DIGEST

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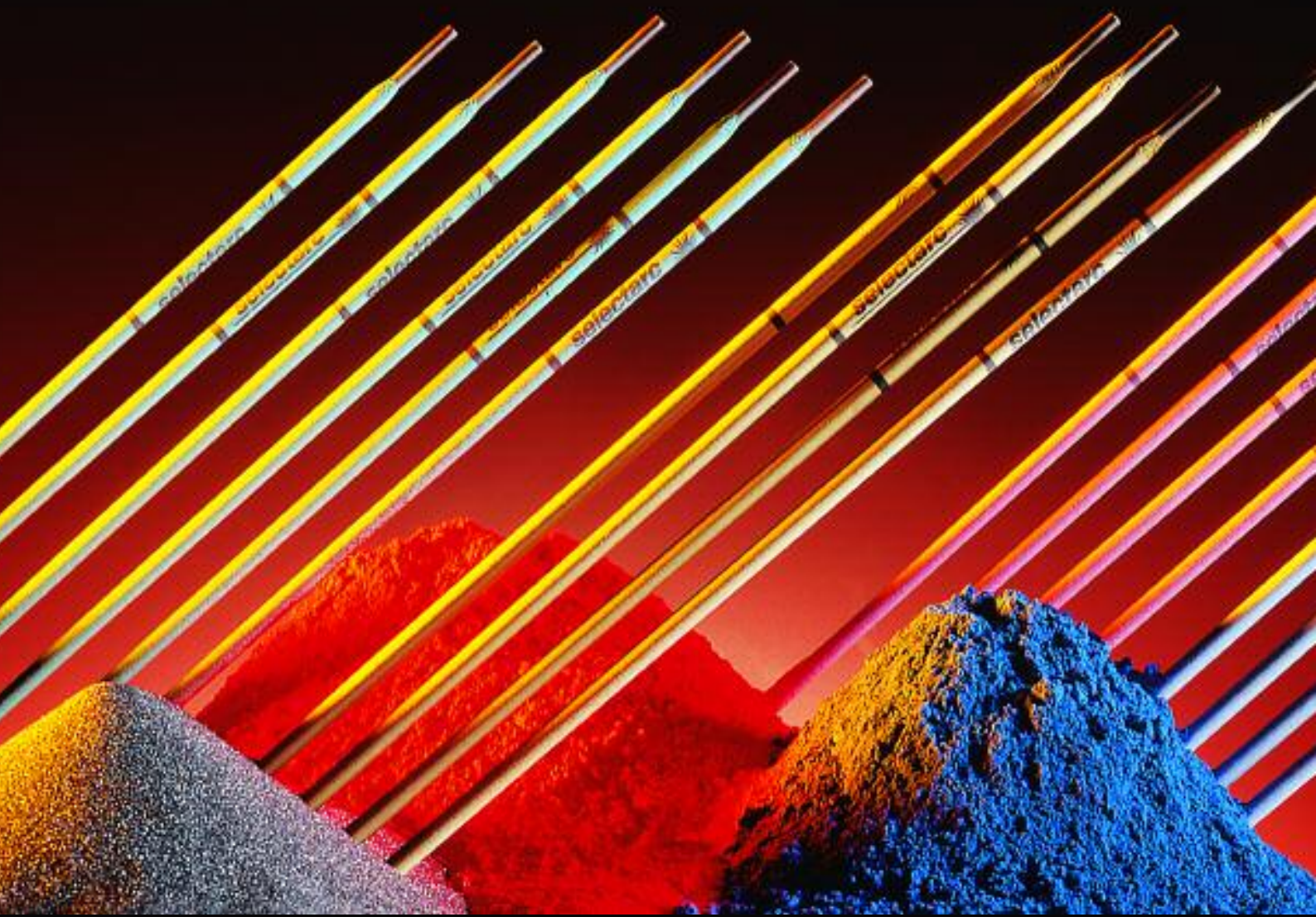
Innovative welding electrodes



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A wide range of innovative welding electrodes

rutile and cellulose electrodes

Type	Norm
48SP	E 6013
51	E 6013
54	E 6013
55	E 6013
D6	E 6013
160	E 7024
180*	E 7024
C6010	E 6010
C8010*	E 8010-G
GALVA 46	E 6013
RRB7	E 6013
R63*	E 8013-G
D C S	(Chamfering)
CUT 100	(Cutting)
Goug	(Gouging)

basic electrodes for low alloy steels

Type	Norm
B56	E 7018-1
B7016Sp	E 7016
B7028	E 7028

basic electrodes for high temperature service

Type	Norm
B 60	E 7018-A1
B 63	E 8018-B2
B 68	E 9018-B3
B 69	E 8018-B6
B 609	E 8016-B8

basic electrodes for high strength steels

Type	Norm
B 70	E 10018-G
B 72	E 9018-G
B 73	E 9018-D1
B 75Cu	E 8018 –W
B 77	E 11018-M

basic electrodes for low temperature steels

Type	Norm
B 81	E 8018-C3
B 82	E 8018-C1
B 84*	E 8018-C2

**Available on request. Consult us.*

electrodes for stainless steels and repair

Type	Norm
20/10BC	E 308L-16
Inox 308B	E 308L-15
308 HR	E 308L-26
Inox 308HB	E 308H-15
Inox 347	E 347-16
20/10MBC	E 316L-16
316VD	E 316L-16
Inox 316B	E 316L-15
316HR	E 316L-26
Inox 318	E 318-17
24/12 S	E 309L-16
309HR	E 309-26
24/12Mo	E 309 MoL-17
307R	E 307-16
307B	E 307-15
18/8Mn	E 307-26
Inox 308Mo	E 308 Mo-17
29/9	E 312-16
Inox 312HR	E 312-26
25/20R	E 310-16
25/20B	E 310-15
Inox 310H*	E 310H-15
Inox 253MA	E 22 12 B 4 2
Inox 25/35H*	
Inox 2209	E 2209-17
Inox 2209B*	E 2209-15
Inox 2509MoB*	E 25 9 4 N LB 4 2
Inox 385	E 385-16
Inox 383*	E 383-16
Inox 410B	E 410-15
Inox 13/4	E 410 NiMo-15
Inox 17/4Mo	Z 16 5 1 B 4 2
Inox 316L	E 316L-17

cast-iron welding electrodes

Type	Norm
Fonte-Ni	E Ni-Cl
Fonte-Ni2	E Ni-Cl
Fonte-Ni3	E Ni-Cl
Ferro-Ni	E NiFe-Cl
Bimetal NiFe	E NiFe-Cl
Fe - Ni/Cu	E NiFe-Cl
Fonte NiFe-2	E NiFe-Cl
Fonte-Fe	E St
Fonte Fe-2*	E St
Fonte Fe-3*	ECl-B

nickel base electrodes

Type	Norm
B 90	E NiCrFe-3
B 91	E NiCrMo-3
B 94	E NiCrFe-2
B 96*	E NiCrMo-6
Ni 82*	E NiCrFe-3
Ni 182	E NiCrFe-3
Ni 190	E NiCu-7
Ni 276	E NiCrMo-4
Ni 617*	E NiCrCoMo-1
Ni 625	E NiCrMo-3
Ni-A*	E NiCrFe-2
Ni-C*	E NiCrMo-5
Ni Ti 3	E Ni-1

non ferrous electrodes

Type	Norm
Al 105	E 4043
Al 112*	E 4047
Cu 110*	E Cu
Cu 114	E CuSn-A
Cu 115	E CuSn-C
Cu 116	E Cu Al-A2
Cu 118	E CuMnNiAl
Cu Ni 30*	E CuNi

hardfacing electrodes

Type	Norm
HB 25	E 1-UM-250
HB300B	E 1-UM-300-P
HB40	E 1-UM-400
HB60	E 2-UM-60
HB 40HT	E 3-UM-40-PT
HB 48HT	E 3-UM-50-T
HB 56HT	E 3-UM-55-ST
HB 450HT	E 3-UM-45-T
HB 600HT	E 3-UM-60-ST
HBC 62	E 4-UM-60-ST
HB 61B	E 6-UM-60-S
HB 61R	E 6-UM-60-S
HMn	E 7-UM-250-KP
HB MnCr	E 7-UM-250-KPR
HB 14 Mn*	E 7-UM-250-KP
HB 63	E 10-UM-60-GRPZ
HBA	E 10-60-GRZ
HB 64S	E 10-UM-60-GR
HB 65	E 10-UM-65-G
HB 66	E 10-UM-65-G
Co 1	E CoCr-C
Co 6	E CoCr-A
Co 12	E CoCr-B
Co 21S	E 20-UM-350-CKTZ
Co 25	E 20-UM-250-CKTZ
B 92	E NiCrMo-5
B 92Co	E 23-UM-250-CKNTZ
HRT 60	(Tubular)
HRT 60 WC	E 21-UM-65-G
HRT 63	(Tubular)
HRT 68	(Tubular)

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