | EN ISO 14341-A: G2 Si | EN ISO 636-A: W2 Si | EN 440: G2 Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.65 Mn = 1.15	530 R <sub>m</sub> (N/mm <sup>2</sup> ) 430 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 24 A <sub>5</sub> (%) +20°C 16 ISO - V (J)	=	-	1.6 x 1000	-	CS113669
				2.0 x 1000	-	CS113670
				2.4 x 1000	-	CS113671

### APPLICATIONS

- Suitable for welding carbon-manganese and low-alloy steels. Characterised by limited slag production. It can be galvanised afterwards.
- Tanks, containers, vehicle repairs, structural work, domestic appliances, pipework, boilers, applications in the naval sector, petrochemical industry, etc.

### BASE MATERIALS

- ASTM A285; A283; A572.
- EN S275ML; P235G1TH; P255NH; P355GH; S420ML; P310GH.

### PROTECTIVE GAS

- I1

**xARC SG2** AWS/ASME SFA-5.18: ER 70 S-6 | EN ISO 14341-A: G 42 4 M21 3Si1 | EN ISO 14341-A: G 42 3 C1 3Si1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.92 Cr = 0.01 Cu = 0.07 Mn = 1.67 Mo = 0.01 Ni = 0.02 S = 0.008 P = 0.008 V = 0.001	560 R <sub>m</sub> (N/mm <sup>2</sup> ) 470 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%) -30°C 80 ISO - V (J)	=	-	1.6 x 1000	-	CS113672
				2.0 x 1000	-	CS113673
				2.4 x 1000	-	CS113674
				3.2 x 1000	-	CS113675
				4.0 x 1000	-	CS113676

### APPLICATIONS

- Copper-coated carbon steel welding rods with gas protection for fabricating mild steel.
- It provides excellent usability with a stable arc and good bead appearance
- The weld metal has excellent mechanical performance and is less sensitive to pores.
- Used for welding carbon and alloy steel structures with a tensile strength of 500 MPa, and high-speed welding of plates and pipes.

### PROTECTIVE GAS

- I1

**xARC SG3** AWS/ASME SFA-5.18: ER 70 S-6 | EN ISO 14341-A: G 46 5 M21 4Si1 | EN ISO 14341-A: G 42 4 C1 4Si1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.92 Cr = 0.01				1.6 x 1000	-	CS113677
Cu = 0.07 Mn = 1.67 Mo = 0.01 Ni = 0.02 P = 0.010 S = 0.92 V = 0.001	560 R <sub>m</sub> (N/mm <sup>2</sup> ) 470 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%) -30°C 80 ISO - V (J)	=	-	2.0 x 1000	-	CS113678
				2.4 x 1000	-	CS113679

## APPLICATIONS

- ▶ Copper-coated carbon steel welding rods with gas protection for fabricating mild steel.
- ▶ It provides excellent usability with a stable arc and good bead appearance. The weld metal has excellent mechanical performance and is less sensitive to pores.
- ▶ Used for welding carbon and alloy steel structures with a tensile strength of 500MPa, and high-speed welding of plates and pipes.

## PROTECTIVE GAS

- ▶ I1

## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

### xARC 80 Ni1 AWS/ASME SFA-5.28: ER 80 S-Ni1 | EN ISO 14341-A: G3 Ni1 | EN ISO 636-A: W3 Ni

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.70	600 R <sub>m</sub> (N/mm <sup>2</sup> )	=	-	1.6 x 1000	-	CS113680
Cr ≤ 0.15 Cu ≤ 0.25	480 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%)			2.0 x 1000	-	CS113681
Mn = 1.20 Mo ≤ 0.15 Ni = 1.00	+20°C 185 ISO - V (J)			2.4 x 1000	-	CS113682

#### APPLICATIONS

- Fine-grained low-alloy steels and also austempered steels for applications from -30°C to +350°C.
- Used in the construction of cranes, transport, tanks, industrial installations, equipment in general, pipelines, shipbuilding, etc.

#### BASE MATERIALS

- A 106; A515; A714; A131; A369; A210; L290; P235 T1/T2; P275 T1; L360; L415; P275T2; P355N; API X-42; X46; X62; X60; P235GH; P355GH; A283; A285; A414; A372; A662; S275; S420; A516; A255; A333; A350; A350; A612.

#### PROTECTIVE GAS

- I1

### xARC 80 Ni2 AWS/ASME SFA-5.28: ER 80 S-Ni2 | EN ISO 14341-A: G2 Ni2 | EN ISO 636-A: W3 Ni2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.50	630 R <sub>m</sub> (N/mm <sup>2</sup> )	=	-	1.6 x 1000	-	CS113683
Cu ≤ 0.25	530 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%)			2.0 x 1000	-	CS113684
Mn = 1.10 Ni = 2.50	+20°C 230 ISO - V (J)			2.4 x 1000	-	CS113685

#### APPLICATIONS

- Applications down to -60°C (-76°F), in mild steels, light alloy steels and fine grain steels.
- Plates, storage tanks, pipework and equipment for cryogenic use.

#### BASE MATERIALS

- S235NL2; 14Ni6; 12Ni14; X12Ni5; S255N; S380N; S255NL; S380NL; S 255NL1; S380NL1; A333:Gr.1-3; A442:Gr.55-60; A334:Gr.3; 10Ni14; 13MnNi63; TTSt E355; TTSt E 460; HY 80; TT SE 35 N.

#### PROTECTIVE GAS

- I1

## TEMPERATURE RESISTANT STEELS

**xARC MO** AWS/ASME SFA-5.28: ER 70 S-A1 | EN ISO 14341-A: G2 Mo | EN ISO 636-A: W2 Mo | EN 440: G2 Mo

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.60 Cr ≤ 0.15 Cu ≤ 0.25 Mn = 1.20 Mo ≤ 0.15 Ni ≤ 0.15	610 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 25 A <sub>5</sub> (%) +20°C 150 ISO - V (J)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">=</div>	-	1.6 x 1000	-	CS113686
				2.0 x 1000	-	CS113687
				2.4 x 1000	-	CS113688
				3.2 x 1000	-	CS113689

### APPLICATIONS

- Structural steels resistant to heat and creep in hot work. Pipes, steam boilers, pressure vessels, gas pipelines, shipbuilding, chemicals, petrochemicals, equipment, crane construction.
- V and Nb increase resistance to deformation, corrosion, thermal oxidation and cracking over time. Suitable for thermal power stations, turbine rotors, petrochemical plants.

### BASE MATERIALS

- P295GH; P335GH; 16M03; 17M03; 14M06; S275; S355; S420; A210, A285; A335; A369; A516; S275ML; S355M; S420M; S460; 15M03; 10MnMo45; 11MnMo45; GS60; GS22M04; 20MnMoNi5-5; 15NiCuMoNd5S; 17MnMoV64.

### PROTECTIVE GAS

- l1

**xARC 80 D2** AWS/ASME SFA-5.28: ER 80 S-D2 | EN ISO 14341-A: G4 Mo | EN 440: G4 Mo | MAT. N° 1.5428

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.70 Cr ≤ 0.15 Cu ≤ 0.25 Mn = 1.90 Mo ≤ 0.15 Ni ≤ 0.15	670 R <sub>m</sub> (N/mm <sup>2</sup> ) 550 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 24 A <sub>5</sub> (%) -20°C 50 ISO - V (J)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">=</div>	-	1.6 x 1000	-	CS113690
				2.0 x 1000	-	CS113691
				2.4 x 1000	-	CS113692

### APPLICATIONS

- Creep-resistant steels for hot working in the construction industry. Steam boilers, pressure vessels, gas pipelines, shipbuilding, petrochemical industry, heat exchangers, crane construction, bridges, etc.
- Fine-grained NiCrMo steels for low-temperature applications. Used in the industrial sectors of means of transport and earthmoving. Construction, bridges, cisterns, railway transport, mining industry, shipbuilding, etc.

### BASE MATERIALS

- P235G1TH; P255G1TH; P310GH; 16M03; A255; A350; A612; A210; A333; A316; A369; A106.

### PROTECTIVE GAS

- l1

## xARC 80 SG AWS/ASME SFA-5.28: ER 80 S-G | EN 12070: Cr Mo1 Si | DIN 8575: SG Cr Mo1 | MAT. N° 1.7339

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.65 Cr = 1.15 Cu ≤ 0.25 Mn = 1.05 Mo = 0.50	630 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 23 A <sub>5</sub> (%) +20°C 110 ISO - V (J)		-	1.6 x 1000	-	CS113693
				2.0 x 1000	-	CS113694
				2.4 x 1000	-	CS113695

### APPLICATIONS

- For heat-resistant steels. Provides good resistance to attack by hydrogen and sulphur agents.
- Used in steam boilers, pressure tanks, pipework, cranes, earthmoving machinery, presses, the chemical and petrochemical industry.

### BASE MATERIALS

- 13CrMo4-5; 15CrMo5; 16CrMoV4; 22M04; G17CrMo5-5; G22CrMo5- 4; A193 Gr.B7; A335 P11-P12; A193:B7; 13CrMo4-5; 15CrMo3; 13CrMo44; 15CrMo3; 13CrMo4 2; GS-25CrMo 4; GS-17 CrMo55; GS17CrMo55; GS22CrMo4; H IV; 15CrMo3; 13CrMoV42; 13CrMo44; St44KL;

### PROTECTIVE GAS

- I1

## xARC 80 B2 AWS/ASME SFA-5.28: ER 80 S-B2 | EN ISO 21952-B: 1CM

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.55 Cr = 1.30 Cu ≤ 0.25 Mn = 0.60 Mo = 0.50 Ni ≤ 0.20	620 R <sub>m</sub> (N/mm <sup>2</sup> ) 510 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 24 A <sub>5</sub> (%) +20°C 120 ISO - V (J)		-	1.6 x 1000	-	CS113696
				2.0 x 1000	-	CS113697
				2.4 x 1000	-	CS113698

### APPLICATIONS

- For Cr-Mo steels resistant to heat and cracking.
- Boilers, material handling machines, pipework. Chemical and petrochemical industry, especially when dealing with sulphur products.


### BASE MATERIALS

- 13 CrMo4-5(1.7335); G17CrMo55; A387:2,11,12; A199:T11; A200:T11; A213:T11,T12; GS- 25CrMo 4 (1.7128 ) GS 18CrMo910(1.7379); 10CrMo910(1.7380); 10CrSi-MoV7(1.8075); 10CrV63; 12CrNiMo8.

### PROTECTIVE GAS

- I1

## xARC 80 B6 AWS/ASME SFA-5.28: ER 80 S-B6 | EN 12070: Cr Mo5 Si | EN ISO 21952-A: Cr Mo5 Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.45 Cr = 5.70 Cu ≤ 0.25 Mn = 0.60 Mo = 0.60 Ni ≤ 0.20	660 R <sub>m</sub> (N/mm <sup>2</sup> ) 560 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) +20°C 180 ISO - V (J)		-	1.6 x 1000	-	CS113699
				2.0 x 1000	-	CS113700
				2.4 x 1000	-	CS113701

### APPLICATIONS

- Cr-Mo alloy steels resistant to oxidation, heat, corrosion and wear.
- Steam boiler sectors, pressure vessels, thermoelectric, chemical and petrochemical plants, oil cracking plants and also slide rails, excavators, moulds, etc.


### BASE MATERIALS

- X12CrMo5(1.7362); GX12CrMo5(1.7363); A213; A217:C5; A335:P5; GS 12CrMo19 5 (1.7363)

### PROTECTIVE GAS

- I1

## xARC 90 SG AWS/ASME SFA-5.28: ER 90 S-G | EN 12070: Cr Mo2 Si | EN ISO 21952-A: Cr Mo2 Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.60 Cr = 2.50 Cu ≤ 0.25 Mn = 1.00 Mo = 1.00	650 R <sub>m</sub> (N/mm <sup>2</sup> ) 550 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) +20°C 150 ISO - V (J)		-	1.6 x 1000	-	CS113702
				2.0 x 1000	-	CS113703
				2.4 x 1000	-	CS113704

### APPLICATIONS

- Cr-Mo alloy steels, resistant to high temperatures, wear, impact and corrosion.
- Boiler tubes, steam boilers, pressure vessels.

### BASE MATERIALS

- 10CrMo9-10;(1.7380); 10CrSiMoV7(1.8075); G17CrMo9-10(1.7379); A335:P 22; GS 10CrSiMoV7; 12CrSiMo8; GS17Cr-MoV5 11.

### PROTECTIVE GAS

- I1

## xARC 90 B3 AWS/ASME SFA-5.28: ER 90 S-B3 | EN ISO 21952-B: 2C1M

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.50 Cr = 2.40 Cu ≤ 0.25 Mn = 0.60 Mo = 1.00 Ni ≤ 0.20	640 R <sub>m</sub> (N/mm <sup>2</sup> ) 540 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) +20°C 150 ISO - V (J)		-	1.6 x 1000	-	CS113705
				2.0 x 1000	-	CS113706
				2.4 x 1000	-	CS113707

### APPLICATIONS

- Cr-Mo alloy steels resistant to high temperatures, corrosion and attack by sulphur agents.
- Boilers, pipework, steam boilers, pressure vessels, oil industry, thermoelectric industry, chemical and petrochemical industry.

### BASE MATERIALS

- 10CrMo9-10(1.7380); GS 17CrMoV5 11; 10CrSiMoV7; 12CrSiMo8; GS12CrMo9 10; 10CrSiMoV7; 10Cr V63; 12CrSiMo8.

### PROTECTIVE GAS

- I1

## xARC 90 B9 AWS/ASME SFA-5.28: ER 90 S-B9 | EN 12070: Cr Mo9 1 | EN ISO 21952-A: Cr Mo9 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.30 Cr = 9.10 Cu ≤ 0.20 Mn = 0.50 Mo = 0.90 Ni = 0.50 V = 0.20	780 R <sub>m</sub> (N/mm <sup>2</sup> ) 690 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 21 A <sub>5</sub> (%) +20°C 150 ISO - V (J)		-	1.6 x 1000	-	CS113708
				2.0 x 1000	-	CS113709
				2.4 x 1000	-	CS113710

### APPLICATIONS

- The addition of V and Nb increases resistance to deformation, corrosion and thermal oxidation.
- Excellent resistance to creep and hydrogen.
- Suitable for thermoelectric power stations, turbine rotors, petrochemical plants.

### BASE MATERIALS

- X10CrMoVNb9-1(1.4903); X12CrMo9- 1(1.7386); A335:P91; A213:T91; A387:91; A182:F91; X 20CrMoV12-1.

### PROTECTIVE GAS

- I1



## STAINLESS STEEL

### xARC 308L Si AWS/ASME SFA-5.9: ER 308L Si | EN 12072: W 19 9 L Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.65-2.20 Cr = 19.50-22.00 Cu = 0.75 Mn = 1.50-2.20 Mo = 0.75 Ni = 9.00-22.00 P = 0.03 S = 0.03	$\geq 520 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 5 A_5$ (%) 20°C $\geq 47$ ISO - V (J)			1.0 x 1000	-	CS113711
				1.2 x 1000	-	CS113712
				1.6 x 1000	-	CS113713
				2.0 x 1000	-	CS113714
				2.4 x 1000	-	CS113715
				3.2 x 1000	-	CS113716

#### APPLICATIONS

- ▶ TIG welding rods made of 20 Cr / 10 Ni stainless steel with a composition similar to ER 308LSi, suitable for welding austenitic stainless steels such as 18 Cr / 8 Ni AISI 304, 304L and 308LSi type steels.
- ▶ Excellent corrosion resistance and good mechanical properties. Ferrite control between 5 and 10 per cent. Silicon - an approximate content of 0.85 improves weldability and the appearance of the seam.

#### PROTECTIVE GAS

- ▶ I1

### xARC FLUX 308L AWS/ASME SFA-5.22: R 308L T1-5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.60 Cr = 19.50 Mn = 0.90 Ni = 10.00	$620 R_m$ (N/mm <sup>2</sup> ) $460 R_{p0.2}$ (N/mm <sup>2</sup> ) $45 A_5$ (%) +20°C 140 ISO - V (J)			2.2 x 1000	80-140	CS113717

#### APPLICATIONS

- ▶ Filler rod with flux core for TIG welding.
- ▶ Produces slag to protect the reverse side of the root pass from oxidisation by the atmosphere.
- ▶ Saves the cost of subsequent shielding gases.
- ▶ Eliminates downtime for gas purging, perfectly suited to welding stainless steel pipes.

#### PROTECTIVE GAS

- ▶ I1

## xARC 316L Si AWS/ASME SFA-5.9: ER 316L Si | EN 12072: W 19 12 3 LSi

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.65-1.20 Cr = 18.00-20.00 Cu = 0.25 Mn = 1.50-2.50 Mo = 2.50-3.00 Ni = 11.00-14.00 P = 0.03 S = 0.020	$\geq 520 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 47$ ISO - V (J)			1.0 x 1000	-	CS113718
				1.2 x 1000	-	CS113719
				1.6 x 1000	-	CS113720
				2.0 x 1000	-	CS113721
				2.4 x 1000	-	CS113722
				3.2 x 1000	-	CS113723

### APPLICATIONS

- Extra low carbon TIG stainless steel rod 19 Cr/ 12 Ni/ 3 Mo /0.85 Si, suitable for welding or cladding materials with similar compositions.
- The weld metal has excellent creep resistance up to 850°C. Ferrite control between 5 and 10 per cent.
- The weld metal has excellent properties in terms of resistance to cracking, intergranular corrosion and creep.
- Excellent mechanical properties and excellent appearance of the weld bead.

### PROTECTIVE GAS

- I1

## xARC FLUX 316L AWS/ASME SFA-5.22: R 316L T1-5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.50 Cr = 18.50 Mn = 0.90 Mo = 2.8 Ni = 12.00	$630 R_m$ (N/mm <sup>2</sup> ) $510 R_{p0.2}$ (N/mm <sup>2</sup> ) $32 A_5$ (%) +20°C 140 ISO - V (J)			2.2 x 1000	80-140	CS113724





### APPLICATIONS

- Filler rod with flux core for TIG welding.
- Produces slag to protect the reverse side of the root pass from oxidation by the atmosphere.
- Saves the cost of subsequent shielding gases.
- Eliminates downtime for gas purging, perfectly suited to welding stainless steel pipes.

### PROTECTIVE GAS

- I1

## xARC 310 AWS/ASME SFA-5.9: ER 310 | EN 12072: W 25 20

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08-0.15 Si = 0.30-0.65 Cr = 25.00-28.00 Cu = 0.75 Mn = 1.50-2.20 Mo = 0.75 Ni = 20.00-22.50 P = 0.03 S = 0.03	$\geq 550 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 47$ ISO - V (J)		 PA PB	1.6 x 1000	-	CS113725
			 PC PG	2.0 x 1000	-	CS113726
			 PF PE	2.4 x 1000	-	CS113727

### APPLICATIONS

- Stainless TIG rod conforming to ER 310 with 25% Cr and 20% Ni.
- Suitable for welding steels with similar chemical compositions or dissimilar steels.
- The weld deposit is completely austenitic. Excellent resistance to corrosion at high temperatures.





### BASE MATERIALS

- AISI 310; 1.4845 (X8CrNi25-21); 1.4841 (X15CrNiSi25-21); 1.4828 (X15CrNiSi20-12).

### PROTECTIVE GAS

- I1

## xARC 317L AWS/ASME SFA-5.9: ER 317L | EN 12072: W 19 15 3 L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.30-0.60 Cr = 18.50-20.50 Cu = 0.25 Mn = 1.50-2.20 Mo = 3.00-4.00 Ni = 13.00-15.00 P = 0.03 S = 0.03	$\geq 550 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 27$ ISO - V (J)		 PA PB	1.6 x 1000	-	CS113728
			 PC PF	2.0 x 1000	-	CS113729
			 PE	2.4 x 1000	-	CS113730

### APPLICATIONS

- Suitable for welding or coating materials with similar compositions. The use of xARC 317L is limited to corrosion conditions in the presence of sulphuric and sulphurous acids and their salts.
- Excellent weldability with a spatter-free arc and produces a very smooth bead appearance. The weld metal has excellent resistance properties to cracking, intergranular corrosion and creep.

### PROTECTIVE GAS

- I1

## xARC 318 AWS/ASME SFA-5.9: ER 318 | EN ISO 14343-A: W 19 12 3 Nb

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.080 Si = 0.30-0.65 Cr = 18.00-20.00 Cu = 0.50 Mn = 1.50-2.50 Mo = 2.00-3.00 Ni = 11.00-14.00 P = 0.03 S = 0.03	≥550 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥400 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%) 20°C ≥65 ISO - V (J)	==	 PA PB	1.6 x 1000	-	CS113731
			 PC PF	2.0 x 1000	-	CS113732
			 PE	2.4 x 1000	-	CS113733

### APPLICATIONS

- Suitable for use mainly with Argon shielding gas. Mainly used for welding 316Ti and 316Nb stainless steels in a wide range of applications, including the manufacture of pipes, plates and containers.
- The weld metal offers good resistance to crevice corrosion by oxidising acids.

### PROTECTIVE GAS

- I1

## xARC 347 AWS/ASME SFA-5.9: ER 347 | EN ISO 14343-A: W 19 9 Nb

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.30-0.65 Cr = 19.00-21.50 Cu = 0.75 Mn = 1.50-2.20 Mo = 0.75 Ni = 9.00-11.00 Nb = 10XC-1.00 P = 0.03 S = 0.03	≥550 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥400 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%) 20°C ≥65 ISO - V (J)	==	 PA PB	1.6 x 1000	-	CS113734
			 PC PG	2.0 x 1000	-	CS113735
			 PF PE	2.4 x 1000	-	CS113736

### APPLICATIONS

- Solid TIG welding rod type W 19 9 Nb /ER 347 that deposits a weld metal stabilised with niobium 19Cr 9Ni, suitable for use mainly with Ar shielding gas.
- Used for welding grade 321 and 347 stainless steel in a wide range of applications, including the manufacture of pipes, plates and containers.
- The weld metal has high resistance to corrosive media at operating temperatures <400° C.

### BASE MATERIALS

- AISI 347-321  
1.4541 (X6CrNiTi18-10); 1.4301(X4CrNi18-10); 1.4550 (X6CrNiNb18-10); 1.4541

### PROTECTIVE GAS

- I1

## xARC 385 AWS/ASME SFA-5.9: ER 385 | EN 14343-A: W 20 25 5 Cu L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.025 Si = 0.50 Cr = 19.50-21.50 Cu = 1.20-2.00 Mn = 1.50-2.20 Mo = 4.20-5.20 Ni = 24.00-26.00 P = 0.030 S = 0.020	$\geq 560 R_m$ (N/mm <sup>2</sup> ) $\geq 410 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 35 A_5$ (%) 20°C $\geq 47$ ISO - V (J) -196°C $\geq 32$ ISO - V (J)		 PA PB PC PG PF PE	1.6 x 1000	-	CS113737
				2.0 x 1000	-	CS113738
				2.4 x 1000	-	CS113739

### APPLICATIONS

- TIG welding rod suitable for use with Ar shielding gas.
- Used for welding ASTM 316 or similar steels when a ferrite-free weld metal is required.
- Used in cryogenic and non-magnetic applications. Impact resistance at low temperatures is excellent.
- Also used for welding 904L to ASTM 304 and 316.
- It has excellent resistance to general and crevice corrosion, as well as stress corrosion cracking.

### PROTECTIVE GAS

- I1

## xARC 410 AWS/ASME SFA-5.9: ER 410 | EN ISO 14343- A: G 13

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.12 Si = 0.50 Cr = 11.50-13.50 Cu = 0.75 Mn = 0.60 Mo = 0.75 Ni = 0.60 P = 0.030 S = 0.030	$\geq 450 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 20 A_5$ (%) 20°C $\geq 47$ ISO - V (J)		 PA PB PC PG PF PE	1.6 x 1000	-	CS113740
				2.0 x 1000	-	CS113741
				2.4 x 1000	-	CS113742

### APPLICATIONS

- ER410/G13 type TIG welding rod that deposits a C-13%Cr weld metal.
- Suitable for use with Ar-CO2 shielding gas.
- Mainly used for depositing coatings on carbon steels to resist corrosion, erosion or abrasion.

### PROTECTIVE GAS

- I1

## xARC 430 AWS/ASME SFA-5.9: ER 430 | EN ISO 14343- A: G 17

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.50 Cr = 15.50-17.00 Cu = 0.75 Mn = 0.60 Mo = 0.75 Ni = 0.60 P = 0.030 S = 0.030	≥450 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥400 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥15 A <sub>5</sub> (%) 20°C ≥27 ISO - V (J)		 PA PB	1.6 x 1000	-	CS113743
			 PC PG	2.0 x 1000	-	CS113744
			 PF PE	2.4 x 1000	-	CS113745

### APPLICATIONS

- 16 Cr alloy (% by weight) and the composition is balanced, providing enough chromium to give adequate corrosion resistance for usual applications and yet maintain sufficient ductility in the heat-treated state.

### PROTECTIVE GAS

- I1

## xARC DUPLEX AWS/ASME SFA-5.9: ER 2209 | EN 14343 - A: W 22 9 3 N L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.030 Si = 0.90 Cr = 21.50-23.50 Cu = 0.50 Mn = 0.50-2.00 Mo = 2.50-3.50 Ni = 7.50-9.50 P = 0.03 S = 0.03 N <sub>2</sub> = 0.08-0.20	≥690 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥480 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥22 A <sub>5</sub> (%) 20°C ≥50 ISO - V (J)		 PA PB	1.6 x 1000	-	CS113746
			 PC PG	2.0 x 1000	-	CS113747
			 PF PE	2.4 x 1000	-	CS113748





### APPLICATIONS

- Suitable for use mainly with Ar shielding gas.
- The rod is used for welding duplex stainless steels in a variety of applications, including pipe and sheet fabrication.
- The weld metal offers high resistance to cracking and stress corrosion, especially in media with a high chloride content.

### PROTECTIVE GAS

- I1

## xARC SUPER DUPLEX AWS/ASME SFA-5.9: ER 2594 | EN 14343 - A: W 25 9 4 N L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.030 Si = 1.00 Cr = 24.00-27.00 Cu = 1.50 Mn = 0.50-2.50 Mo = 2.50-4.50 Ni = 8.00-10.50 P = 0.03 S = 0.02 W = 1.00 N2 = 0.20-0.30	$\geq 800 R_m$ (N/mm <sup>2</sup> ) $\geq 550 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 25 A_5$ (%) 20°C $\geq 80$ ISO - V (J)		 PA PB	1.6 x 1000	-	CS113749
			 PC PG	2.0 x 1000	-	CS113750
			 PF PE	2.4 x 1000	-	CS113751

### APPLICATIONS

- TIG welding rod type W 25 9 4 N L that deposits a C-25Cr 10Ni 4Mo weld metal suitable for use mainly with Ar shielding gas.
- Used for welding super-duplex stainless steels.
- Used mainly in offshore applications, the paper industry, the oil industry and the production of artificial fertiliser.
- Used for root pass welding of standard 22%Cr duplex steels for critical applications, and for welding low carbon 13%Cr super martensitic steels.
- The rod has very good resistance to general corrosion, the weld metal has high corrosion resistance combined with good resistance to crevice corrosion and stress corrosion cracking.

### PROTECTIVE GAS

- I1

## SPECIAL APPLICATIONS

### xARC 307 SI AWS/ASME SFA-5.9: ER 307 Si | EN ISO 14343-A: W 18 8 Mn

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.020 Si = 1.20 Cr = 17.00-20.00 Cu = 0.30 Mn = 5.00-8.00 Mo = 0.30 Ni = 7.00-10.00 P = 0.03 S = 0.03	≥590 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥420 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥40 A <sub>5</sub> (%) 20°C ≥100 ISO - V (J)	==	 PA PB	1.6 x 1000	-	CS113752
			 PC PF	2.0 x 1000	-	CS113753
			 PE	2.4 x 1000	-	CS113754

#### APPLICATIONS

- Austenitic stainless steel with added manganese and silicon, used mainly for bonding and cladding applications for work-resistant steels, armour plates, heat-resistant steels and dissimilar steels, such as austenitic manganese steels, for carbon steel forgings and castings.
- The welding deposits are porosity-free, crack-resistant and corrosion-resistant.

#### PROTECTIVE GAS

- I1

### xARC 309L SI AWS/ASME SFA-5.9: ER 309L Si | EN 12072: W 23 12 LSi

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.65-1.00 Cr = 23.00-25.00 Cu = 0.75 Mn = 1.50-2.20 Mo = 0.75 Ni = 12.00-14.00 P = 0.03 S = 0.03	≥520 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥350 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%) 20°C ≥47 ISO - V (J)	==	 PA PB	1.6 x 1000	-	CS113755
			 PC PG	2.0 x 1000	-	CS113756
			 PF PE	2.4 x 1000	-	CS113757

#### APPLICATIONS

- Stainless TIG rod for welding austenitic stainless steels such as AISI 309LSi. It is also used for welding dissimilar steels and for cushion and buttery layers of 18 Cr/8 Ni steels.
- Excellent resistance to oxidation and corrosion in continuous service up to 1100°C. The ferrite content is approximately 15%. The Si content of approximately 0.85% improves weldability and bead appearance.

#### PROTECTIVE GAS

- I1



## xARC FLUX 309L AWS/ASME SFA-5.22: R 309L T1-5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.80 Cr = 24.50 Mn = 1.50 Ni = 13.00	580 R <sub>m</sub> (N/mm <sup>2</sup> ) 460 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 35 A <sub>5</sub> (%) 20°C 70 ISO - V (J)		 PA  PB  PC  PD  PF  PE	2.2 x 1000	80-140	CS113758

### APPLICATIONS

- Filler rod with flux core for TIG welding.
- Produces slag to protect the reverse side of the root pass from oxidisation by the atmosphere.
- Saves the cost of subsequent shielding gases.
- Eliminates downtime for gas purging, perfectly suited to welding stainless steel pipes.

### PROTECTIVE GAS

- I1

## xARC 309L MO AWS/ASME SFA-5.9: ER 309L Mo | EN 12070: W 23 12 2 L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.030 Si = 0.30-0.65 Cr = 23.00-25.00 Cu = 0.50 Mn = 1.00-2.50 Mo = 2.0-3.0 Ni = 12.00-14.00 P ≤ 0.025 S ≤ 0.02	≥550 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥350 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%) 20°C ≥45 ISO - V (J)		 PA  PB  PC  PG  PF  PE	1.6 x 1000	-	CS113759
				2.0 x 1000	-	CS113760
				2.4 x 1000	-	CS113761




### APPLICATIONS

- Stainless TIG rod with 25% Cr 12% Ni low C and high Mo suitable for welding austenitic stainless steels such as AISI 309.
- Used for welding dissimilar steels and for pad layers prior to coating, when Mo is a necessary alloying element. It is also used for welding stainless steels and medium-strength steels, for intermediate layers in structural steel prior to the deposition of 316L grade stainless steel cladding.

### PROTECTIVE GAS

- I1

## xARC 312 AWS/ASME SFA-5.9: ER 312 | EN 12072: W 29 9

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.15 Si = 0.30-0.65 Cr = 28.00-32.00	≥650 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥450 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥22 A <sub>5</sub> (%) 20°C ≥47 ISO - V (J)	=-	 PA PB	1.6 x 1000	-	CS113762
Cu = 0.75 Mn = 1.50-2.20 Mo = 0.75 Ni = 8.00-10.50 P = 0.03 S = 0.03			 PC PG	2.0 x 1000	-	CS113763
			 PF PE	2.4 x 1000	-	CS113764

### APPLICATIONS





- Stainless TIG rod suitable for welding or coating difficult to weld steels.
- Suitable for welding pad layers.

### PROTECTIVE GAS

- I1

## NICKEL BASED STEELS

### xARC NICR 3 AWS/ASME SFA-5.14: ER NiCr-3 | EN ISO 18274: W Ni 6082 (NiCr20Mn3Nb)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.50 Cr = 18.00-22.00 Cu = 0.50	$\geq 620 R_m$ (N/mm <sup>2</sup> ) $\geq 380 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 35 A_5$ (%) 20°C $\geq 100$ ISO - V (J)		 PA PB	1.6 x 1000	-	CS113765
Mn = 2.50-3.50 Fe = 3.00 Ni = 67.00 Ti = 0.75			 PC PG	2.0 x 1000	-	CS113766
Nb+Ta = 2.00-3.00 P = 0.03 S = 0.015			 PF PE	2.4 x 1000	-	CS113767





#### APPLICATIONS

- TIG welding rod suitable for use with inert shielding gases.
- Used for welding Ni-Cr alloys that are highly resistant to creep, heat and corrosion, where good toughness and ductility properties are required after post-weld heat treatment or prolonged operation at high temperatures.

#### PROTECTIVE GAS

- I1

### xARC NICRMO 3 AWS/ASME SFA-5.14: ER NiCrMo-3 | EN 18274: S Ni 6625 (NiCr22Mo9Nb)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.50 Cr = 20.00-23.00 Cu = 0.50	$\geq 720 R_m$ (N/mm <sup>2</sup> ) $\geq 460 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 120$ ISO - V (J) -196°C $\geq 40$ ISO - V (J)		 PA PB	1.6 x 1000	-	CS113768
Al = 0.40 Mn = 0.50 Mo = 8.00-10.00 Fe = 5.00			 PC PG	2.0 x 1000	-	CS113769
Ni = 58.00 Ti = 0.40 Nb+Ta = 3.15-4.15 P = 0.020 S = 0.015			 PF PE	2.4 x 1000	-	CS113770

#### APPLICATIONS

- TIG welding rods type S Ni 6625 / ER NiCrMo-3, suitable for use with inert shielding gases.
- Used for welding highly corrosion-resistant Cr-Mo-Nickel base alloys. Also suitable for corrosion-resistant steels with molybdenum alloys.

#### PROTECTIVE GAS

- I1

**xARC NICU 7** AWS/ASME SFA-5.14: ER NiCu-7 | EN ISO 18274: S Ni 4060 | MAT. Nº 2.4377

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.15 Si = 1.2 Cu = 28.0-32.0 Mn = 4.0 Fe = 2.5 Ti = 1.5-3.0	>480 R <sub>m</sub> (N/mm <sup>2</sup> ) >180 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%)		 PA PB	1.6 x 1000	-	CS113774
			 PC PF	2.0 x 1000	-	CS113775
			 PE	2.4 x 1000	-	CS113776

## APPLICATIONS





- Nickel-copper alloys, e.g. NiCu 30 Fe (2.4360) and their connection to copper alloys and steels (from all-black to red metals), coatings and cushion layers.

## PROTECTIVE GAS

- I1

## CAST IRON

**xARC Ni 1** AWS/ASME SFA-5.14: ER Ni 1 | EN ISO 18274: S Ni 2061 | MAT. Nº 2.4155

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.15 Si = 0.7 Mn = 1.0 Fe = 0.2 Ti = 2-3.5	>380 R <sub>m</sub> (N/mm <sup>2</sup> ) >200 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >30 A <sub>5</sub> (%)		 PA PB	1.6 x 1000	-	CS113777
			 PC PF	2.0 x 1000	-	CS113778
			 PE	2.4 x 1000	-	CS113779

### APPLICATIONS



- Nickel, low alloy nickel (semi-finished Ni products/Ni castings), e.g. LC-Ni 99.6 (2.4061), NiMn 5 (2.4116), G-Ni 95 (2.4170), as well as welded joints between these materials and steel, cast steel, copper; coatings and protective layers.

### PROTECTIVE GAS

- I1

## TITANIUM

**xARC TI 2** AWS/ASME SFA-5.16: ER Ti 2 | EN ISO 24034: S Ti 0120 | MAT. N° 3.7035

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Fe = 0.25 N = 0.05 O = 0.18 H = 0.013 Ti remaining	500 R <sub>m</sub> (N/mm <sup>2</sup> ) 295 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 42 A <sub>5</sub> (%)			1.6 x 1000	-	CS113780
				2.0 x 1000	-	CS113781
				2.4 x 1000	-	CS113782

### APPLICATIONS

- TIG rods for welding titanium alloys.

### BASE MATERIALS

- Titan Grade 1, Grade 2, Grade 3, Grade 4.

### PROTECTIVE GAS

- I1

## COPPER ALLOYS

**xARC COBRE** AWS/ASME SFA-5.7: ER Cu | EN ISO 24373: S Cu 1898A-CuSn1MnSi | DIN 1733: W CuSn

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.10-0.40 Sn = 0.50-1.00 Al = 0.01				1.6 x 1000	-	CS113783
Mn = 0.10-0.40 Fe < 0.03 Ni < 0.10 P < 0.015 Pb < 0.01 Cu remaining	210-245 R <sub>m</sub> (N/mm <sup>2</sup> ) 60-80 HB	==	-	2.0 x 1000	-	CS113784
				2.4 x 1000	-	CS113785

### APPLICATIONS

- Copper rods for high-quality welding.
- It can be used with TIG and MIG methods.
- Its excellent fluidity makes it ideal for welding copper. Thanks to the deoxidiser in the welding material, the weld is solid and pore-free.

### PROTECTIVE GAS

- I1

**xARC CUSN 6** AWS/ASME SFA-5.7: ER Cu Sn-A | EN ISO 24373: S Cu 5180A-CuSn6P | DIN 1733: W CuSn6

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 4.00-7.00 Zn < 0.10 Al < 0.01	320-360 R <sub>m</sub> (N/mm <sup>2</sup> )			1.6 x 1000	-	CS113786
Fe < 0.10 P < 0.01-0.40 Pb < 0.02 Cu remaining	≥25 A <sub>5</sub> (%) 130 HB	==	-	2.0 x 1000	-	CS113787
				2.4 x 1000	-	CS113788

### APPLICATIONS

- Suitable for TIG and MIG methods and excellent for fixing in artistic castings.
- Ideal for surfaces, this material improves hardness and can also be used to fix worn surfaces with similar base metals.

### PROTECTIVE GAS

- I1

## xARC CUSN 12 EN ISO 24373: S Cu 5410 | MAT. N° 2.1056

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 12 Cu = Bal.	350 R <sub>m</sub> (N/mm <sup>2</sup> ) 200 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 15 A <sub>5</sub> (%) 120 HB	=	PA PB	1.6 x 1000	-	CS113789
			PC PF	2.0 x 1000	-	CS113790
			PE	2.4 x 1000	-	CS113791

### APPLICATIONS

- Copper-tin alloys, e.g. bronze with 10-12% Sn, copper-zinc alloys (brass), cast copper-tin-zinc-lead alloys (red bronze: Rg5, Rg7); accumulation welds on cast iron.

### PROTECTIVE GAS

- I1

## xARC CUAL 8 AWS/ASME SFA-5.7: ER Cu-Al-A1 | EN ISO 24373: S Cu 6100-CuAl7 | DIN 1733: W CuAl8

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si < 0.20 Zn < 0.20 Al = 6.00-8.50 Pb < 0.02 Cu remaining	390-450 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥45 A <sub>5</sub> (%) 80-110 HB	=	-	1.6 x 1000	-	CS113792
				2.0 x 1000	-	CS113793
				2.4 x 1000	-	CS113794

### APPLICATIONS


- Shipbuilding: propellers, pumps, shafts and valves, bearings, main shafts.
- Chemical industry: gate valves, sleeves, pipes, heat exchangers, gearboxes.
- Automotive industry: maintenance of car parts and tools, bearings in general and galvanised sheet metal.
- Construction industry: welding and coating aluminium-bronze with a steel base.
- Recommended for coating wear metals.

### PROTECTIVE GAS

- I1



## xARC CUSI 3 AWS/ASME SFA-5.7: ER Cu Si-A | EN ISO 24373: S Cu 6560-CuSi3Mn1 | DIN 1733: W CuSi3

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 2.80-4.00 Sn < 0.20 Zn < 0.40	330-370 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥40 A <sub>5</sub> (%) 80-90 HB		-	1.6 x 1000	-	CS113795
Mn = 0.50-1.50 Fe < 0.50 P < 0.05 Pb < 0.02 Cu remaining				2.0 x 1000	-	CS113796
				2.4 x 1000	-	CS113797







### APPLICATIONS

- This material is often used for fastening in artistic foundries, for welding galvanised sheets and even as a coating for steel using the MIG and TIG methods. It is also suitable for surfaces subject to corrosion.

### PROTECTIVE GAS

- I1

## xARC CUNI30 AWS/ASME SFA-5.7: ER Cu Ni | EN ISO 24373-A: S Cu 7158 | MAT. N° 2.0837

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.	
C = 0.02 Si = 0.25 Mn = 1.0	390 R <sub>m</sub> (N/mm <sup>2</sup> ) 240 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%)		  PA PB	1.6 x 1000	-	CS113801	
Ti = 0.3 Fe = 0.6 Ni = 30 Cu remaining				  PC PF	2.0 x 1000	-	CS113802
				 PE	2.4 x 1000	-	CS113803

### APPLICATIONS


- The seawater-resistant weld metal allows these rods to be used in shipbuilding, oil refineries, the food industry and generally in the construction of corrosion-resistant appliances and containers.

### PROTECTIVE GAS

- I1/I3

## HARDFACING

**xARC DUR 600** EN ISO 14700: S Fe8 | DIN 8555: WSG 6-GZ-60 | MAT. Nº 1.4718

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.45 Si = 3.00 Cr = 9.30 Mn = 0.40	550-620HB 57-60 HRc		-	1.2 x 1000	-	CS113804
				1.6 x 1000	-	CS113805
				2.0 x 1000	-	CS113806
				2.4 x 1000	-	CS113807


### APPLICATIONS

- Anti-wear welding rods for hardfacing.
- Applications for maintenance and repair of guide rollers, screw conveyors, gears, grinders, tools, hammers, etc.

### PROTECTIVE GAS

- I1

**xARC DUR 3348** AISI: M7 | MAT. Nº 1.3348

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1.00 Si = 0.40 Cr = 3.80 Mn = 0.30 Mo = 8.60 V = 1.90 W = 1.80	593-685 HB 57-62 HRc		-	1.6 x 1000	-	CS113808
				2.0 x 1000	-	CS113809
				2.4 x 1000	-	CS113810

### APPLICATIONS

- Welding rods for hardfacing high-speed tungsten-molybdenum alloy steels with hardness values above 57 HRC.
- Applications for maintenance and repair of gears, cutting tools, gouges, turning chisels, drills, extrusion dies, etc.

### PROTECTIVE GAS

- I1

## ALUMINUM ALLOYS

### xARC AL Si5 AWS/ASME SFA-5.10: ER 4043 | EN ISO 18273: S Al 4043 (AlSi5)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 4.50-6.00	120 R <sub>m</sub> (N/mm <sup>2</sup> ) 60 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 15 A <sub>5</sub> (%)	~	-	1.6 x 1000	-	CS113811
Zn = 0.10				2.0 x 1000	-	CS113812
Cu = 0.30				2.4 x 1000	-	CS113813
Mn = 0.05				3.2 x 1000	-	CS113814
Mg = 0.05				4.0 x 1000	-	CS113815
Ti = 0.20						
Be = 0.0003						
Fe = 0.80						

#### APPLICATIONS

- Components for cars, furniture, carpentry.

#### PROTECTIVE GAS

- I1/I3

### xARC AL Si12 AWS/ASME SFA-5.10: ER 4047A | EN ISO 18273: S Al 4047A (AlSi12(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 11.00-13.00	130 R <sub>m</sub> (N/mm <sup>2</sup> ) 70 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 13 A <sub>5</sub> (%)	~	-	1.6 x 1000	-	CS113816
Zn = 0.20				2.0 x 1000	-	CS113817
Cu = 0.30				2.4 x 1000	-	CS113818
Mn = 0.15				3.2 x 1000	-	CS113819
Mg = 0.10				4.0 x 1000	-	CS113820
Ti = 0.15						
Be = 0.0003						
Fe = 0.60						
Al remaining						

#### APPLICATIONS

- Automotive industry, refrigeration, heat exchanger, conditioning.

#### PROTECTIVE GAS

- I1/I3

## xARC AL MG3 AWS/ASME SFA-5.10: ER 5754 | EN ISO 18273: S Al 5754 (AlMg3)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.40 Cr = 0.30 Zn = 0.20 Cu = 0.10 Mn = 0.50 Mg = 2.60-3.60 Ti = 0.15 Be = 0.0003 Fe = 0.40 Al remaining	190 R <sub>m</sub> (N/mm <sup>2</sup> ) 80 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 20 A <sub>5</sub> (%)	~	-	2.0 x 1000	-	CS113821
				2.4 x 1000	-	CS113822

### APPLICATIONS

- The construction sector in general, outdoor furniture (gardens, beaches) and the structural industry.

### PROTECTIVE GAS

- I1/I3

## xARC AL MG5 AWS/ASME SFA-5.10: ER 5356 | EN ISO 18273: S Al 5356 (AlMg5Cr(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.25 Cr = 0.05-0.20 Zn = 0.10 Cu = 0.10 Mn = 0.05-0.20 Mg = 4.50-5.50 Ti = 0.06-0.20 Be = 0.0003 Fe = 0.40 Al remaining	250 R <sub>m</sub> (N/mm <sup>2</sup> ) 115 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 17 A <sub>5</sub> (%)	~	-	1.6 x 1000	-	CS113823
				2.0 x 1000	-	CS113824
				2.4 x 1000	-	CS113825
				3.2 x 1000	-	CS113826
				4.0 x 1000	-	CS113827

### APPLICATIONS

- Bicycle and motorbike frames, car body components, loading side panels, fuel tanks, metal furniture, ladders, loading ramps, lifting stirrups, ship's top table.

### PROTECTIVE GAS

- I1/I3

## xARC AL MG4.5 MN AWS/ASME SFA-5.10: ER 5183 | EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.40 Cr = 0.05-0.25 Zn = 0.25 Cu = 0.10	278 R <sub>m</sub> (N/mm <sup>2</sup> ) 135 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 17 A <sub>5</sub> (%)	~	-	2.0 x 1000	-	CS113828
Mn = 0.50-1.00 Mg = 4.30-5.20 Ti = 0.15 Be = 0.0003 Fe = 0.40 Al remaining				2.4 x 1000	-	CS113829

### APPLICATIONS

- Shipyards, storage tanks, structural industry, cryogenic applications.

### PROTECTIVE GAS

- I1/I3

## xARC AL 99.7 AWS/ASME SFA-5.10: ER 1070 | EN ISO 18273: S Al 1070 (Al 99.7)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.20 Zn = 0.04 Cu = 0.04 Al = 99.70	80 R <sub>m</sub> (N/mm <sup>2</sup> ) 35 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%)	~	-	2.0 x 1000	-	CS113830
Mn = 0.03 Mg = 0.03 Ti = 0.03 Be = 0.0003 Fe = 0.25 V = 0.05				2.4 x 1000	-	CS113831



### APPLICATIONS

- Used for GMAW and GTAW welding processes in the chemical, electronics, construction and food industries.
- The 99.7% Al alloy is used for spray metallisation and arc spray metallisation.

### PROTECTIVE GAS

- I1/I3

## xARC MAGNÉSIO AWS/ASME SFA-5.19: ~R AZ61 A

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.4 Zn = 0.8 Mn = 0.3 Al = 6.5 Mg remaining	280 R <sub>m</sub> (N/mm <sup>2</sup> ) 180 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 6 A <sub>5</sub> (%)		 PA PB	2.4 x 1000	-	CS113832
				3.2 x 1000	-	CS113833

### APPLICATIONS

- TIG rods for welding magnesium.

### BASE MATERIALS

- AZ61A-F; B91.

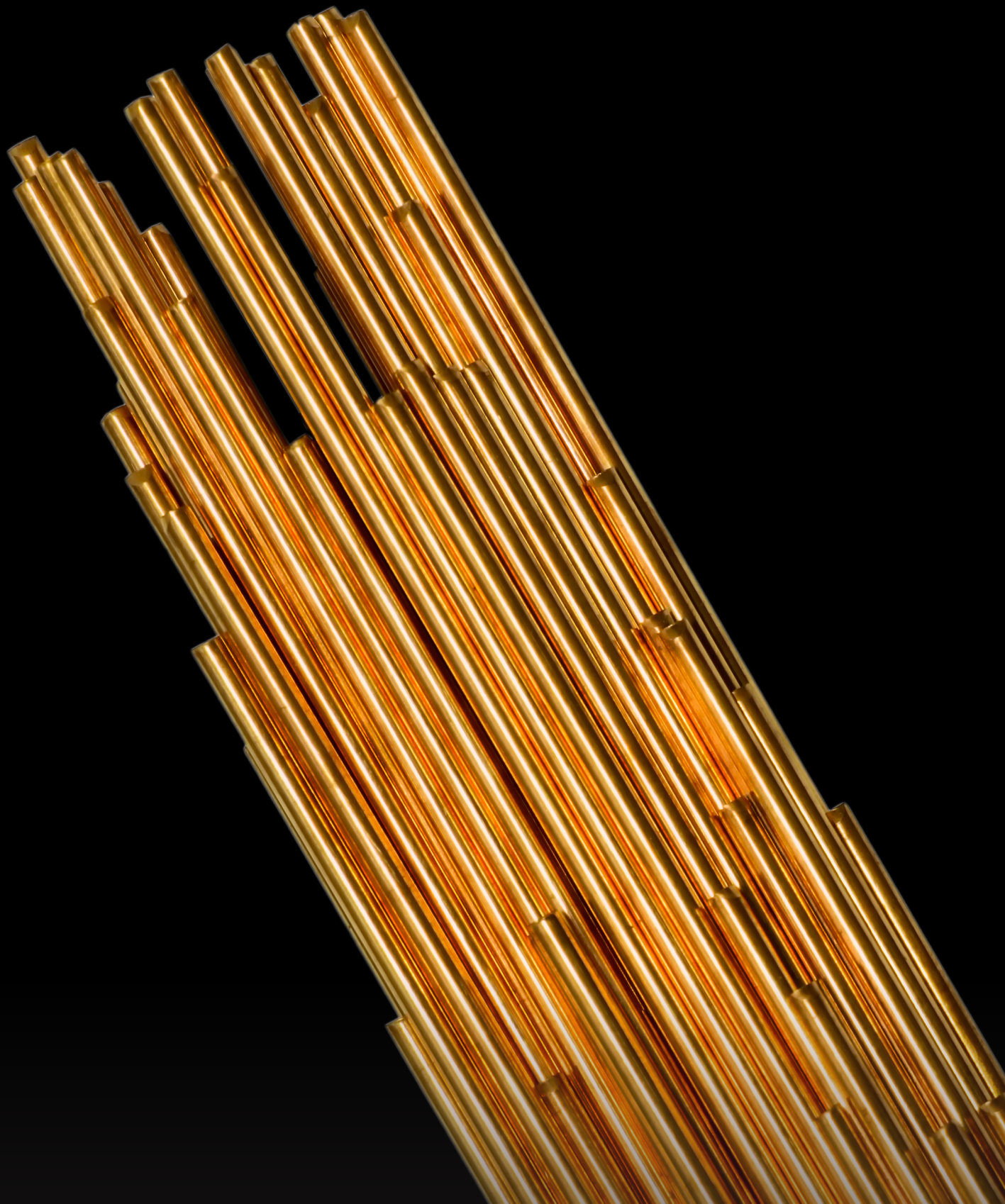
### PROTECTIVE GAS

- I1/I3



# TIG RODS

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**OXY-GAS RODS  
BRAZING**





## LOW AND MEDIUM CARBON STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC BRAZING R45	AWS/ASME SFA-5.2: R 45   EN 12536: O I   MAT. Nº 1.0324	82
xARC BRAZING R45 EC	AWS/ASME SFA-5.2: R 45   EN 12536: O I   MAT. Nº 1.0324	82

## COPPER ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC BRAZING P6	DIN 8513: L - Cu P 6	83
xARC BRAZING P7	DIN 8513: L - Cu P 7	83
xARC BRAZING P8	DIN 8513: L - Cu P 8	84
xARC BRAZING LATÃO	AWS/ASME SFA-5.8: CuZn-A   EN ISO 24373: S Cu 4641   MAT. Nº 2.0366	84
xARC BRAZING LATÃO EC	AWS/ASME SFA-5.8: CuZn-A   EN 14640: CuZn40	85

## DEOXIDIZING COPPER ALLOY

DESIGNATION	CLASSIFICATION	PAG.
xARC DESOXIDANTE COBRE/ LIGAS DE COBRE	-	86
xARC DESOXIDANTE LATÃO	-	86

## DEOXIDIZING SILVER ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC DESOXIDANTE PRATA	-	87

## DEOXIDIZING ALUMINUM ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC DESOXIDANTE ALUMÍNIO	-	88

## LOW AND MEDIUM CARBON STEELS

### xARC BRAZING R45 AWS/ASME SFA-5.2: R 45 | EN 12536: O | MAT. N° 1.0324

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si < 0.10 Mn = 0.45	400 R <sub>m</sub> (N/mm <sup>2</sup> ) 280 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 20 A <sub>5</sub> (%) +20°C 60 ISO - V (J)	-	-	1.6 x 1000	-	CS114108
				2.0 x 1000	-	CS114109
				2.4 x 1000	-	CS114110
				3.2 x 1000	-	CS114111

#### APPLICATIONS

- Used in unalloyed C-Mn steels for construction and without high thicknesses.
- Shipbuilding, bodywork, motor vehicles, light structures, construction of small containers, tanks, furniture and shelves, pipe industry (including gas pipes), car tubes, etc.

#### BASE MATERIALS

- ASTM L280; A516; A36.
- EN S355; P255G1TH; P235T1/T2; S235J; P355N; S235G2T; S255GT.

### xARC BRAZING R45 EC AWS/ASME SFA-5.2: R 45 | EN 12536: O | MAT. N° 1.0324

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.041 Si = 0.014 Cr = 0.022 Cu = 0.15 Mn = 0.45 Mo = 0.001 Ni = 0.006 P = 0.015 S = 0.008 V = 0.001			 PA PB	2.0 x 1000	-	CS114112
			 PF PE	2.4 x 1000	-	CS114113

#### APPLICATIONS

- R45 welding rods are used for oxy-gas welding of steels where the minimum tensile strength of the steel does not exceed 45,000 psi.
- R45 rods have a low carbon steel composition.
- Oxy-gas welding rods do not have covers that influence the usability of the rod. Therefore, the ability to weld in the PF or PE position is essentially a matter of the welder's skill and can be affected to a certain extent by the chemical composition of the rod.

## COPPER ALLOYS

### xARC BRAZING P6 DIN 8513: L - Cu P 6

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
P = 6.00 Cu remaining	25 R <sub>m</sub> (N/mm <sup>2</sup> ) 5 A <sub>5</sub> (%) 8.1 HRc	-	-	2.0 x 500	-	CS114114
				2.4 x 500	-	CS114115
				3.2 x 500	-	CS114116

#### APPLICATIONS

- Soldering copper, brass and bronze.
- For copper-to-copper applications, no flux is required.
- Construction of appliances, pipework, heaters, etc.

### xARC BRAZING P7 DIN 8513: L - Cu P 7

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
P = 7.00 Cu remaining	25 R <sub>m</sub> (N/mm <sup>2</sup> ) 4 A <sub>5</sub> (%) 8.1 HRc	-	-	2.0 x 500	-	CS114117
				2.4 x 500	-	CS114118
				3.2 x 500	-	CS114119

#### APPLICATIONS

- Soldering copper, brass and bronze.
- For copper to copper application, no flux is required.
- Construction of appliances, pipework, heaters, etc.

## xARC BRAZING P8 DIN 8513: L - Cu P 8

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
P = 7.6 - 8.4 Cu remaining	25 R <sub>m</sub> (N/mm <sup>2</sup> ) 3 A <sub>5</sub> (%) 8.0 HRc	-	-	2.0 x 500	-	CS114120
				2.4 x 500	-	CS114121
				3.2 x 500	-	CS114122

### APPLICATIONS

- Soldering copper, brass and bronze.
- For copper-to-copper applications, no flux is required.
- Construction of appliances, pipework, heaters, etc.

## xARC BRAZING LATÃO AWS/ASME SFA-5.8: CuZn-A | EN ISO 24373: S Cu 4641 | MAT. Nº 2.0366

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.4 Sn = 0.4 Zn = 40.00 Cu = 59.00	8.4 HRc	-	-	2.0 x 1000	-	CS114123
				2.4 x 1000	-	CS114124
				3.0 x 1000	-	CS114125
				4.0 x 1000	-	CS114126
				5.0 x 1000	-	CS114127

### APPLICATIONS

- Multipurpose brazing alloys, particularly deoxidisers and degassers, with exceptional properties for high-quality brazing in automobile construction, the bicycle and motorbike industry, the construction of accessories and instruments, plumbing, repair shops, etc.
- Suitable for brazing steel, cast iron, malleable cast steel, red bronze, tin bronze and copper, for coating sliding and wear surfaces and for joining brass, bronze, copper and copper alloys.

## xARC BRAZING LATÃO EC AWS/ASME SFA-5.8: CuZn-A | EN 14640: CuZn40

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 0.52 Cu = 59.5 Al = 0.008 Pb = 0.03 Zn remaining	-	-	-	2.0 x 1000	-	CS114128
				2.4 x 1000	-	CS114129
				3.0 x 1000	-	CS114130
				4.0 x 1000	-	CS114131
				5.0 x 1000	-	CS114132

### APPLICATIONS

- A filler metal for copper-zinc brazing that contains small amounts of tin to improve the strength and corrosion resistance of the weld deposit.
- It is a good choice when the high-strength properties of low-smoke bronze are not required.

## DEOXIDIZING COPPER ALLOY

### xARC DESOXIDANTE COBRE/LIGAS DE COBRE

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Inorganic fluorides Inorganic Borates	-	-	-	100 GR	-	CS114133
				250 GR	-	CS114134

#### APPLICATIONS

- Dexosidising flux for brazing.

### xARC DESOXIDANTE LATÃO

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Inorganic fluorides Inorganic Borates	-	-	-	250 GR	-	CS114135
				500 GR	-	CS114136

#### APPLICATIONS

- Dexosidising flux for brazing.

## DEOXIDIZING SILVER ALLOYS

### xARC DESOXIDANTE PRATA

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Inorganic fluorides Inorganic Borates	-	-	-	100 GR	-	CS114137
				250 GR	-	CS114138

### APPLICATIONS

- Dexosidising flux for brazing.

## DEOXIDIZING ALUMINUM ALLOYS

### xARC DESOXIDANTE ALUMÍNIO

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
-	-	-	-	250 GR	-	CS114139

#### APPLICATIONS

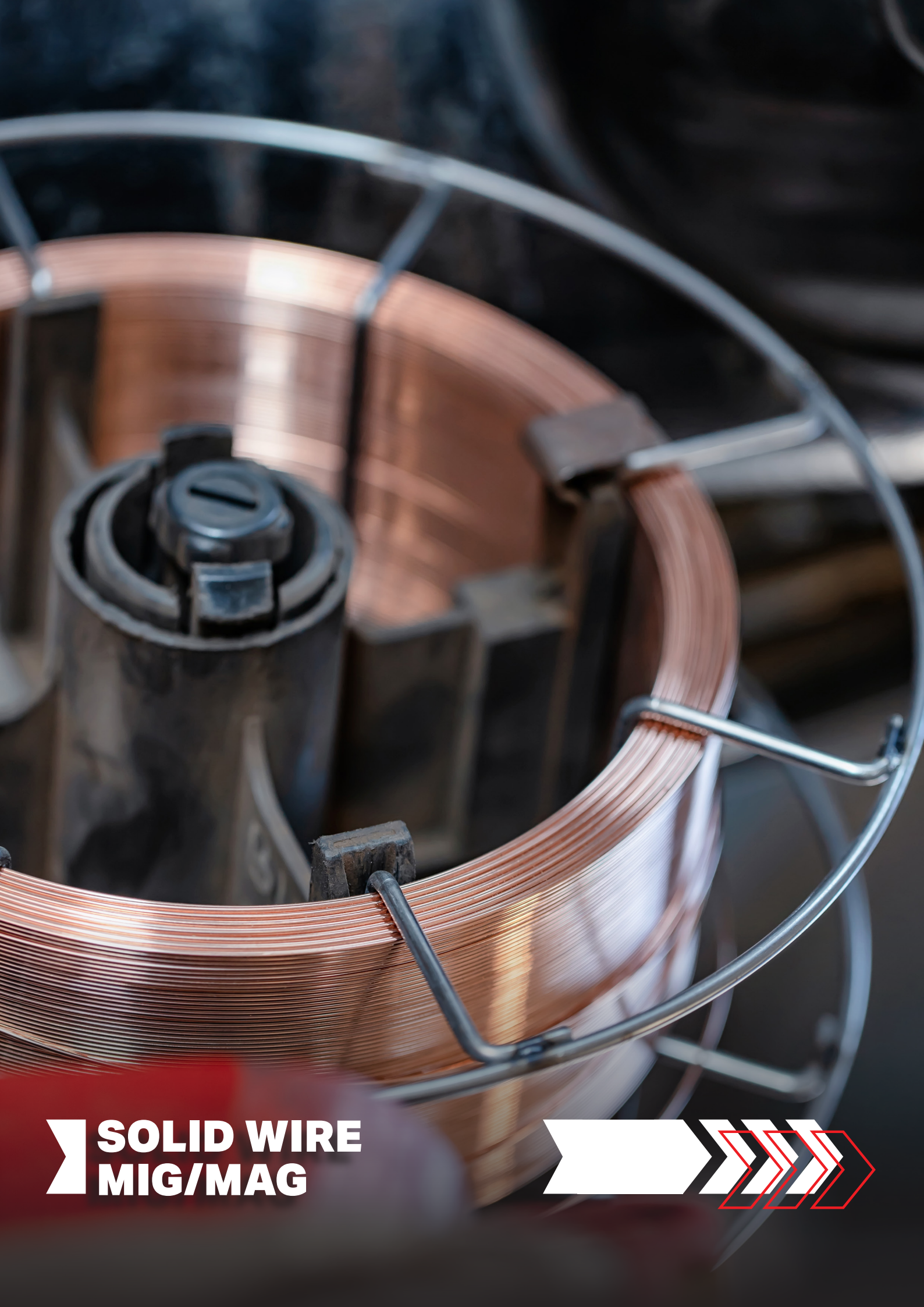
- Aluminium, aluminium alloys.





# OXY-GAS RODS / BRAZING

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**SOLID WIRE  
MIG/MAG**



## LOW AND MEDIUM CARBON STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC SG2	AWS/ASME SFA-5.18: ER 70 S-6   EN ISO 14341-A: G 42 4 M21 3Si1	94
xARC SG3	AWS/ASME SFA-5.18: ER 70 S-6   EN ISO 14341-A: G 46 5 M21 4Si1	94
xARC SG T1	AWS/ASME SFA-5.18: ER 70 S-2	95

## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC CORTEN	AWS/ASME SFA-5.28: ER 80 S-SG   EN ISO 14341-A: G 50 4 M21 Z	96

## STEELS WITH HIGH ELASTIC STRENGTH

DESIGNATION	CLASSIFICATION	PAG.
xARC 100 SG	AWS/ASME SFA-5.28: ER 100 S-SG   EN ISO 16834-A: G 62 4 M21 Mn3NiCrMo	97
xARC 110 SG	AWS/ASME SFA-5.28: ER 110 S-SG   EN ISO 16834-A: Mn3Ni1CrMo   EN 12534: Mn3Ni1CrMo	97
xARC 120 SG	AWS/ASME SFA-5.28: ER 120 S-SG   EN ISO 16834-A: Mn4Ni2,5CrMo   EN 12534: Mn4Ni2,5CrMo	98

## TEMPERATURE RESISTANT STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC MO	AWS/ASME SFA-5.28: ER 70 S-A1   EN ISO 14341-A: G2 Mo   EN 440: G2 Mo   M. N° 1.5424	99
xARC 80 D2	AWS/ASME SFA-5.28: ER 80 S-D2   EN ISO 14341-A: G 50 4 M21 4Mo	99
xARC 80 SG	AWS/ASME SFA-5.28: ER 80 S-G   EN 12070: Cr Mo1 Si   DIN 8575: SG Cr Mo1	100
xARC 80 B2	AWS/ASME SFA-5.28: ER 80 S-B2   EN ISO 21952-B: 1CM	100
xARC 90 SG	AWS/ASME SFA-5.28: ER 90 S-G   EN 12070: Cr Mo2 Si   EN ISO 21952-A: Cr Mo2 Si	101
xARC 90 B3	AWS/ASME SFA-5.28: ER 90 S-B3   EN ISO 21952-B: 2C1M	101

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 308L SI	AWS/ASME SFA-5.9: ER 308L Si   EN 12072: G 19 9 L Si	102
xARC 316L SI	AWS/ASME SFA-5.9: ER 316L Si	102
xARC 310	AWS/ASME SFA-5.9: ER 310   EN ISO 14343- A: G 25 20	103
xARC 347	AWS/ASME SFA-5.9: ER 347   EN ISO 14343-A: G 19 9 Nb	103
xARC 385	AWS/ASME SFA-5.9: ER 385   EN 14343-A: G 20 25 5 Cu L	104
xARC 410	AWS/ASME SFA-5.9: ER 410   EN ISO 14343- A: G 13	104
xARC 420	AWS/ASME SFA-5.9: ER 420	105
xARC DUPLEX	AWS/ASME SFA-5.9: ER 2209   EN 14343 - A: G 22 9 3 N L	105

## SPECIAL APPLICATIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC 307 SI	AWS/ASME SFA-5.9: ER 307 Si   EN ISO 14343-A: G 18 8 Mn	106
xARC 309L SI	AWS/ASME SFA-5.9: ER 309L Si   EN ISO 14343-A: G 23 12 L Si	106
xARC 309L MO	AWS/ASME SFA-5.9: ER 309L Mo   EN ISO 14343-A: G 23 12 2 L	107
xARC 312	AWS/ASME SFA-5.9: ER 312   EN ISO 14343- A: G 29 9	107

## NICKEL BASED STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC NICKR 3	AWS/ASME SFA-5.14: ER NiCr-3   EN ISO 18274: G Ni 6082 ( NiCr20Mn3Nb)	108
xARC NICKRMO 3	AWS A 5.14: ERNiCrMo-3   UNS: N06625	108

## CAST IRON

DESIGNATION	CLASSIFICATION	PAG.
xARC NIFE	EN ISO 1071: G C NiFe-1	109
xARC NI 1	AWS/ASME SFA-5.14: ER Ni 1   EN ISO 18274: S Ni 2061   MAT. N° 2.4155	109

## COPPER ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC COBRE	AWS/ASME SFA-5.7: ER Cu   EN ISO 24373: S Cu 1898A-CuSn1MnSi   DIN 1733: M CuSn	110
xARC CUSN 6	AWS/ASME SFA-5.7: ER Cu Sn-A   EN ISO 24373: S Cu 5180A-CuSn6P   DIN 1733: M CuSn6	110
xARC CUSN 12	EN ISO 24373: S Cu 5410   MAT. Nº 2.1056	111
xARC CUAL 8	AWS/ASME SFA-5.7: ER Cu-Al-A1   EN ISO 24373: S Cu 6100-CuAl7   DIN 1733: M CuAl8	111
xARC CUSI 3	AWS/ASME SFA-5.7: ER Cu Si-A   EN ISO 24373: S Cu 6560-CuSi3Mn1   DIN 1733: M CuSi3	112

## HARDFACING

DESIGNATION	CLASSIFICATION	PAG.
xARC DUR 350	DIN 8555: MSG 5-GZ-350   MAT. Nº 1.7363	113
xARC DUR 600	EN ISO 14700: S Fe8   DIN 8555: MSG 6-GZ-60   MAT. Nº 1.4718	113

## ALUMINUM ALLOYS

DESIGNATION	CLASSIFICATION	PAG.
xARC AL SI5	AWS/ASME SFA-5.10: ER 4043   EN ISO 18273: S Al 4043 (AlSi5)	114
xARC AL SI12	AWS/ASME SFA-5.10: ER 4047A   EN ISO 18273: S Al 4047A (AlSi12(A))	114
xARC AL MG3	AWS/ASME SFA-5.10: ER 5754   EN ISO 18273: S Al 5754 (AlMg3)	115
xARC AL MG5	AWS/ASME SFA-5.10: ER 5356   EN ISO 18273: S Al 5356 (AlMg5Cr(A))	115
xARC AL MG4.5 MN	AWS/ASME SFA-5.10: ER 5183   EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A))	116
xARC AL 99.7	AWS/ASME SFA-5.10: ER 1070   EN ISO 18273: S Al 1070 (Al 99.7)	116

## LOW AND MEDIUM CARBON STEELS

### xARC SG2 AWS/ASME SFA-5.18: ER 70 S-6 | EN ISO 14341-A: G 42 4 M21 3Si1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.92 Cr = 0.01 Cu = 0.07 Mn = 1.67 Mo = 0.01 Ni = 0.02 P = 0.010 S = 0.008 V = 0.001	560 R <sub>m</sub> (N/mm <sup>2</sup> ) 470 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%) -30°C 80 ISO - V (J)		 PA PB  PF PE	0,60 0,80 1,00 1,20 1,60	- 50-140 80-160 80-220 -	CS113837 CS113838 CS113839 CS113840 CS113841

#### APPLICATIONS

- Copper-coated welding wire with gas protection for the manufacture of mild steel.
- Used for welding carbon and alloy steel structures with a tensile strength of 500MPa, and high-speed welding of plates and pipes.

#### PROTECTIVE GAS

- M20/M21/C1

### xARC SG3 AWS/ASME SFA-5.18: ER 70 S-6 | EN ISO 14341-A: G 46 5 M21 4Si1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.93 Cr = 0.02 Cu = 0.019 Mn = 1.70 Mo = 0.01 Ni = 0.02 P = 0.010 S = 0.008 V = 0.001	569 R <sub>m</sub> (N/mm <sup>2</sup> ) 478 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26,5 A <sub>5</sub> (%) -40°C 84 ISO - V (J)		 PA PB  PF PE	0,80 1,00 1,20	50-140 80-160 80-220	CS113845 CS113846 CS113847


#### APPLICATIONS

- Wire designed for welding all unalloyed carbon-manganese and low-alloy structural and engineering steels in general.

#### PROTECTIVE GAS

- M20/M21/C1

## xARC SG TI AWS/ASME SFA-5.18: ER 70 S-2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.68 Zr = 0.11 Al = 0.09 Mn = 1.32 Ti = 0.10 P = 0.010 S = 0.008	520 R <sub>m</sub> (N/mm <sup>2</sup> ) 440 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 29 A <sub>5</sub> (%) -20°C 52 ISO - V (J)	=+	 PA PB PF PE	0,80	50-140	CS113848
				1,00	80-160	CS113849
				1,20	80-220	CS113850

### APPLICATIONS

- Top quality wire for welding on all types of mild and carbon steels, producing quality welds with minimal porosity. It is a triple deoxidised wire (Zirconium, Titanium and Aluminium), which makes it an excellent choice for welding over rust and mill scale.
- Used for welding carbon and alloy steel structures with a tensile strength of 500MPa, and high-speed welding of plates and pipes.

### PROTECTIVE GAS

- M20/M21

## STEEL RESISTANT TO ATMOSPHERIC CONDITIONS

**xARC CORTEN** AWS/ASME SFA-5.28: ER 80 S-SG | EN ISO 14341-A: G 50 4 M21 Z

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06-0.10 Si = 0.70-0.90 Cr = 0.25-0.35 Cu = 0.25-0.40 Al = 0.02 Mn = 1.30-1.50 Mo = 0.10 Ni = 0.70-0.90 P = 0.02 S = 0.02 V = 0.015 Ti + Zr = 0.03	620 R <sub>m</sub> (N/mm <sup>2</sup> ) 530 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) -20°C 80 ISO - V (J)		 PA PB PC PG PF PE PD	0,80	-	CS113851
				1,00	-	CS113852
				1,20	-	CS113853

### APPLICATIONS

- Welding wire for weather-resistant steels.
- Solid copper-coated wire for weather-resistant steels, thanks to the Cu and Ni content in the solid wire.
- For use with Ar/CO<sub>2</sub> and Ar/CO<sub>2</sub>/O<sub>2</sub> shielding gas.

### BASE MATERIALS

- EN 10025-5 up to S355K2W, S355K2WP, COR-TEN A®, COR-TEN B®, COR-TEN B®, PATINAX 37, ALCODUR 50, KORAL-PIN 52.

### PROTECTIVE GAS

- M20/M21/C2



## STEELS WITH HIGH ELASTIC STRENGTH

### xARC 100 SG AWS/ASME SFA-5.28: ER 100 S-SG | EN ISO 16834-A: G 62 4 M21 Mn3NiCrMo

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08-0.11 Si = 0.70-0.80 Cr = 0.55-0.65 Cu = 0.30 Al = 0.02 Mn = 1.60-1.80 Mo = 0.20-0.30 Ni = 0.50-0.60 P = 0.015 S = 0.015 V = 0.015 Ti + Zr = 0.03	740 R <sub>m</sub> (N/mm <sup>2</sup> ) 640 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 19 A <sub>5</sub> (%) -20°C 110 ISO - V (J)		 PA PB	0,80	-	CS113854
			 PC PG	1,00	-	CS113855
			 PF PE PD	1,20	-	CS113856

#### APPLICATIONS

- ▶ Copper-coated solid wire for GMAW welding of high-strength steels.
- ▶ Also suitable for welding steels where good impact resistance is required at low temperatures.
- ▶ For use with Ar/CO<sub>2</sub> and Ar/CO<sub>2</sub>/O<sub>2</sub> shielding gas.

#### BASE MATERIALS

- ▶ Fine-grained structural steels: EN 10025-6 up to S620QL1.
- ▶ Pipeline steel: EN ISO 3183 up to L555M; API5L up to X80.

#### PROTECTIVE GAS

- ▶ M20/M21/C2

### xARC 110 SG AWS/ASME SFA-5.28: ER 110 S-SG | EN ISO 16834-A: Mn3Ni1CrMo | EN 12534: Mn3Ni1CrMo

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.60 Cr = 0.30 Cu ≤ 0.25 Mn = 1.60 Mo = 0.30 Ni = 1.50 V = 0.10	800 R <sub>m</sub> (N/mm <sup>2</sup> ) 750 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 19 A <sub>5</sub> (%) +20°C 180 ISO - V (J)		-	0,80	-	CS113857
			-	1,00	-	CS113858
			-	1,20	-	CS113859

#### APPLICATIONS

- ▶ Steel used in the industrial sectors of means of transport and ground transport, construction, bridges, tanks, rail transport, mining, shipbuilding, etc.


#### BASE MATERIALS

- ▶ S690Q; S690QL1; S420N; S500N; P420NH; P500NH; S420NL; S500NL; L690M; N-A-XTRA70; USST1; BH70V; HY 100; ASTM A514 F; T1; T1A; T1B; HSST; BH70; HSB77; sTe460-690; Weldox 700; Welten80; Bisalloy80; N-A-XTRA 56-63-65-70; USST1 - T1; HY90

#### PROTECTIVE GAS

- ▶ M20/M21/C2

**xARC 120 SG** AWS/ASME SFA-5.28: ER 120 S-SG | EN ISO 16834-A: Mn4Ni2,5CrMo | EN 12534: Mn4Ni2,5CrMo

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.11 Si = 0.70 Cr = 0.50 Cu ≤ 0.25 Mn = 1.90 Mo = 0.50 Ni = 2.50	1040 R <sub>m</sub> (N/mm <sup>2</sup> ) 960 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 16 A <sub>5</sub> (%) +20°C 130 ISO - V (J)		-	0,80	-	CS113860
				1,00	-	CS113861
				1,20	-	CS113862

## APPLICATIONS

- Fine-grained, high yield strength, austempered steels; excellent properties down to -60°C.
- Lifting and handling machinery, bridges, tanks, transport, shipbuilding, railways, mines, cranes, structures, etc.

## BASE MATERIALS

- S890QL; P460NH; P460NL1; Weldom 900; StE960; S960Q.

## PROTECTIVE GAS

- M20/M21/C2

## TEMPERATURE RESISTANT STEELS

**xARC MO** AWS/ASME SFA-5.28: ER 70 S-A1 | EN ISO 14341-A: G2 Mo | EN 440: G2 Mo | M. Nº 1.5424

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.60 Cr ≤ 0.15 Cu ≤ 0.25 Mn = 1.20 Mo = 0.50 Ni ≤ 0.15	610 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 25 A <sub>5</sub> (%) +20°C 150 ISO - V (J)		-	0,80	-	CS113863
				1,00	-	CS113864
				1,20	-	CS113865

### APPLICATIONS

- Structural steels resistant to heat and creep in hot work. Pipes, steam boilers, pressure vessels, gas pipelines, shipbuilding, chemicals, petrochemicals, equipment, crane construction.
- V and Nb increase resistance to deformation, corrosion, thermal oxidation and cracking over time.
- Suitable for thermal power stations, turbine rotors, petrochemical plants.

### BASE MATERIALS

- P295GH; P335GH; 16M03; 17M03; 14M06; S275; S355; S420; A210; A285; A335; A369; A516; S275ML; S355M; S420M; S460; 15M03; 10MnMo45; 11MnMo45; GS60; GS22M04; 20MnMoNi5-5; 15NiCuMoNd5S; 17MnMoV64.

### PROTECTIVE GAS

- M21

**xARC 80 D2** AWS/ASME SFA-5.28: ER 80 S-D2 | EN ISO 14341-A: G 50 4 M21 4Mo

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07-0.10 Si = 0.60-0.80 Cr = 0.15 Cu = 0.30 Al = 0.02 Mn = 1.70-1.95 Mo = 0.40-0.60 Ni = 0.10 P = 0.02 S = 0.02 V = 0.015 Ti + Zr = 0.03	730 R <sub>m</sub> (N/mm <sup>2</sup> ) 590 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 21 A <sub>5</sub> (%) -30°C 60 ISO - V (J)			0,80	-	CS114078
				1,00	-	CS114079
				1,20	-	CS114080

### APPLICATIONS

- Solid copper-clad wire for GMAW of creep-resistant low-alloy steels and steels with an operating temperature of up to 500°C, with a high manganese and silicon content to increase deoxidisation properties.
- For use with mixed Ar/Co2 and pure CO2 shielding gas.

### BASE MATERIALS

- Steels for pressure purposes: EN 10028-2, EN 10028-3.
- Fine grain structural steels: EN 10025-3, EN 10025-4.
- Pipework steels: EN ISO 3183, EN 10216-1, EN 10216-2.

### PROTECTIVE GAS

- M21

# SOLID WIRE MIG/MAG



## xARC 80 SG AWS/ASME SFA-5.28: ER 80 S-G | EN 12070: Cr Mo1 Si | DIN 8575: SG Cr Mo1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.65 Cr = 0.15 Cu ≤ 0.25 Mn = 1.05 Mo = 0.50	630 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 23 A <sub>5</sub> (%) +20°C 110 ISO - V (J)	=+	-	0,80	-	CS113866
				1,00	-	CS113867
				1,20	-	CS113868

### APPLICATIONS

- For heat-resistant steels; provides good resistance to attack by hydrogen and sulphur agents.
- Used in steam boilers, pressure tanks, pipework, cranes, earthmoving machinery, presses, the chemical industry and the petrochemical industry.

### BASE MATERIALS

- 13CrMo4-5; 15CrMo5; 16CrMoV4; 22M04; G17CrMo5-5; G22CrMo5- 4; A193 Gr.B7; A335 P11-P12; A193:B7; 13CrMo4-5; 15CrMo3; 13CrMo44; 15CrMo3; 13CrMo4 2; GS-25CrMo 4; GS-17 CrMo55;GS17CrMo55; GS22CrMo4;H IV; 15CrMo3; 13CrMoV42; 13CrMo44; St44KL.

### PROTECTIVE GAS

- M21/C1

## xARC 80 B2 AWS/ASME SFA-5.28: ER 80 S-B2 | EN ISO 21952-B: 1CM

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.55 Cr = 1.30 Cu ≤ 0.25 Mn = 0.60 Mo = 0.50 Ni ≤ 0.20	620 R <sub>m</sub> (N/mm <sup>2</sup> ) 510 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 24 A <sub>5</sub> (%) +20°C 120 ISO - V (J)	=+	-	0,80	-	CS113869
				1,00	-	CS113870
				1,20	-	CS113871

### APPLICATIONS

- For Cr-Mo steels resistant to heat and cracking.
- Boilers, material handling machines, pipework. Chemical and petrochemical industry, especially when dealing with sulphur products.

### BASE MATERIALS

- 13 CrMo4-5(1.7335); G17CrMo55; A387:2,11,12; A199:T11; A200:T11; A213:T11, T12; GS- 25CrMo 4 (1.7128 ) GS 18CrMo910(1.7379); 10CrMo910(1.7380); 10CrSi-MoV7(1.8075); 10CrV63; 12CrSiMo8.

### PROTECTIVE GAS

- M21

## xARC 90 SG AWS/ASME SFA-5.28: ER 90 S-G | EN 12070: Cr Mo2 Si | EN ISO 21952-A: Cr Mo2 Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.60 Cr = 2.50 Cu ≤ 0.25 Mn = 1.00 Mo = 0.50	650 R <sub>m</sub> (N/mm <sup>2</sup> ) 550 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) +20°C 150 ISO - V (J)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">=+</div>	-	0,80	-	CS113872
				1,00	-	CS113873
				1,20	-	CS113874

### APPLICATIONS

- ▶ Cr-Mo alloy steels resistant to high temperatures, corrosion and attack by sulphur agents.
- ▶ Boilers, pipework, steam boilers, pressure vessels, oil industry, thermoelectric industry, chemical and petrochemical industry.

### BASE MATERIALS

- ▶ 10CrMo9-10; (1.7380); 10CrSiMoV7(1.8075); G17CrMo9-10(1.7379); A335:P 22; GS 10CrSiMoV7;12CrSiMo8; GS17Cr-MoV511

### PROTECTIVE GAS

- ▶ M21/C1

## xARC 90 B3 AWS/ASME SFA-5.28: ER 90 S-B3 | EN ISO 21952-B: 2C1M

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.50 Cr = 2.40 Cu ≤ 0.25 Mn = 0.60 Mo = 1.00 Ni ≤ 0.20	640 R <sub>m</sub> (N/mm <sup>2</sup> ) 540 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22 A <sub>5</sub> (%) +20°C 150 ISO - V (J)	<div style="border: 1px solid black; padding: 2px; display: inline-block;">=+</div>	-	0,80	-	CS113875
				1,00	-	CS113876
				1,20	-	CS113877

### APPLICATIONS

- ▶ Cr-Mo alloy steels resistant to high temperatures, corrosion and attack by sulphur agents.
- ▶ Boilers, pipework, steam boilers, pressure vessels, oil industry, thermoelectric industry, chemical and petrochemical industry.

### BASE MATERIALS

- ▶ 10CrMo9-10(1.7380); GS 17CrMoV5 11; 10CrSiMoV7;12CrSi-Mo8; GS12CrMo9 10; 10CrSiMoV7; 10Cr V63; 12CrSiMo8.

### PROTECTIVE GAS

- ▶ M21

## STAINLESS STEEL

### xARC 308L Si AWS/ASME SFA-5.9: ER 308L Si | EN 12072: G 19 9 L Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.030 Si = 0.65-1.00 Cr = 19.50-22.00 Cu = 0.75 Mn = 1.60-2.50 Mo = 0.75 Ni = 9.00-11.00 P = 0.03 S = 0.03	$\geq 520 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 35 A_5$ (%) 20°C $\geq 60$ ISO - V (J)		 PA PB	0,80	CS113880
			 PC PF	1,00	CS113881
			 PE	1,20	CS113882

#### APPLICATIONS

- xARC 308L Si is used for welding grade 304 and 304L stainless steel.
- It is used for a wide range of applications, including pipe and sheet metal fabrication, container production, etc.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

#### PROTECTIVE GAS

- M12/M13

### xARC 316L Si AWS/ASME SFA-5.9: ER 316L Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.03 Si = 0.65-1.00 Cr = 18.00-20.00 Cu = 0.50 Mn = 1.50-2.50 Mo = 2.50-3.00 Ni = 11.00-14.00 P = 0.030 S = 0.020	$\geq 520 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 47$ ISO - V (J)		 PA PB	0,80	CS113887
			 PC PF	1,00	CS113888
			 PC PF	1,20	CS113889
			 PC PF	1,60	CS113890

#### APPLICATIONS

- Extra low carbon stainless steel solid wire, type 19 Cr/ 12 Ni/ 3 Mo, similar in composition to ER 316LSi. Suitable for welding or coating surfaces with similar compositions.
- The weld metal has excellent creep resistance up to 850°C. Ferrite control between 5 and 10 per cent. The weld metal has excellent resistance to cracking, intergranular corrosion and creep. Excellent mechanical properties and resistance to chemical corrosion. Si~0.85% improves weldability and produces an excellent bead appearance.
- Precision layer winding technologies guarantee smooth and virtually trouble-free feeding.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

#### PROTECTIVE GAS

- M12/M13

## xARC 310 AWS/ASME SFA-5.9: ER 310 | EN ISO 14343- A: G 25 20

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.08-0.15 Si = 0.30-0.65 Cr = 25.00-28.00 Cu = 0.50 Mn = 1.60-2.50 Mo = 0.50 Ni = 20.00-22.50 P = 0.015 S = 0.03	$\geq 550 > R_m$ (N/mm <sup>2</sup> ) $\geq 350 > R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 70$ ISO - V (J)	=+	 PA PB PC PF PE	0,80 1,00 1,20	CS113891 CS113892 CS113893

### APPLICATIONS

- xARC 310 weld metal is used for welding 310, 314 austenitic stainless steel pipes, plates and fittings used in the manufacture of furnaces and similar applications that work at high temperatures.
- It is mainly used for heat exchangers and hot water boilers.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## xARC 347 AWS/ASME SFA-5.9: ER 347 | EN ISO 14343-A: G 19 9 Nb

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.080 Si = 0.30-0.65 Cr = 19.00-21.50 Cu = 0.75 Mn = 1.60-2.50 Mo = 0.75 Ni = 9.00-11.00 P = 0.03 S = 0.03	$\geq 550 R_m$ (N/mm <sup>2</sup> ) $\geq 400 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) 20°C $\geq 65$ ISO - V (J)	=+	 PA PB PC PF PE	0,80 1,00 1,20	CS113894 CS113895 CS113896

### APPLICATIONS

- Used for welding stainless steels of grades 321 and 347. The wire is used for a range of applications, including the manufacture of pipes, plates and containers.
- The weld metal has a high resistance to corrosive media at operating temperatures <400°C. The presence of niobium reduces the propensity for intergranular precipitation of chromium carbide, thus reducing susceptibility to intergranular corrosion.
- The addition of Nb considerably improves the oxidation resistance of the weld deposit.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## xARC 385 AWS/ASME SFA-5.9: ER 385 | EN 14343-A: G 20 25 5 Cu L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.025 Si = 0.50 Cr = 19.50-21.50 Cu = 1.20-2.00 Mn = 1.60-2.50 Mo = 4.20-5.20 Ni = 24.00-26.00 P = 0.020 S = 0.030	$\geq 560 R_m$ (N/mm <sup>2</sup> ) $\geq 410 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 35 A_5$ (%) +20°C $\geq 80$ ISO - V (J)		 PA PB	0,80	CS113897
			 PC PF	1,00	CS113898
			 PE	1,20	CS113899

### APPLICATIONS

- xARC 385 is used for welding ASTM 316 or similar steels when a ferrite-free weld metal is required.
- Used mainly in cryogenic and non-magnetic applications and for welding 904L to ASTM 304 and 316.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## xARC 410 AWS/ASME SFA-5.9: ER 410 | EN ISO 14343- A: G 13

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.12 Si = 0.50 Cr = 11.50-13.50 Cu = 0.75 Mn = 0.60 Mo = 0.75 Ni = 0.60 P = 0.03 S = 0.03	$\geq 450 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 20 A_5$ (%) +20°C $\geq 47$ ISO - V (J)		 PA PB	0,80	CS113900
			 PC PF	1,00	CS113901
			 PE	1,20	CS113902

### APPLICATIONS

- Suitable for use with Ar-CO<sub>2</sub> mixture shielding gases.
- SUPERMIG 410 is mainly used for depositing coatings on carbon steels to resist corrosion, erosion or abrasion.
- Precision layer winding technologies ensure smooth and virtually trouble-free feeding.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13



## xARC 420 AWS/ASME SFA-5.9: ER 420

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.25-0.40 Si = 0.50 Cr = 12.00-14.00 Cu = 0.75 Mn = 0.60 Mo = 0.75 Ni = 0.60 P = 0.03 S = 0.03	$\geq 450 R_m$ (N/mm <sup>2</sup> ) $\geq 400 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 15 A_5$ (%) +20°C $\geq 47$ ISO - V (J)	=+	 PA PB PC PF PE	0,80 1,00 1,20	CS113903 CS113904 CS113905

### APPLICATIONS

- Solid MAG welding wire type ER 420 supplied with a precision layer, suitable for use with Ar-CO<sub>2</sub> mixture shielding gases.
- Mainly used for many coating operations, but with a higher chromium and carbon content, which increases wear resistance.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## xARC DUPLEX AWS/ASME SFA-5.9: ER 2209 | EN 14343 - A: G 22 9 3 N L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.030 Si = 0.90 Cr = 21.50-23.50 Cu = 0.50 Mn = 0.50-2.00 Mo = 2.50-3.50 Ni = 7.50-9.50 N <sub>2</sub> = 0.08-0.20 P = 0.03 S = 0.03	$\geq 690 R_m$ (N/mm <sup>2</sup> ) $\geq 480 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 22 A_5$ (%) +20°C $\geq 50$ ISO - V (J)	=+	 PA PB PC PF PE	0,80 1,00 1,20	CS113906 CS113907 CS113908

### APPLICATIONS

- Used for welding duplex stainless steels in a variety of applications including the manufacture of tubes and plates.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## SPECIAL APPLICATIONS

### xARC 307 SI AWS/ASME SFA-5.9: ER 307 Si | EN ISO 14343-A: G 18 8 Mn

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.20 Si = 1.20 Cr = 17.00-20.00 Cu = 0.30 Mn = 5.00-8.00 Mo = 0.30 Ni = 7.00-10.00 P = 0.03 S = 0.03	$\geq 590 R_m$ (N/mm <sup>2</sup> ) $\geq 420 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 40 A_5$ (%) +20°C $\geq 100$ ISO - V (J)			0,80	CS113909
				1,00	CS113910
				1,20	CS113911

#### APPLICATIONS

- Suitable for welding dissimilar steels between non-alloy steels, austenitic stainless steels or heat-resistant steels, also used for welding hardening and tempering steels such as ballistic steels.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

#### PROTECTIVE GAS

- M12/M13

### xARC 309L SI AWS/ASME SFA-5.9: ER 309L Si | EN ISO 14343-A: G 23 12 L Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.030 Si = 0.65-1.00 Cr = 23.00-25.00 Cu = 0.75 Mn = 1.50-2.50 Mo = 0.75 Ni = 12.00-14.00 P = 0.03 S = 0.03	$\geq 520 R_m$ (N/mm <sup>2</sup> ) $\geq 350 R_{p0.2}$ (N/mm <sup>2</sup> ) $\geq 30 A_5$ (%) +20°C $\geq 100$ ISO - V (J)			0,80	CS113912
				1,00	CS113913
				1,20	CS113914

#### APPLICATIONS

- Used for welding stainless steels to medium and moderate tensile steels; for depositing intermediate layers on the steel before depositing grade 308 stainless steel; for welding coated steels where operating temperatures are below 300°C.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

#### PROTECTIVE GAS

- M12/M13

## xARC 309L MO AWS/ASME SFA-5.9: ER 309L Mo | EN ISO 14343-A: G 23 12 2 L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.030 Si = 0.30-0.65 Cr = 23.00-25.00 Cu = 0.50 Mn = 1.00-2.50 Mo = 2.0-3.0 Ni = 12.00-14.00 P ≤ 0.025 S ≤ 0.020	≥550 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥350 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥30 A <sub>5</sub> (%) +20°C ≥55 ISO - V (J)	=+	 PA PB	0,80	CS113915
			PC PF	1,00	CS113916
			PE	1,20	CS113917

### APPLICATIONS

- Suitable for use with mixed Ar+2%O<sub>2</sub> or Ar+0.5...5%CO<sub>2</sub> shielding gases.
- Used for TIG / MIG welding of high alloy steels with molybdenum and unalloyed steels.
- Suitable for welding stainless steels of the AISI 309 series, coated steels of the 316 series, as well as dissimilar metals such as austenitic stainless steel with molybdenum to carbon steel, etc.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## xARC 312 AWS/ASME SFA-5.9: ER 312 | EN ISO 14343- A: G 29 9

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	REF.
C = 0.15 Si = 0.30-0.65 Cr = 28.00-32.00 Cu = 0.75 Mn = 1.60-2.50 Mo = 0.75 Ni = 8.00-10.50 P = 0.03 S = 0.03	≥700 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥550 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥22 A <sub>5</sub> (%) +20°C ≥30 ISO - V (J)	=+	 PA PB	0.80	CS113918
			PC PF	1.00	CS113919
			PE	1.20	CS113920

### APPLICATIONS

- Used for welding steels such as medium and high carbon steels and combinations of dissimilar steels.
- It offers a high tolerance to dilution and is therefore particularly suitable for depositing pad layers before coating.

CURRENT INTENSITY	0.80mm	1.00mm	1.20mm
Ar+1~2%CO <sub>2</sub>	40~120 (A)	80~160 (A)	100~210 (A)
Ar+1~2%O <sub>2</sub>	160~210(A)	180~280 (A)	200~300 (A)

### PROTECTIVE GAS

- M12/M13

## NICKEL BASED STEELS

### xARC NICR 3 AWS/ASME SFA-5.14: ER NiCr-3 | EN ISO 18274: G Ni 6082 (NiCr20Mn3Nb)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.50 Cr = 18.00-22.00 Cu = 0.50 Mn = 2.50-3.50 Fe = 3.00 Ti = 0.75 Ni = 67.00 Nb+Ta = 2.00-3.00 P = 0.03 S = 0.015	≥620 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥380R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥35 A <sub>5</sub> (%) 20°C ≥100 ISO - V (J)	=+	 PA PB	0,80	-	CS113921
			 PC PG	1,00	-	CS113922
			 PF PE	1,20	-	CS113923

#### APPLICATIONS

- Solid MIG welding wire type Ni 6082 / ER NiCr-3, suitable for use with inert shielding gases.
- Used for welding Ni-Cr alloys that are highly resistant to creep, heat and corrosion. It can be used to join steels with 3%, 5% and 9% nickel to give good strength and toughness in LPG and LNG processing or storage facilities.
- xARC NICR 3 is also used to join ferritic to austenitic (dissimilar) steels.

#### PROTECTIVE GAS

- I1/I3

### xARC NICRMO 3 AWS A 5.14: ERNiCrMo-3 | UNS: N06625

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.10 Si = 0.50 Cr = 20.00-23.00 Cu = 0.50 Al = 0.40 Mn = 0.50 Mo = 8.00-10.00 Fe = 5.00 Ti = 0.40 Ni = 58.00 Nb+Ta = 3.15-4.15 P = 0.020 S = 0.015	≥750 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥350 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) ≥25 A <sub>5</sub> (%) 20°C ≥100 ISO - V (J)	=+	 PA PB	0,80	-	CS113924
			 PC PF	1,00	-	CS113925
			 PE	1,20	180~220	CS113926

#### APPLICATIONS

- Exceptional fatigue strength and excellent resistance to oxidation and corrosion in a wide range of corrosive conditions, including the aerospace industry (aircraft duct systems, jet engine exhaust systems, turbine cover rings, bellows and expansion joints, aircraft exhaust liners and turbine seals), nuclear water reaction components, power stations, seawater, marine engineering, pollution control equipment and applications in the chemical processing industry.

#### PROTECTIVE GAS

- I1/I3

## CAST IRON

### xARC NIFE EN ISO 1071: G C NiFe-1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.03 Si = 0.1 Cu = 0.4 Mn = 0.7 Ni = 55 Fe remaining	450 R <sub>m</sub> (N/mm <sup>2</sup> ) 350 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 16 A <sub>5</sub> (%)		 PA PB	1,00	-	CS113927
			 PC PF			
			 PE	1,20	-	CS113928

#### APPLICATIONS

- Cast iron joint with special graphite cast iron according to DIN 1693, e.g. GGG-38 to GGG-70.

#### PROTECTIVE GAS

- M11/M12

### xARC NI 1 AWS/ASME SFA-5.14: ER Ni 1 | EN ISO 18274: S Ni 2061 | MAT. N° 2.4155

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.	
C = 0.15 Si = 0.7 Mn = 1.00 Ti = 2.0-3.5 Fe = 0.2	>380 R <sub>m</sub> (N/mm <sup>2</sup> ) >200 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) >30 A <sub>5</sub> (%)		 PA PB	1,00	-	CS113929	
			 PC PF				
			 PE	1,20	-	CS113930	

#### APPLICATIONS

- Nickel, low-alloy nickel (semi-finished Ni products/Ni castings), e.g. LC-Ni 99.6 (2.4061), NiMn 5 (2.4116); G-Ni 95 (2.4170), as well as welded joints between these materials and steel, cast steel, copper; coatings and cushion layers.

#### PROTECTIVE GAS

- I1

## COPPER ALLOYS

**xARC COBRE** AWS/ASME SFA-5.7: ER Cu | EN ISO 24373: S Cu 1898A-CuSn1MnSi | DIN 1733: M CuSn

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.10-0.40 Sn = 0.50-1.00 Al < 0.01 Mn = 0.10-0.40 Fe < 0.03 Ni < 0.10 P < 0.015 Pb < 0.01 Cu remaining	210-245 R <sub>m</sub> (N/mm <sup>2</sup> ) 60-80 HB	<b>==+</b>	-	1,00	-	CS113931
				1,20	-	CS113932

### APPLICATIONS

- Copper wire for high-quality welding.
- It can be used with TIG and MIG methods.
- Its excellent fluidity makes it ideal for welding copper. Thanks to the deoxidiser in the welding material, the weld is solid and pore-free.

### PROTECTIVE GAS

- I1

**xARC CUSN 6** AWS/ASME SFA-5.7: ER Cu Sn-A | EN ISO 24373: S Cu 5180A-CuSn6P | DIN 1733: M CuSn6

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 4.00-7.00 Zn < 0.10 Al < 0.01 Fe < 0.10 P < 0.01-0.40 Pb < 0.02 Cu remaining	320-360 R <sub>m</sub> (N/mm <sup>2</sup> ) >25 A <sub>5</sub> (%) 80-90 HB	<b>==+</b>	-	1,00	-	CS113933
				1,20	-	CS113934

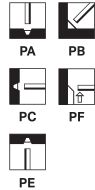
### APPLICATIONS

- Suitable for TIG and MIG methods and excellent for fixing in artistic castings.
- Ideal for surfaces, this material improves hardness and can also be used to fix worn surfaces with similar base metals.

### PROTECTIVE GAS

- I1

## xARC CUSN 12 EN ISO 24373: S Cu 5410 | MAT. N° 2.1056

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Sn = 12 Cu Bal.	350 R <sub>m</sub> (N/mm <sup>2</sup> ) 200 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 15 A <sub>5</sub> (%) 120 HB	=+	 PA PB PC PF PE	1,00	-	CS113935
			1,20	-	CS113936	

### APPLICATIONS

- ▶ Copper-tin alloys, e.g. bronze with 10-12% Sn, copper-zinc alloys (brass), cast copper-tin-zinc-lead alloys (red bronze: Rg5, Rg7), accumulation welds on cast iron.

### PROTECTIVE GAS

- ▶ I1

## xARC CUAL 8 AWS/ASME SFA-5.7: ER Cu-Al-A1 | EN ISO 24373: S Cu 6100-CuAl7 | DIN 1733: M CuAl8

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si < 0.20 Zn < 0.20 Al = 6.00-8.50 Pb < 0.02 Cu remaining	390-450 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥45 A <sub>5</sub> (%) 80-110 HB	=+	-	0,80	-	CS113937
				1,00	-	CS113938
				1,20	-	CS113939

### APPLICATIONS

- ▶ Shipbuilding: propellers, pumps, shafts and valves, bearings, main shafts.
- ▶ Chemical industry: gate valves, sleeves, pipes, heat exchangers, gearboxes.
- ▶ Automotive industry: maintenance of car parts and tools, bearings in general and galvanised sheet metal.
- ▶ Construction industry: welding and coating aluminium-bronze with a steel base. Recommended for coating wear metals.

### PROTECTIVE GAS

- ▶ I1

**xARC CUSI 3** AWS/ASME SFA-5.7: ER Cu Si-A | EN ISO 24373: S Cu 6560-CuSi3Mn1 | DIN 1733: M CuSi3

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 2.80-4.00 Sn < 0.20 Zn < 0.40				0,80	-	CS113944
Al < 0.02 Mn = 0.50-1.50 Fe < 0.50 P < 0.05 Pb < 0.02 Cu remaining	330-370 R <sub>m</sub> (N/mm <sup>2</sup> ) ≥40 A <sub>5</sub> (%) 80-90 HB	<b>==+</b>	-	1,00	-	CS113945
				1,20	-	CS113946

## APPLICATIONS

- This material is often used for fastening in artistic foundries, for welding galvanised sheets and even as a coating for steel using MIG and TIG methods.
- Suitable for surfaces subject to corrosion.

## PROTECTIVE GAS

- I1



## HARDFACING

### xARC DUR 350 DIN 8555: MSG 5-GZ-350 | MAT. Nº 1.7363

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.50 Cr = 6.00 Mn = 0.70 Mo = 0.70	337-372 HB 36-40 HRC	=+	-	1,00	-	CS113947
				1,20	-	CS113948

#### APPLICATIONS

- Wires for wear-resistant coatings with hardness values from 22 HRC to 60 HRC.
- They are used for repairing guide rollers, screw conveyors, gears, crushers, tools, hammers, etc.

#### PROTECTIVE GAS

- M21

### xARC DUR 600 EN ISO 14700: S Fe8 | DIN 8555: MSG 6-GZ-60 | MAT. Nº 1.4718

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.45 Si = 3.00 Cr = 9.30 Mn = 0.40	550-620 HB 57-60 HRC	=+	-	1,00	-	CS113949
				1,20	-	CS113950
				1,60	-	CS113951

#### APPLICATIONS

- Wires for wear-resistant linings.
- They are used to repair guide rollers, screw conveyors, gears, crushers, tools, hammers, etc.

#### PROTECTIVE GAS

- M21

## ALUMINUM ALLOYS

### xARC AL Si5 AWS/ASME SFA-5.10: ER 4043 | EN ISO 18273: S Al 4043 (AlSi5)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 4.50-6.00 Zn = 0.10 Cu = 0.30				1,00	-	CS113953
Mn = 0.05 Mg = 0.05 Ti = 0.20 Be = 0.0003 Fe = 0.80 Al remaining	120 R <sub>m</sub> (N/mm <sup>2</sup> ) 60 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 15 A <sub>5</sub> (%)	<b>==+</b>	-	1,20	-	CS113954
				2,40	-	CS114005

#### APPLICATIONS

▸ Components for cars, furniture, carpentry.

#### PROTECTIVE GAS

▸ I1/I3

### xARC AL Si12 AWS/ASME SFA-5.10: ER 4047A | EN ISO 18273: S Al 4047A (AlSi12(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 11.00-13.00 Zn = 0.20 Cu = 0.30				1,00	-	CS113955
Mn = 0.15 Mg = 0.10 Ti = 0.15 Be = 0.0003 Fe = 0.60 Al remaining	130 R <sub>m</sub> (N/mm <sup>2</sup> ) 70 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 13 A <sub>5</sub> (%)	<b>==+</b>	-	1,20	-	CS113956

#### APPLICATIONS

▸ Automotive industry, refrigeration, heat exchanger, conditioning.

#### PROTECTIVE GAS

▸ I1/I3

## xARC AL MG3 AWS/ASME SFA-5.10: ER 5754 | EN ISO 18273: S Al 5754 (AlMg3)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.40 Cr = 0.30 Zn = 0.20 Cu = 0.10 Mn = 0.50 Mg = 2.60-3.60 Ti = 0.15 Be = 0.0003 Fe = 0.40 Al remaining	190 R <sub>m</sub> (N/mm <sup>2</sup> ) 80 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 20 A <sub>5</sub> (%)	=+	-	1,00	-	CS113957
				1,20	-	CS113958

### APPLICATIONS

- The construction sector in general, outdoor furniture (gardens, beaches) and the structural industry.

### PROTECTIVE GAS

- I1/I3

## xARC AL MG5 AWS/ASME SFA-5.10: ER 5356 | EN ISO 18273: S Al 5356 (AlMg5Cr(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.25 Cr = 0.05-0.20 Zn = 0.10 Cu = 0.10 Mn = 0.05-0.20 Mg = 4.50-5.50 Ti = 0.06-0.20 Be = 0.0003 Fe = 0.40 Al remaining	250 R <sub>m</sub> (N/mm <sup>2</sup> ) 115 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 17 A <sub>5</sub> (%)	=+	-	0,80	-	CS113961
				1,00	-	CS113962
				1,20	-	CS113963
				1,60	-	CS113964

### APPLICATIONS

- Bicycle and motorbike frames, car body components, closed and tipper bodies, loading side panels, fuel tanks, metal furniture, ladders, loading ramps, lifting stirrups, ship's top table.

### PROTECTIVE GAS

- I1/I3

## xARC AL MG4.5 MN AWS/ASME SFA-5.10: ER 5183 | EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A))

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.40 Cr = 0.05-0.25 Zn = 0.25 Cu = 0.10 Mn = 0.50-1.00 Mg = 4.30-5.20 Ti = 0.15 Be = 0.0003 Fe = 0.40 Al remaining	278 R <sub>m</sub> (N/mm <sup>2</sup> ) 135 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 17 A <sub>5</sub> (%)	=+	-	1,00	60-80	CS113966
				1,20	110-135	CS113967

### APPLICATIONS

- Shipyards, storage tanks, structural industry, cryogenic applications.

### PROTECTIVE GAS

- I1/I3

## xARC AL 99.7 AWS/ASME SFA-5.10: ER 1070 | EN ISO 18273: S Al 1070 (Al 99.7)

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
Si = 0.20 Zn = 0.04 Cu = 0.04 Al = 99.70 Mn = 0.03 Mg = 0.03 Ti = 0.03 Be = 0.0003 Fe = 0.25 V = 0.05	80 R <sub>m</sub> (N/mm <sup>2</sup> ) 35 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 30 A <sub>5</sub> (%)	=+	-	1,00	-	CS113968
				1,20	-	CS113969

### APPLICATIONS

- Used for GMAW and GTAW welding processes in the chemical, electronics, construction and food industries.
- The 99.7% Al alloy is used for flame metallisation and arc spray metallisation.

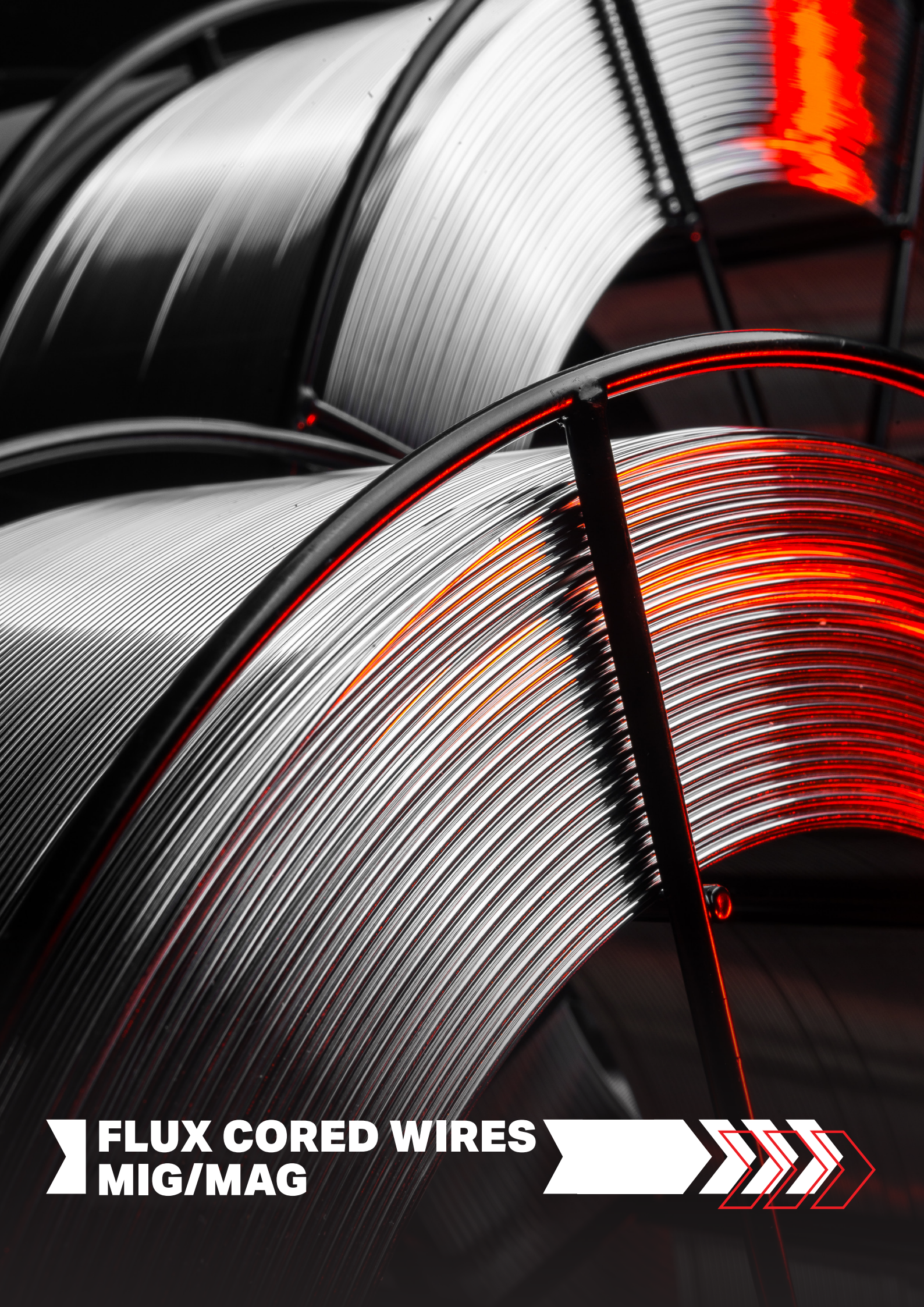
### PROTECTIVE GAS

- I1/I3



# SOLID WIRE MIG/MAG

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**FLUX CORED WIRES**  
**MIG/MAG**



## LOW AND MEDIUM CARBON STEELS

DESIGNATION	CLASSIFICATION	PAG.
	AWS A5.20: E70C-6M H4   EN ISO 17632-A: T 42 2 M C/M21 1 H5	120
xARC 70 6M PREMIUM	AWS/ASME A 5.18: E70C-6M H4   EN ISO 17632-A: T 46 6 M M 1 H5	120
xARC 71R	AWS/ASME A5.20: E 71T-1C/M   EN ISO 17632-A: T 42 2 P C1/M21 1	121
xARC 71R PREMIUM	AWS/ASME A5.20: E 71T-1M H4   EN ISO 17632-A: T 46 4 P M 1 H5	121
xARC 71B	AWS A5.20: E71T-5M-J   EN ISO 17632-A: T 42 4 B M 1 H5	122
xARC 71B PREMIUM	AWS/ASME A5.20: E71T-5M-JH4   EN ISO 17632-A: T 46 6 B M 3 H5	
xARC 71 11 AP		123
xArc 71 ZINC	AWS/ASME A5.18: E70C-GS   EN ISO 17632-A: T 46 Z Z M M 1 H5	123

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 308L	AWS/ASME SFA-5.22: E 308L T1-1/4   EN ISO 17633-A: T 19 9 L P C/M 1	124
xARC 308L AP	AWS A5.22: E308L T0-3	124
xARC 316L	AWS/ASME SFA-5.22: E 316L T1-1/4   EN ISO 17633-A: T 19 12 3 L P C/M 1	125
xARC 316L AP	AWS A5.22: E316LT0-3	125

## SPECIAL APPLICATIONS

DESIGNATION	CLASSIFICATION	PAG.
xARC 307	AWS A5.22: E307T0-1/4   EN ISO 17633-A: T 18 8 Mn C/M 1	126
xARC 309L		126
xARC 309L MO	AWS/ASME SFA-5.22: E 309L Mo T1-1/4   EN ISO 17633-A: T 23 12 2 L P C/M 1	127

## HARDFACING

DESIGNATION	CLASSIFICATION	PAG.
xARC DUR 350	EN14700: T Fe1	128
xARC DUR 350 PREMIUM	EN ISO 14700: T Fe1	128
xARC DUR 600	EN 14700: T Fe2	129
	EN ISO 14700: T Fe2	129
xARC DUR FAST STEELS PREMIUM	EN ISO 14700: T Fe4	130
xARC DUR 65/13 PREMIUM		130
xARC DUR 67/16 PREMIUM	EN ISO 14700: T ZFe16	131
xARC DUR 61/15 PREMIUM	AWS/ASME A5.21: ERCFeCr-A9   EN ISO 14700: T Fe15	131

## LOW AND MEDIUM CARBON STEELS

### xARC 70 6M AWS A5.20: E70C-6M H4 | EN ISO 17632-A: T 42 2 M C/M21 1 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.04 Si = 0.80 Mn = 1.47 P = 0.013 S = 0.012	590 R <sub>m</sub> (N/mm <sup>2</sup> ) 520 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 27 A <sub>5</sub> (%) -20°C 85 ISO - V (J)	=+	 PA PB	1.00	-	CS113970
			 PF PE	1.20	140-300	CS113971

#### APPLICATIONS

- Flux cored wire for welding. The quality of the slag is almost the same as solid wire and multiple pass welding can be carried out without removing the slag. A 20 per cent higher productivity can be achieved compared to solid wires. It has good penetration, high resistance to porosity, good wetting behaviour and low hydrogen content.
- Typical applications include machinery, shipbuilding, offshore structures, naval structures, bridges and general fabrication, suitable for semi-automatic, automatic, single pass and multiple pass welding.

#### PROTECTIVE GAS

- M21/C1

### xARC 70 6M PREMIUM AWS/ASME A 5.18: E70C-6M H4 | EN ISO 17632-A: T 46 6 M M 1 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.5 Mn = 1.4		=+	 PA PB PF PE	1.20	100-350	CS113972

#### APPLICATIONS

- Non-alloy construction steel, boiler plate, pipe steels, fine grain steels, shipbuilding steels, cast steels.

#### PROTECTIVE GAS

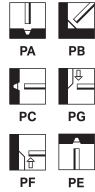
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#### BASE MATERIALS

- Unalloyed construction steels: EN 10025 | S185, S235JR to S355K2G4.
- Boiler plate: EN 10028-2 | P235GH, P265GH, P295GH, P355GH.
- Fine grain steels: EN 10028-3 | P275N, NH, NL1, NL2 to P460N, NH, NL1, and NL2. EN 10113 | S275N to S460N, S275M to S460ML.
- Pipe steels: EN 10208 | L240NB to L445NB.
- Pressure vessel plates: ASTM | SA-516 Gr55 to SA-516Gr70.
- Steels for shipbuilding: A, B, D, E, and A32/36 to F40.
- Foundry steels: DIN 1681 | GS-38, GS-45, and GS-52.



## xARC 71R AWS/ASME A5.20: E 71T-1C/M | EN ISO 17632-A: T 42 2 P C1/M21 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.056 Si = 0.35 Mn = 1.37 P = 0.019 S = 0.012	565 R <sub>m</sub> (N/mm <sup>2</sup> ) 480 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 26 A <sub>5</sub> (%) -20°C 112 ISO - V (J)	=+		1.20	140-300	CS113973

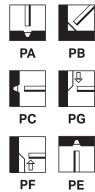
### APPLICATIONS

- Dual-use CO<sub>2</sub> and mixed gas flux-cored wire used for all positional welding, and can also be used for vertical downward welding.
- Good operating properties, such as easy slag removal, stable arc, less smoke and spatter.
- Used for welding carbon steels and high-strength steels of 500MPa grade.

### PROTECTIVE GAS

- M21/C1

## xARC 71R PREMIUM AWS/ASME A5.20: E 71T-1M H4 | EN ISO 17632-A: T 46 4 P M 1 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.04 Si = 0.4 Mn = 1.2		=+		1.20	100-300	CS113974

### APPLICATIONS

- Unalloyed or low-alloy construction steels, boiler plates, pipe steels, fine-grained steels and shipbuilding steels.

### BASE MATERIALS

- Unalloyed construction steels: EN 10025 | S235JRG1 to S355J2G3.
- Boiler plate: EN 10028-2 | P235GH to P355GH.
- Fine grain steels: EN 10113 | S275 to S420N, P275NL to P420NL.
- Pipe steels: EN 10208 | L240NB to L415NB. API 5LX | X42, X46, X52, X60.
- Steels for shipbuilding: A, E, A32 - F40

### PROTECTIVE GAS

- M21

## xARC 71B AWS A5.20: E71T-5M-J | EN ISO 17632-A: T 42 4 B M 1 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.07 Si = 0.38 Mn = 1.58 P = 0.019 S = 0.012	570 R <sub>m</sub> (N/mm <sup>2</sup> ) 486 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 31 A <sub>5</sub> (%) -45°C ≥27 ISO - V (J)			1.00	-	CS113975
				1.20	140-300	CS113976
				1.60	180-400	CS113977

### APPLICATIONS

- Used for welding carbon steel and low-alloy structural steel with tensile strengths greater than or equal to 490MPa and with excellent low-temperature toughness and good resistance to cracking.
- Suitable for welding some important structures such as shipbuilding, vehicles, mechanical engineering, pressure vessels, petrochemical machinery, lifting machinery, etc.  
Used for welding carbon steels and high-strength steels of grade 500MPa.

### PROTECTIVE GAS

- M21/C1

## xARC 71B PREMIUM AWS/ASME A5.20: E71T-5M-JH4 | EN ISO 17632-A: T 46 6 B M 3 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.06 Si = 0.4 Mn = 1.4	580 R <sub>m</sub> (N/mm <sup>2</sup> ) 480 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 28 A <sub>5</sub> (%) -60°C 100 ISO - V (J)				110-300	CS113978

### APPLICATIONS

- Non-alloy construction steel, boiler plate, pipe steels, fine grain steels, shipbuilding steels, cast steels.

### PROTECTIVE GAS

- M21

### BASE MATERIALS

- Unalloyed construction steels: EN 10025 | S185, S235JR to S355K2G4.
- Boiler plate: EN 10028-2 | P235GH, P265GH, P295GH, P355GH.
- Fine grain steels: EN 10028-3 | P275N, NH, NL1, NL2 to P460N, NH, NL1, NL2. EN 10113 | S275N to S460N, S275M to S460ML.
- Pipe steels: EN 10208 | L240NB to L445NB. API 5LX | X42, X46, X52, X60, X65.
- Pressure vessel plates: ASTM SA-516 Gr55 to SA-516Gr70.
- Steels for shipbuilding: A, B, D, E, and A32/36 to F40.
- Cast steels: DIN 1681 | GS-38, GS-45, GS-52

## xARC 71 11 AP AWS A5.20: E71T-11 | EN ISO 17632-A: T 42 Z Z Z N 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.08 Si = 0.25 Mn = 1.21 P = 0.024 S = 0.017	545 R <sub>m</sub> (N/mm <sup>2</sup> ) 455 R <sub>p0.2</sub> (N/mm <sup>2</sup> ) 22.5 A <sub>5</sub> (%)			0.90	-	CS114080
				1.20	-	CS114081

### APPLICATIONS

- Self-shielded flux-cored wire for all positions, suitable for multipass welding and can be used for vertical downward welding. With good welding properties such as less spatter, stable arc, low smoke content, easy slag removal and excellent bead appearance.

## xArc 71 ZINC AWS/ASME A5.18: E70C-GS | EN ISO 17632-A: T 46 Z Z M M 1 H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.1 Si = 0.6 Mn = 1.6 Fe Bal.				1.00	70-250	CS114082

### APPLICATIONS

- Unalloyed galvanised steel for construction, boiler plate, pipe steels, fine grain steels, shipbuilding steels.

### BASE MATERIALS


- St12, St13, St14.
- ZStE 260 to ZStE 420.
- StE 250-2Z to StE 305-3Z.

### PROTECTIVE GAS

- M21

## STAINLESS STEEL

### xARC 308L AWS/ASME SFA-5.22: EN ISO 17633-A:

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.035 Si = 0.60 Cr = 19.2 Cu = 0.02 Mn = 1.60 Mo = 0.01 Ni = 9.5 P = 0.020 S = 0.015	580 R <sub>m</sub> (N/mm <sup>2</sup> ) 46 A <sub>5</sub> (%)	=+	 PA PB PF PE	1.20	120-220	


#### APPLICATIONS

- Super low carbon stainless steel flux cored wire, designed for all positional welds, which can be used to join stainless steel alloys such as AISI types 301, 302, 304, 305 and 308.
- Its deposited metal has excellent mechanical properties and resistance to intergranular corrosion.

#### PROTECTIVE GAS

- M21/C1



### xARC 308L AP AWS A5.22: E308L T0-3

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.035 Si = 0.60 Cr = 20.3 Cu = 0.02 Mn = 1.60 Mo = 0.01 Ni = 9.5 P = 0.020 S = 0.015	585 (N/mm <sup>2</sup> ) 43 A <sub>5</sub> (%)	=+	 PA PB	0.90	120-220	CS113983

#### APPLICATIONS

- Self-shielded, flux-cored stainless steel wire designed with a nominal weld metal composition of 21% chromium and 10% nickel, with a maximum carbon content of 0.03%.
- The low carbon content of E308LT0-3 minimises the precipitation of carbides and makes the weld metal more resistant to intergranular corrosion.

## xARC 316L AWS/ASME SFA-5.22: E 316L T1-1/4 | EN ISO 17633-A: T 19 12 3 L P C/M 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.039 Si = 0.55 Cr = 18.50 Cu = 0.03 Mn = 1.4 Mo = 2.60 Ni = 12.30 P = 0.022 S = 0.007	549 R <sub>m</sub> (N/mm <sup>2</sup> ) 40 A <sub>5</sub> (%) -196°C 38 ISO - V (J)			1.20	120-220	



### APPLICATIONS

- All-position flux-cored wire adaptable to a variety of workshop and field assembly applications.
- Designed for cryogenic applications where good weld metal strength is required.
- Contains molybdenum which resists pitting corrosion induced by sulphuric and sulphurous acids, chlorides and cellulose solutions.
- Developed for welding austenitic stainless steels type 316, 316L for low temperatures.

### PROTECTIVE GAS

- M21/C1

## xARC 316L AP AWS A5.22: E316LT0-3

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.039 Si = 0.55 Cr = 18.50 Cu = 0.03 Mn = 1.4 Mo = 2.60 Ni = 12.30 P = 0.022 S = 0.007	544 R <sub>m</sub> (N/mm <sup>2</sup> ) 42 A <sub>5</sub> (%) -196°C 49 ISO - V (J)			0.90	120-220	CS113986

### APPLICATIONS

- Self-protected, flux-cored stainless steel wire designed with a nominal weld metal composition of 19% chromium, 12.5% nickel, 2.5% molybdenum and a maximum carbon content of 0.03%. The Mo contained improves corrosion resistance and provides greater resistance to creep. In addition, the low carbon content minimises the precipitation of carbides and makes it more resistant to intergranular corrosion.

## SPECIAL APPLICATIONS

### xARC 307 AWS A5.22: E307T0-1/4 | EN ISO 17633-A: T 18 8 Mn C/M 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.025 Si = 0.566 Cr = 19.98 Cu = 0.025 Mn = 4.33 Mo = 0.569 Ni = 9.82 P = 0.018 S = 0.009	582 R <sub>m</sub> (N/mm <sup>2</sup> ) 41 A <sub>5</sub> (%)	=+	 PA PB	1.20	120-220	CS113987

#### APPLICATIONS

- Stainless steel wire for gas shielded arc welding (CO<sub>2</sub>/Ar + CO<sub>2</sub>) of austenitic stainless steels and manganese steels considered difficult to weld or poorly identified.
- Non-magnetic stainless steel, resistant to hot cracking and work hardening welding deposits.
- Ideal as a cushion layer before hardfacing crack-sensitive grades or in the case of dissimilar joints between stainless steel and steel construction.
- Used for repairing parts exposed to shocks and friction.

#### PROTECTIVE GAS

- M21/C1

### xARC 309L AWS A5.22: E309LT1-1/4 | EN ISO 17633-A: T 23 12 L P C/M 1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.039 Si = 0.55 Cr = 23.02 Cu = 0.03 Mn = 2.10 Mo = 0.02 Ni = 12.97 P = 0.022 S = 0.007	575 R <sub>m</sub> (N/mm <sup>2</sup> ) 34 A <sub>5</sub> (%) -196°C 40 ISO - V (J)	=+	 PA PB PF PE	1.20	120-220	CS113988


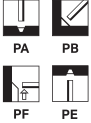
#### APPLICATIONS

- Stainless steel flux-cored wire, designed for welding 22% Cr-12%Ni steel (SUS 309S), 18% Cr-8%Ni coated steel and dissimilar materials such as Cr-Mo steel or mild steel to stainless steel and carbon steel build-up welding.

#### PROTECTIVE GAS

- M21/C1

## xARC 309L MO AWS/ASME SFA-5.22: EN ISO 17633-A:

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.02 Si = 0.47 Cr = 23.43 Cu = 0.05 Mn = 1.3 Mo = 2.3 Ni = 13.12 P = 0.008 S = 0.015	627 R <sub>m</sub> (N/mm <sup>2</sup> ) 32 A <sub>5</sub> (%)			1.20	120-220	CS113989

### APPLICATIONS

- Suitable for welding carbon steel, low alloy steel and dissimilar stainless steel materials, or for overlap welding on the stainless steel cladding layer.

### PROTECTIVE GAS

- M21/C1

## HARDFACING

### xARC DUR 350 EN14700: T Fe1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C < 1.0 Si ≤ 1.0 Cr = 1.0-2.0 Mn = 2.5-5.0 Fe Bal.	30-40 HRc		 PA PB	1.20	180-250	CS113990

#### APPLICATIONS

- Gears, bucket teeth, dredger bucket, tractor scraper, other similar wear conditions.

#### PROTECTIVE GAS

- M21/C1

### xARC DUR 350 PREMIUM EN ISO 14700: T Fe1

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.15 Si = 0.7 Cr = 2 Mn = 1.5 Mo = 0.2	350 HB		 PA PB	1.20	110-300	

#### APPLICATIONS

- Used to coat and rebuild parts subject to high impact and high compressive stresses.

#### PROTECTIVE GAS

- M12/M13/M20/M21/C1



## xARC DUR 600 EN 14700: T Fe2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.2-0.8 Si ≤ 2.0 Cr = 4.0-6.0 Mn = 0.5-2.5 V ≤ 1.0 W ≤ 1.5 Fe Bal.	55-60 HRc	<b>==+</b>	-	1.20	180-260	CS113993

### APPLICATIONS

- Part coating for armoured machinery, buckets, cutting picks, loaders, mining machinery.

### PROTECTIVE GAS

- M21/C1

## xARC DUR 600 PREMIUM EN ISO 14700: T Fe2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.5 Si = 0.7 Cr = 6 Mn = 1.2 Mo = 0.7		<b>==+-</b>	-	1.20	110-300	CS113994



### APPLICATIONS

- Used for paving components that must combine resistance to abrasion and moderate impact.

### PROTECTIVE GAS

- M12/M20/M21

## xARC DUR FAST STEELS PREMIUM EN ISO 14700: T Fe4

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 1.1 Si = 0.5 Cr = 4.9 Mn = 0.5 Mo = 7.5 V = 1.1 W = 2.3	57-63 HRc		 PA PB	1.20	100-300	CS113995



### APPLICATIONS

- Used for hardfacing components subject to metal-to-metal wear under moderate impact conditions.

### PROTECTIVE GAS

- M12/M13/M20/M21/C1



## xARC DUR 65/13 PREMIUM EN ISO 14700: T ZFe13

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.5 Si = 1.3 Mn = 2 Ni = 2 B = 4.5 Fe Bal.	60-65 HRc		 PA PB	1.20	140-230	CS113996

### APPLICATIONS

- Self-protecting flux-cored wire used for coating components subject to wear from dirt, sand and abrasives in agriculture, quarries, mines and public works.



## xARC DUR 67/16 PREMIUM EN ISO 14700: T ZFe16

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 2.5 Si = 0.6 Cr = 11.5 Mn = 2 Nb = 5 B = 2.2	64-68 HRc		 PA PB	1.20	-	CS113997

### APPLICATIONS

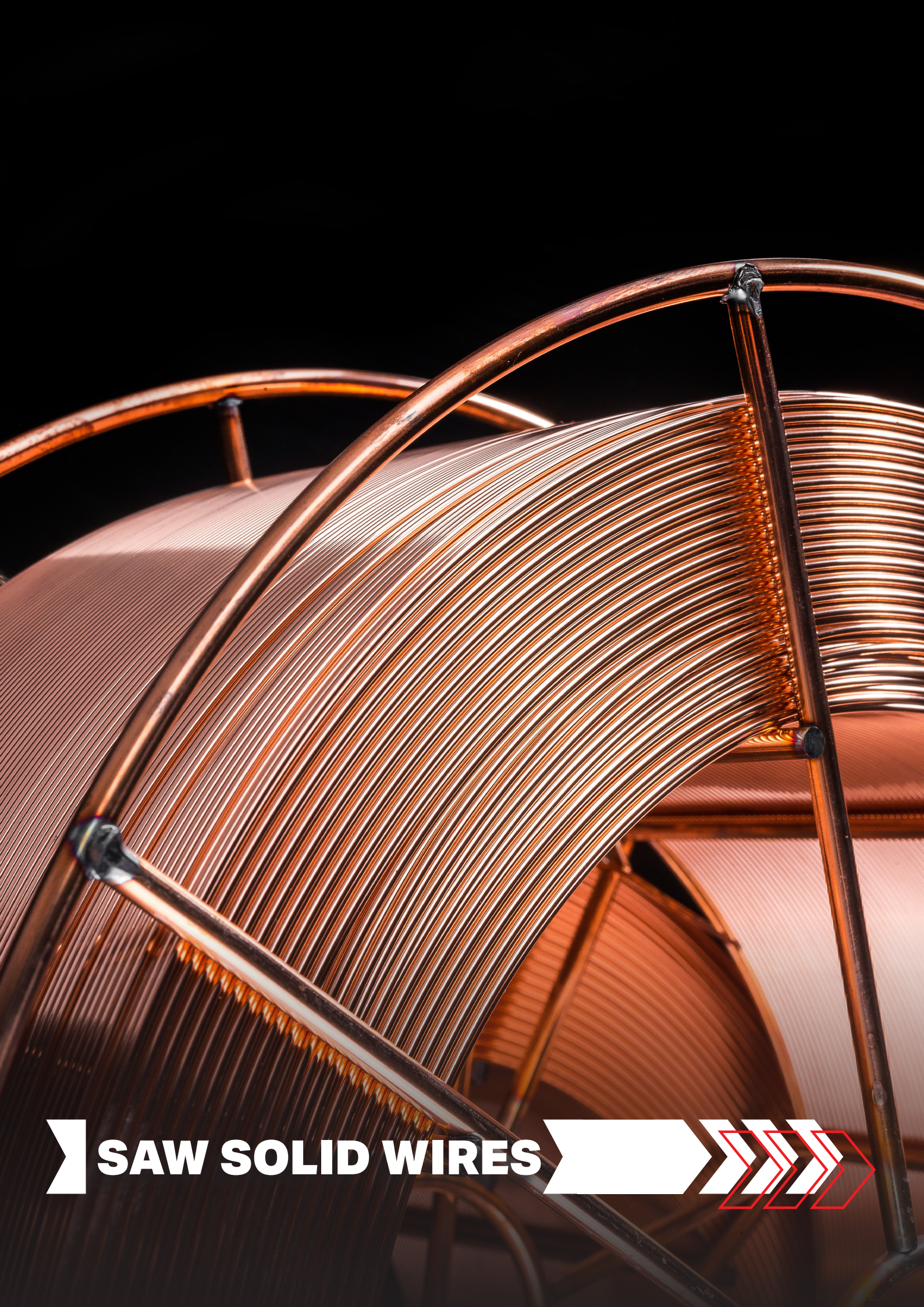
- Self-shielded flux-cored wire for loads resistant to abrasion by fine particles under high tension or erosion in a gaseous environment.

## xARC DUR 61/15 PREMIUM AWS/ASME A5.21: ERCFeCr-A9 | EN ISO 14700: T Fe15

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 5 Si = 1.5 Cr = 27 Mn = 1.5	58-64 HRc		 PA PB	1.20	100-250	CS113998

### APPLICATIONS

- Self-shielding flux-cored wire used for hardfacing components subject to wear from dirt, sand and abrasives.



**SAW SOLID WIRES**



## CARBON AND LOW ALLOY STEELS

DESIGNATION	CLASSIFICATION	PAG.
xARC S2	SFA 5.17/AWS A5.17: EM12(K)   EN ISO 14171-A (EN 756): S2	134
xARC S2 Si	SFA 5.17/AWS A5.17: EM12K   EN ISO 14171-A (EN 756): S2Si	134
xARC S3 Si	SFA 5.17/ASME A5.17: EH12K   EN ISO 14171-A (EN 756): S3Si	135
xARC S2MO	SFA/AWS A5.23: EA2   EN ISO 14171-A: S2Mo   EN ISO 24598-A: S2MO	135

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC 308L	SFA 5.9/AWS A5.9: ER 308L   EN ISO 14343-A: S 19 9 L	136
xARC 316L	SFA-5.9/AWS A5.9: ER 316L   EN ISO 14343-A: S 19 12 3 L	136

## CARBON AND LOW ALLOY STEELS

### xARC S2 SFA 5.17/AWS A5.17: EM12(K) | EN ISO 14171-A (EN 756): S2

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.11 Si = 0.12 Cr = 0.03 Cu = 0.09 Mn = 1.07 Mo = 0.01 Ni = 0.04 P = 0.007 S = 0.008	-	-	-	2.40	-	CS114083
				3.20	-	CS114084
				4.00	-	CS114085

#### APPLICATIONS

- Wire for submerged arc welding of non-alloy and fine-grained steels, boiler steels and pipe steels.

#### BASE MATERIALS

- Non-alloy structural steels according to EN 10025 and ASTM: S235JRG2/A570 grade 36 to S355J2G3R/A572 grade 50.
- Fine grain steels according to EN 10025, EN 10028 and ASTM: up to P355N/S355NL/A516 grade 70.
- Pipe steels according to ISO 3183, EN 10208 and API-5: L415N/X60.
- Boiler steel according to EN 10028 and ASTM: P235GH/A516 grade 55, P355GH/A516 grade 70 and S275J2G3/ A572 grade 42, S355J2G3/A572 grade 50.

### xARC S2 Si SFA 5.17/AWS A5.17: EM12K | EN ISO 14171-A (EN 756): S2Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.26 Cr = 0.05 Mn = 0.96 Mo = 0.03 Ni = 0.05 P = 0.008 S = 0.006	-	-	-	2.40	-	CS114086
				3.20	-	CS114087
				4.00	-	CS114088

#### APPLICATIONS

- Wire with higher Si content for submerged arc welding of unalloyed and fine-grained steels, boiler steels and pipe steels.

#### BASE MATERIALS

- Non-alloy structural steels according to EN 10025 and ASTM: S235JRG2/A570 grade 36 to S355J2G3R/A572 grade 50.
- Fine grain steels according to EN 10025, EN 10028 and ASTM: up to P355N/S355NL/A516 grade 70.
- Pipe steels according to ISO 3183, EN 10208 and API-5 standards: L415N/X60 and L450Q/X65.
- Boiler steels according to EN 10028 and ASTM: P235GH/A516 grade 55, P355GH/A516 grade 70 and S275J2G3/A572 grade 42, S355J2G3/A572 grade 50.

## xARC S3 Si SFA 5.17/ASME A5.17: EH12K | EN ISO 14171-A (EN 756): S3Si

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.33 Cr = 0.03 Cu = 0.06				2.40	-	CS114089
Mn = 1.57 Mo = 0.06 Ni = 0.04 P = 0.012 S = 0.009	-	-	-	3.20	140-300	CS114090
				4.00	180-400	CS114091

### APPLICATIONS

- Wire with higher Si content for submerged arc welding of unalloyed and fine-grained steels (especially Off-Shore), higher strength shipbuilding steels, pipe steels, boiler and ship steels.

### BASE MATERIALS

- Non-alloy structural steels according to EN 10025 and ASTM: S235JRG2/A570 grade 36 to S355J2G3R/A572 grade 50.
- Fine grain steels according to EN 10025, EN 10028 and ASTM: P355N/S355NL/A516 grade 70 / 633 grade E and P460N/S460NL.
- Offshore structural steels up to 460 MPa yield strength and BS 4360 grade 50 D.
- Steels for shipbuilding: greater resistance.
- Pipe steels according to ISO 3183, EN 10208 and API-5 standards: L360N/X52 to L485Q/X70.
- Boiler and vessel steels according to EN 10028 and ASTM: P235GH/A516 grade 55, P355GH/A516 grade 70 and S275J2G3/A572 grade 42, S355J2G3/A572 grade 50.

## xARC S2MO SFA/AWS A5.23: EA2 | EN ISO 14171-A: S2Mo | EN ISO 24598-A: S2MO

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.09 Si = 0.16 Cr = 0.02 Mn = 1.15 Mo = 0.50				2.40	-	CS114092
Ni = 0.01 P = 0.006 S = 0.005	-	-	-	3.20	-	CS114093
				4.00	-	CS114094

### APPLICATIONS

- Mo-alloy wire for submerged arc welding of fine-grained steels, pipe steels and heat-resistant steels for boilers and heat-resistant steels.

### BASE MATERIALS

- Fine grain steels according to EN 10025, EN 10028 and ASTM: P420N/S420NL/A633 grade E and P460N/S460NL.
- Pipe steels according to ISO 3183, EN 10208 and API-5: L415N/X60 to L485Q/X70.
- Heat-resistant steels according to EN 10028 and ASTM: 16 Mo 3/A204 grade A and A209 grade T1, S275J2G3/A572 grade 42 and S355J2G3/A572 grade 50.

## STAINLESS STEEL

### xARC 308L SFA 5.9/AWS A5.9: ER 308L | EN ISO 14343-A: S 19 9 L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.02 Si = 0.4 Cr = 20.0 Cu = 0.1 Mn = 1.8 Mo = 0.1 Ni = 10.0 P = 0.020 S = 0.013	-	-	-	2.40	-	CS114095
				3.20	-	CS114096
				4.00	-	CS114097

#### APPLICATIONS

- Submerged arc welding wire for welding austenitic stainless steels 18% Cr-10% Ni 1.4306 type 304, 304L.

#### BASE MATERIALS

- 1.4306/X2CrNi19-11, 1.4301/X5CrNi18-10, 1.4311/X2CrNi18-10, 1.4312/GX10CrNi18-8, 1.4541/X6CrNiTi18-10, 1.4546/X5CrNiNb18-10, 1.4550/X6CrNiNb18-10  
AISI 304, 304L, 304LN, 302, 321, 347; ASTM A157 grau C9; A320 grau B8C ou D

### xARC 316L SFA-5.9/AWS A5.9: ER 316L | EN ISO 14343-A: S 19 12 3 L

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.015 Si = 0.4 Cr = 19.0 Cu = 0.15 Mn = 1.7 Mo = 2.7 Ni = 12.0 P = 0.020 S = 0.013	-	-	-	2.40	-	CS114098
				3.20	-	CS114099
				4.00	-	CS114100

#### APPLICATIONS

- Submerged arc welding wire for welding 1.4435 / 316L austenitic stainless steels. Suitable for operating temperatures from -120°C to +400°C.

#### BASE MATERIALS

- 1.4401/X5CrNiMo17-12-2, 1.4404/X2CrNiMo17-12-2, 1.4435/X2CrNiMo18-14-3, 1.4436/X3CrNiMo17-13-3, 1.4571/X6CrNiMoTi17-12-2, 1.4580/X6CrNiMoNb17-12-2, 1.4583/X10CrNiMoNb18-12, 1.4409/GX2CrNiMo 19-11-2 UNS S31653; AISI 316L, 316Ti, 316Cb





# SAW SOLID WIRES

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**SAW FLUX**



## CARBON AND LOW ALLOY STEELS


DESIGNATION	CLASSIFICATION	PAG.
xARC ALUMINATO RUTÍLO	ISO 14174: S A AR 1 76 AC H5   EN 760: SA AR 1 76 AC	140
xARC ALUMINATO BÁSICO SPECIAL	ISO 14174: S A AB 1 67 AC H5   EN 760: SA AB 1 67 AC H5	140
xARC ALUMINATO BÁSICO	ISO 14174: S A AB 1 67 AC H5   EN 760: SA AB 1 67 AC H5	141
xARC FLUORETO BÁSICO	ISO 14174: S A FB 1 55 AC H5   EN 760: SA FB 1 55 AC	141

## STAINLESS STEEL

DESIGNATION	CLASSIFICATION	PAG.
xARC ALUMINATO FLUORETO BÁS.	ISO 14174: S A AF 2 5644 DC H5   EN 760: SA AF 2 DC	142
xARC CÁLCIO SILICATO	ISO 14174: S F CS 2 5742 DC   ISO 14174: S F CS 1 63 DC   EN 760: SF CS 2 DC	143

## CARBON AND LOW ALLOY STEELS


### xARC ALUMINATO RUTÍLO ISO 14174: S A AR 1 76 AC H5 | EN 760: SA AR 1 76 AC

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.04-0.08 Si = 0.3-0.6 Mn = 0.8-1.1	-		-	-	-	CS114101

#### APPLICATIONS

- Preferably used for single-pass, two-pass and fillet submerged arc welding.
- The main fields of application include steel structures, thin-walled containers, LP gas cylinders and thin tube walls.


### xARC ALUMINATO BÁSICO SPECIAL ISO 14174: S A AB 1 67 AC H5 | EN 760: SA AB 1 67 AC H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.05-0.08 Si = 0.2-0.4 Mn = 0.9-1.3	-		-	-	-	CS114102

#### APPLICATIONS

- Joint welding of non-alloy and low-alloy structural steels according to EN 10025.
- Fine-grained construction steels with YS < 420MPa and boiler steels such as P265GH (H II) and 16M03.


## xARC ALUMINATO BÁSICO ISO 14174: S A AB 1 67 AC H5 | EN 760: SA AB 1 67 AC H5

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.05-0.8 Si = 0.2-0.4 Mn = 1.1-1.5	-		-	-	-	CS114103

### APPLICATIONS

- Submerged arc welding of low-alloy structural steels (Y.S. up to 420MPa), boiler and vessel materials, high-strength ship steels such as EH36, fine-grained structural steels up to Y.S. 460 MPa and pipe steel grades up to X70 (ISO 3183/ API-5L).

## xARC FLUORETO BÁSICO ISO 14174: S A FB 1 55 AC H5 | EN 760: SA FB 1 55 AC

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C = 0.05-0.09 Si = 0.1-0.3 Mn = 0.8-1.2	-		-	-	-	CS114104

### APPLICATIONS

- Thick-walled construction steels with yield strengths up to 420MPa.
- OFF-SHORE applications up to 550MPa yield strength in steels such as BS 4360-Grade 50 D and S355 2G3 according to DIN EN 10025 (previous designation St 52-3N).
- Fine-grained structural steels for low-temperature requirements with impact resistance at - 60°C or less.
- Fine-grained steels with high tensile strength.
- Boiler and vessel steels.

## STAINLESS STEEL

**xARC ALUMINATO FLUORETO BÁSICO** ISO 14174: S A AF 2 5644 DC H5 | EN 760: SA AF 2 DC

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C < 0.03 Si = 0.3-0.65 Cr = 19.5-22.0 Cu = 0.1 Mn = 1.0-2.5 Ni = 9.0-11.0	-	=+	-	-	-	CS114105

### APPLICATIONS

- Austenitic-ferritic stainless steels (DSS) such as grade 2205 (Duplex S31805/S32205 = 1.4462).
- CrNi(Mo) austenitic steels (including Nb/Ti and ELC grades); resistant to intergranular corrosion, both in the welded and solution-treated state.
- High-alloy CrNi(Mo) steels for use at low temperatures and heat-resistant steels.
- Nickel-based alloys using NiCr and NiCrMo wire electrodes in accordance with AWS A5.14/ EN ISO 18274.
- Welding dissimilar metals such as low alloy steel with stainless steel or special cryogenic steel (e.g. Ni-9% steel) in a flat or 2G position.

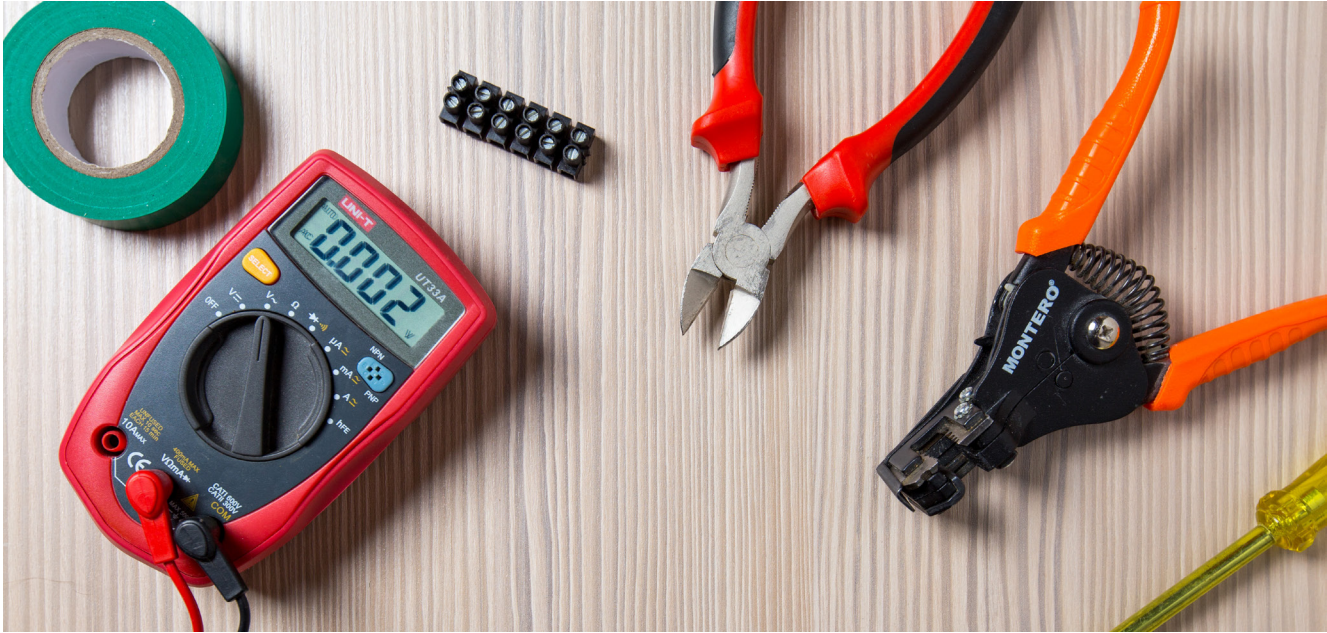
**xARC CÁLCIO SILICATO** ISO 14174: S F CS 2 5742 DC | ISO 14174: S F CS 1 63 DC | EN 760: SF CS 2 DC

CHEMICAL COMPOSITION (%)	MECHANICAL PROPERTIES	POLARITY / VOLTAGE	WELDING POSITION	MEASURES (mm)	AMPERAGE	REF.
C < 0.08 Si < 0.5 Mn < 1.0 Mo = 0.5	-	==+	-	-	-	CS114106

## APPLICATIONS

- Creep-resistant CrMo steels such as 12CrMo19-5/A355 grade P22-P5 or X20CrMoWV12-1/A351 for the manufacture of boilers, vessels and pipes.
- Martensitic and ferritic Cr(NiMo) steels, in accordance with EN 10088, with the appropriate wire electrodes, together with the corresponding heat treatments.
- CrNi(Mo) austenitic steels (including ELC grades) according to EN 10088; resistant to intergranular corrosion in both the welded and solution-treated state.
- High-alloy CrNi(Mo) steels for use at low temperatures and heat-resistant steels.
- High-alloy Cr(NiMo) steels in combination with low-alloy steels (dissimilar joints).
- Nickel-based alloys using NiCr and NiCrMo wire electrodes in accordance with AWS A5.14 / EN ISO 18274.

# ELECTREX SERVICES



## WARRANTY

Our consumables are manufactured using rigorous production processes and tested to operate under the most demanding conditions and in accordance with international standards, guaranteeing their reliability and quality.



## DO YOU HAVE TECHNICAL QUESTIONS?

At Electrex we are always available to listen and answer the needs of our customers as soon as possible. Use our fast Email and WhatsApp communication channels to solve your questions or technical difficulties

**Rui Almeida:**

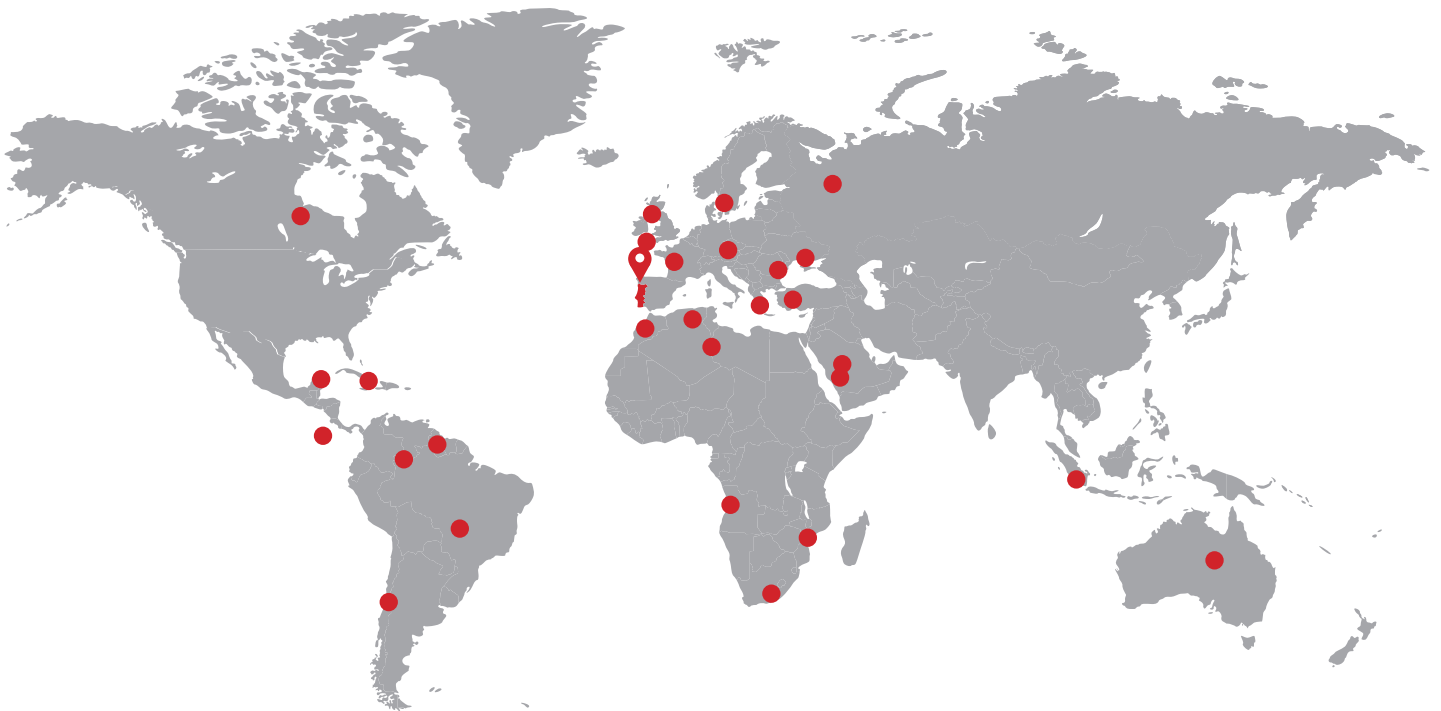
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● Distribution points

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# WELDING SINCE 1946

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