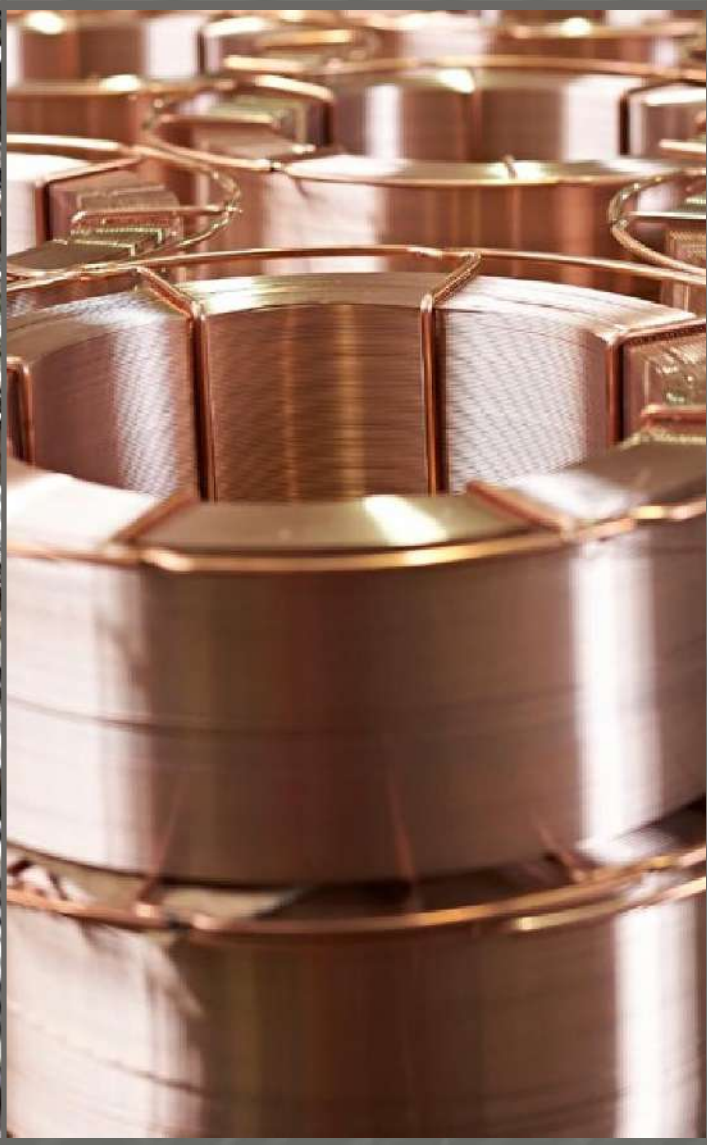
ADDA
SOURCING INNOVATION

# sij | elektrode

## *Product Guide*





**Products are certificate and tested according to the EN norms and we hold the most important international certificates such as TUV, DB, GL, BV, LR, ABS, DNV, RINA, RS and others.**

# ELECTRODES - Welding (MMA)

## *BASIC ELECTRODES*

The basic electrodes are used for welding critical structures made of carbon and low-alloy steels, also operating at low temperatures. These electrodes are characterized by high mechanical properties of the weld metal.

### EVB S

**TYPE OF ELECTRODE**
BASIC, DOUBLE COATED

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 711443001 | 2 | 300 | EVB S ELECTRODE | 3,4 |
| 712444001 | 2.5 | 350 | EVB S ELECTRODE | 4,0 |
| 714444001 | 3.25 | 350 | EVB S ELECTRODE | 4,0 |
| 715445001 | 4 | 450 | EVB S ELECTRODE | 5,0 |

Doublecoated, basic CTOD-tested electrode with excellent welding properties in difficult positions. It has stable welding arc. Very suitable for welding root-runs with DC and AC current.

### EVB 50

**TENSILE STRENGTH**
530 N/mm2
**SUITABLE FOR STEELS UP TO:**
610 N/mm2

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 712474001 | 2.5 | 350 | EVB 50 ELECTRODE | 4,0 |
| 711473001 | 2 | 300 | EVB 50 ELECTRODE | 3,4 |
| 714474001 | 3.25 | 350 | EVB 50 ELECTRODE | 4,0 |
| 715475001 | 4 | 450 | EVB 50 ELECTRODE | 5,4 |

Basic, CTOD tested electrode with excellent welding characteristics, recommended for welding structural steels and steel castings with tensile strength up to 610 N/mm2 and fine-grained steels with increased yield strength. Metal recovery is about 118 %. Deposits have very low hydrogen contents (HD < 4 ml/100 g).

### EVB MO

**SUITABLE FOR STEELS UP TO:**
540 - 640 N/mm2

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 712814001 | 2.5 | 350 | EVB MO ELECTRODE | 4,0 |
| 714814001 | 3.25 | 350 | EVB MO ELECTRODE | 4,0 |
| 715815001 | 4 | 450 | EVB MO ELECTRODE | 5,4 |

Mo alloyed basic electrode for welding creep resistant steels with yield strength up to 460°C. Suited for working temperatures for –40°C to 525°C.

### EVB 47

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 712453001 | 2.5 | 300 | EVB 47 ELEKTRODA | 3,4 |

Basic electrode with lower tensile strength and increased yield strength, therefore suitable for welding rigid constructions.

## HARDFACING ELECTRODESES

Hardfacing electrodes produce hard deposit resistant to abrasive impact. These electrodes are recommended to use in the welding of the parts which work in abrasive conditions.

### ABRADUR 58

**PURPOSE**
HARDFACING/
NAVARJANJE
**TYPE OF ELECTRODE**
RUTIL/ RUTILNA
ELEKTRODA

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 804874001 | 3.25 | 350 | ABRADUR 58 ELECTRODE | 4,0 |
| 805875001 | 4 | 450 | ABRADUR 58 ELECTRODE | 5,0 |
| 806875001 | 5 | 450 | ABRADUR 58 ELECTRODE | 5,0 |

Electrode produces hard deposits extremely resistant to abrasive and moderate impact.

It is suitable for hardfacing crushing and earthmoving equipment, soft ore crushers, conveyor screws, bucket teeth and lips. Welding of buffer layers with Inox B 18/8/6 or Mn17Cr13 electrodes is recommended. The weld metal can be treated with grinding.

### CRWC 600

**TYPE OF ELECTRODE**
BASIC/ BAZIČNA
ELEKTRODA
**PURPOSE**
HARDFACING/
NAVARJANJE

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 804644001 | 3.25 | 350 | CRWC 600 | 4,0 |
| 805645001 | 4 | 450 | CRWC 600 | 5,2 |
| 806645001 | 5 | 450 | CRWC ELECTRODE | 5,2 |

Electrode produces extremely hard deposits resistant to abrasive wear against the minerals and other materials. Weld metal is not recommended to shock-loadings. Welding of buffer layers with INOX B 18/8/6 and combination welding with E DUR 600 is recommended.It is suitable to weld string beads on earth moving, cement mill and brick making equipment.

### E-DUR 600

**PURPOSE**
BASIC ELECTRODE
FOR HARDFACING/
NAVARJANJE

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 804604001 | 3.25 | 350 | E-DUR 600 | 4,0 |
| 805605001 | 4 | 450 | E-DUR 600 | 5,4 |
| 806605001 | 5 | 450 | E-DUR 600 | 5,4 |

Electrode is used for surfacing of steel parts when heavy impact resistance is needed. Welding material enables higher abrasion resistance. Suitable for surfacing parts exposed to heavy abrasive wear by stone, coal, sand etc… The weld metal can be treated with grinding and cut after soft annealing.

### E-DUR 400

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 804584001 | 3.25 | 350 | E-DUR 400 ELEKTRODA | 4,0 |

Basic, Cr-Mn flux-alloyed electrode for surfacing applications. It gives wear and heavy impact resistant, weld metal, suitable for machine parts exposed to wear, machines for structural engineering, cog wheels, chain wheels, tracks etc...

# STAINLESS STEEL ELECTRODES

Stainless electrodes are used for welding high-alloy steels with various chemical compositions, used in various fields of the chemical industry.

**INOX R 19/9 NC HOBY**

**TYPE OF ELECTRODE**
E 308L-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752103009 | 2.5 | 300 | INOX R 19/9 NC HOBY | 0,8 |
| 754104009 | 3.25 | 350 | INOX R 19/9 NC HOBY | 0,8 |
| 755104009 | 4 | 350 | INOX R 19/9 NC HOBY | 0,8 |

Austenitic rutile, low carbon electrode for welding nonstabilised and stabilised stainless steels. Resistant to intergranular corrosion up to 350°C, resistant to oxidation up to 800°C and good low-temperature ductility down to temperature –196°C.

**INOX R 19/9 NC**

**TYPE OF ELECTRODE**
E 308L-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752103001 | 2.5 | 300 | INOX R 19/9 NC | 3,8 |
| 754104001 | 3.25 | 350 | INOX R 19/9 NC | 4,5 |
| 755104001 | 4 | 350 | INOX R 19/9 NC | 4,5 |

Austenitic rutile, low carbon electrode for welding nonstabilised and stabilised stainless steels. Resistant to intergranular corrosion up to 350°C, resistant to oxidation up to 800°C and good low-temperature ductility down to temperature –196°C.down to temperature –196°C.

**INOX R 19/9 NC**

**TYPE OF ELECTRODE**
E 308L-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752443001 | 2.5 | 300 | INOX R 18/8/6 | 3,8 |
| 754444001 | 3.25 | 350 | INOX R 18/8/6 | 4,5 |

Austenitic rutile- basic, electrode for joining dissimilar steels, for welding corrosion resistant steels and steels that are not readily weldable. This electrode yields tough between-layers in hard - surfacing operations. The weld metal has strain harden-ability, cracking resistance, cavitation resistance, thermal shock resistance, scaling resistance up to 800°C and low temperature toughness down to -100°C.

**INOX R 29/9 HOBY**

**TYPE OF ELECTRODE**
E 312-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752463009 | 2.5 | 300 | INOX R 29/9 ELECTRODE HOBY | 0,8 |
| 754464009 | 3.25 | 350 | INOX R 29/9 ELECTRODE HOBY | 0,8 |

Rutile, austenitic ferritic electrode for welding dissimilar and »difficult to weld« steels. Suitable for interpass hardfacing. Because of high mechanical strength and starain hardenability suitable for wear resistant buildups on gear wheels, shafts,… The weld metals has excellent cavitation and cracking resistance.

**INOX B 18/8/6**

**TYPE OF ELECTRODE**
E 307-15

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752413001 | 2.5 | 300 | INOX B 18/8/6 | 4,0 |
| 754414001 | 3.25 | 350 | INOX B 18/8/6 | 4,5 |

Basic coated, austenitic electrode for welding low and high alloyed steels. Scaling resistant up to 800°C and low-temperature toughness down to -100°C. Preheating and postweld heat treatment as required by the base metal.

**INOX R 19/12/3 NB**

**TYPE OF ELECTRODE**
E 318-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752183001 | 2.5 | 300 | INOX R 19/12/3 NB | 4,0 |
| 754184001 | 3.25 | 350 | INOX R 19/12/3 NB | 4,5 |

Austenitc rutile, Nb-stabilised electrode for welding nonstabilised and stabilised stainless steels. Resistant to intergranular corrosion up to 400°C, resistant to oxidation up to 800°C and good hot cracking resistance of the weld metal.

**INOX R 29/9**

**TYPE OF ELECTRODE**
E 312-17

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752463001 | 2.5 | 300 | INOX R 29/9 | 3,8 |
| 754464001 | 3.25 | 350 | INOX R 29/9 | 4,5 |
| 755464001 | 4 | 350 | INOX R 29/9 | 4,5 |

Rutile, austenitic ferritic electrode for welding dissimilar and »difficult to weld« steels. Suitable for interpass hardfacing. Because of high mechanical strength and starain hardenability suitable for wear resistant buildups on gear wheels, shafts,… The weld metals has excellent cavitation and cracking resistance.

**INOX R 22/12/3 FE**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752393001 | 2.5 | 300 | INOX R 22/12/3 FE | 3,5 |

Austenitic-ferritic rutile flux-alloyed electrode for joint welding corrosion and heat resistant steels and steel casting. Suitable for joining dissimilar steels, also as a buffer layer on stainless clads on unalloyed steels.

# CAST IRON ELECTRODES

Special electrodes are used for welding specialised for welding cast iron

## SUPER NI HOBY

**TYPE OF ELECTRODE**
E NI-CI

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752723009 | 2.5 | 300 | SUPER NI HOBY | 0,8 |
| 754724009 | 3.25 | 350 | SUPER NI HOBY | 0,8 |

Electrode with pure Ni-core wire for cold welding of grey and malleable cast iron also suitable for joining them with steel. Suitable for repair purposes, repair of broken parts, building up missing parts and correction of machining errors, joining cast iron for rectification of castings. The weld material is soft and easy machinable we suggest cold impact forging to achieve stress relieving. It is recommended to keep heat input as low as possible. Ground material should be clean. For grooving we suggest our electrode Sekator 2 B. Grinding is not recommended.

## SUPER NI

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752723001 | 2.5 | 300 | SUPER NI | 5,0 |
| 754724001 | 3.25 | 350 | SUPER NI | 6,0 |

Electrode with pure Ni-core wire for cold welding of grey and malleable cast iron also suitable for joining them with steel. Suitable for repair purposes, repair of broken parts, building up missing parts and correction of machining errors, joining cast iron for rectification of castings. The weld material is soft and easy machinable we suggest cold impact forging to achieve stress relieving. It is recommended to keep heat input as low as possible. Ground material should be clean. For grooving we suggest our electrode Sekator 2 B. Grinding is not recommended.

## CAST NIFE C

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 754694001 | 3,25 | 350 | CAST NIFE C ELEKTRODA | 5,0 |

Sheathed electrode made of Ni-Fe wire. It is used for cold welding of ductile, gray and malleable cast iron and welding of these with steel. The most comparable is to repair defects on machines. The weld has higher strength than welds made with Cast Ni or Super Ni electrodes. When welding, it is necessary to pay attention to the lowest possible heat input and the cleanliness of the base material. Cold forging after welding reduces the residual stresses created during welding.

## CAST FOR ALU AND CU METALS

Special electrodes are used for welding specialised for welding cast iron

**ALU MN**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 752934001 | 2.5 | 350 | ALU MN ELEKTRODA | 2,0 |

Electrode recommended for welding aluminium-manganese and aluminium magnesium alloys. Suitable for welding vehicle, container, storage vessel, apparatures construction and seawater resistant welds in the shipbuilding industry.

## RUTILE ELECTRODES

Rutile electrodes are used for welding carbon steels, used in the field of assembly and repair work. They are characterized by stable arc and excellent slag removal.

**RUTILEN 1000S**

**USAGE**
REPARATURE

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 781113001 | 2 | 300 | RUTILEN 1000 S | 4,0 |
| 782114001 | 2.5 | 350 | RUTILEN 1000 S | 4,4 |
| 784114001 | 3.25 | 350 | RUTILEN 1000 S | 4,4 |
| 785115001 | 4 | 450 | RUTILEN 1000 S | 5,4 |

Thick coated rutile-cellulose type electrode for welding low alloyed steels. Suitable for welding constructions, in maintenance and for repairing purposes.

**ELEKTRODE II. KLASA**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 714754001 | | | ELEKTRODE NAVADNE II. KLASA | 4,0 |

Common electrodes class 2

**RUTILEN 13**

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)

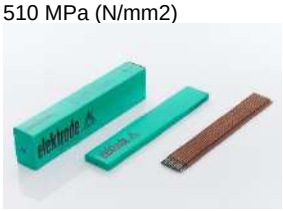
*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 782154001 | 2.5 | 350 | RUTILEN 13 ELECTRODE | 4,4 |
| 784154001 | 3.25 | 350 | RUTILEN 13 ELECTRODE | 4,0 |
| 785155001 | 4 | 450 | RUTILEN 13 ELECTRODE | 5,4 |

Thick rutile coated electrode for welding low alloyed steels. It has excellent welding characteristic, easy to use.

## JADRAN S

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)



*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 781073001 | 2 | 300 | JADRAN S ELECTRODE | 4,0 |
| 782074001 | 2.5 | 350 | JADRAN S ELECTRODE | 4,8 |
| 784074001 | 3.25 | 350 | JADRAN S ELECTRODE | 5,0 |
| 785074001 | 4 | 350 | JADRAN S ELECTRODE | 5,0 |

Multi-purpose electrode, easy to use, for welding light and medium fabrications of steels with tensile strength up to 510 N/mm2. Suitable also for vertical-down welding.

## SEKATOR

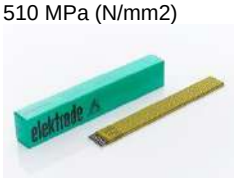
*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 784235001 | 3.25 | 450 | SEKATOR 1 | 6,0 |
| 785235001 | 4 | 450 | SEKATOR 1 | 6,0 |
| 786235001 | 5 | 450 | SEKATOR 1 | 6,0 |

Flux coated electrode for cutting of all types of steels, cast iron, iron, copper and its alloys. WARNING: In small welding rooms the ventilation of air is requested!

## RUTILEN 2000S

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)



*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 781213001 | 2 | 300 | RUTILEN 2000 S YELLOW | 4,0 |
| 782214001 | 2.5 | 350 | RUTILEN 2000 S YELLOW | 4,4 |
| 784214001 | 3.25 | 350 | RUTILEN 2000 S YELLOW | 4,4 |
| 785215001 | 4 | 450 | RUTILEN 2000 S YELLOW | 5,4 |

Thick rutile coated electrode for welding low alloyed steels up to 510 N/mm2. It has excellent welding characteristic.

## JADRAN S HOBY

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 781073009 | 3.25 | 450 | JADRAN S ELECTRDE HOBY | 0,8 |
| 782074009 | 4 | 450 | JADRAN S ELECTRDE HOBY | 0,8 |
| 784074009 | 5 | 450 | JADRAN S ELECTRDE HOBY | 0,8 |

Multi-purpose electrode, easy to use, for welding light and medium fabrications of steels with tensile strength up to 510 N/mm2. Suitable also for vertical-down welding.

**RUTILEN 13 HOBY**

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 782154009 | 2.5 | 350 | RUTILEN 13 ELECTRODE HOBY | 0,8 kg |

Thick rutile coated electrode for welding low alloyed steels. It has excellent welding characteristic, easy to use.

**RUTILEN 13 HOBY**

**SUITABLE FOR STEELS UP TO:**
510 MPa (N/mm2)

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 782154009 | 2.5 | 350 | RUTILEN 13 ELECTRODE HOBY | 0,8 kg |

Thick rutile coated electrode for welding low alloyed steels. It has excellent welding characteristic, easy to use.

**RUTILEN E**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 782574001 | 2.5 | 350 | RUTILEN E ELEKTRODA | 4,4kg |

Thin coated rutile-cellulosic electrode for welding low alloyed steels. Rutilen E is easy operating all position electrode including vertical down. Suitable for welding constructions, in maintenance and repair purposes.

**RUTILEN 12**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 782104001 | 2.5 | 350 | RUTILEN 12 ELEKTRODA | 5,0kg |

Celulosic-rutile type electrode used in maintenance and for repairing purposes of mild steel. In smaller dimensions can be used also for vertical-down welding.

# WELDING WIRES FOR MIG, MAG TIG WELDING

**TIG VAC 60**

**SUITABLE FOR STEELS UP TO:**
530 N/MM2

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 996201083 | 2,0 | 1000 | TIG VAC 60 2,0 X 1000 MM 25 R | 25,0 |
| 996251083 | 2,5 | 1000 | TIG VAC 60 2,0 X 1000 MM 25 R | 25,0 |
| 996301083 | 3,0 | 1000 | TIG VAC 60 2,0 X 1000 MM 25 R | 25,0 |

Solid copper coated, CTOD tested welding wire for welding in gas shielding atmospheres. Suitable for welding unalloyed steels with tensile straight below 530 N/mm$^2$ like boiler plate, fine-grained steels, pipe steels, shipbuilding steels and cast steels.

**VAC 65**

**SUITABLE FOR STEELS UP TO:**
640 N/MM2
**TYPE OF WIRE**
SG3

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 913081050 | 0.8 | WIRE VAC 65 0.8 MM SG3 | 15,0 |
| 913101050 | 1.0 | WIRE VAC 65 1.0 MM | 15,0 |
| 913121050 | 1,2 | WIRE VAC 65 1,2 BS300 SG3 | 15,0 |

Solid copper coated, CTOD tested wire for welding in gas shielding atmospheres. Slightly higher silicon and manganese alloyed than VAC 60. The higher contains of silicon and manganese increase the yield stress and tensile strength of weld metal (compared with VAC 60). The high silicon content promotes a low sensitivity to surface impurities and contributes to smooth weld. Suitable for welding unalloyed and low alloyed construction steels with tensile straight below 640 N/mm$^2$ like boiler plate, fine-grained steels, pipe steels, shipbuilding steels and cast steels.

**VAC 60**

**SUITABLE FOR STEELS UP TO:**
530 N/MM2
**TYPE OF WIRE**
SG2

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 912081030 | 0.8 | WIRE VAC 60 | 5,0 |
| 912081050 | 0,8 | WIRE VAC 60 BS 300 LTL | 15,0 |
| 912101030 | 1,0 | WIRE VAC 60 1,0 MM | 5,0 |
| 912101050 | 1,0 | WIRE VAC 60 1,0 MM | 15,0 |
| 912121030 | 0,8 | WIRE VAC 60 0,8 MM SG2 | 5,0 |
| 912121050 | 1,2 | WIRE VAC 60 1,2 MM 15KG | 15,0 |

Copper welding wire or rod for MAG / TIG welding. It is suitable for welding non-alloy steels and low-alloy steels with strengths up to 530 N / mm2. It is used for welding boiler sheets, pipes, shipbuilding steels, microalloyed steels and steel castings. VAC 60 was tested by the CTOD method.

**MIG 19/12/3 NC SI**

**TYPE OF WIRE**
ER 318 SI

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 93612482 | 1.2 | WIRE MIG 316 LSI (19/12/3 NCSI) | 15,0 |
| 936104082 | 1.0 | WIRE MIG 316 LSI (19/12/3 NCSI) | 15,0 |

Stabilized austenitic wire for metal gas welding of stabilized 18/8 CrNi steels, corrosion resistant. It's used for welding of devices, vessels and parts in chemical, pharmacy, cellulose and nuclear industry up to working temperature of 400°C. Welded material has oxidation resistance up to 800°C.

**TIG 18/8/6**

**TYPE OF WIRE**
ER 307

*More technical details available on request

| SKU | Diameter (mm) | Length | Name | Weight (kg) |
|---|---|---|---|---|
| 73255701 | 2.0 | 1000 | WIRE TIG 307 SI(18/8/6 SI) | 5,0 |
| 733557001 | 2.4 | 1000 | WIRE TIG 307 SI(18/8/6 SI) | 5,0 |
| 734557001 | 3.2 | 1000 | WIRE TIG 307 SI(18/8/6 SI) | 5,0 |

Solid wires for welding dissimilar steels, armour plate, austenitic manganese steels and generally difficult to weld steels. Buttering before hardsurfacing. The weld metal remains austenitic and tough also in diluted condition. The tough weld metal is able to absorb high welding stresses, which is important particularly when welding rigid structures. Good mechanical properties, excellent ductility.

**TIG MO**

**SUITABLE FOR STEELS UP TO:**
590 N/MM2

*More technical details available on request

| SKU | Diameter (mm) | Length | Name | Weight (kg) |
|---|---|---|---|---|
| 995201083 | 2.0 | 1000 | TIG MO | 25,0 |
| 995251083 | 2,5 | 1000 | TIG MO | 25,0 |
| 995301083 | 3,0 | 1000 | TIG MO | 25,0 |

With Mo-alloyed rod and wire for welding of heat-resistant, unalloyed and low-alloyed structural steels with tensile strenght up to 590 N/mm$^2$. It's well used for welding pipe-lines, high-pressure boilers, armour parts and for repairing in thermo-energetic devices. It can be used up to process-temperature of 500°C.

**TIG 19/12/3 NC SI**

**TYPE OF WIRE**
ER 316 L SI

*More technical details available on request

| SKU | Diameter (mm) | Length | Name | Weight (kg) |
|---|---|---|---|---|
| 73457701 | 3.2 | 1000 | WIRE TIG 316 LSI (19/12/3 NCSI) | 5,0 |
| 732577001 | 2.0 | 1000 | WIRE TIG 316 LSI (19/12/3 NCSI) | 5,0 |
| 733577001 | 2.4 | 1000 | WIRE TIG 316 LSI (19/12/3 NCSI) | 5,0 |

Austenitic wire for metal inert gas welding. It is suitable for welding corrosion resistant 18/8 CrNi steels for devices, vessels and parts in chemical, pharmacy and cellulose industry for temperature up to 350°C. Welded material has oxidation resistance up to 800°C and ductility to - 196°C.

**TIG 19/9 NC SI**

**TYPE OF WIRE**
ER 308 L SI

*More technical details available on request

| SKU | Diameter (mm) | Length | Name | Weight (kg) |
|---|---|---|---|---|
| 73231701 | 2.0 | 1000 | WIRE TIG 308 LSI (19/9 NCSI) | 5,0 |
| 73331701 | 2.4 | 1000 | WIRE TIG 308 LSI (19/9 NCSI) | 5,0 |
| 73431701 | 3.2 | 1000 | WIRE TIG 308 LSI (19/9 NCSI) | 5,0 |

Stabilized austenitic wire for metal gas welding of stabilized 18/8 CrNi steels, corrosion resistant. It's used for welding of devices, vessels and parts in chemical, pharmacy, cellulose and nuclear industry up to working temperature of 400°C. Welded material has oxidation resistance up to 800°C.

**MIG 19/9 NC SI**

**TYPE OF WIRE**
ER 308 L SI

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 93212482 | 1.2 | WIRE MIG 308 LSI (19/9 NCSI) | 15,0 |
| 932104082 | 1.0 | WIRE MIG 308 LSI (19/9 NCSI) | 15,0 |

Stabilized austenitic wire for metal gas welding of stabilized 18/8 CrNi steels, corrosion resistant. It's used for welding of devices, vessels and parts in chemical, pharmacy, cellulose and nuclear industry up to working temperature of 400°C. Welded material has oxidation resistance up to 800°C.

**MIG 75**

**SUITABLE FOR STEELS UP TO:**
690 N/MM2
**TYPE OF WIRE**
ER 100 S-1

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 917101050 | 1,0 | WIRE MIG 75 | 15,0 |
| 917121050 | 1,2 | WIRE MIG 75 | 15,0 |

Mn, Ni and Mo alloyed metal inert gas, CTOD tested wire, is suitable for welding fine - grained steels with high tensile straight and Rp up to 690 $N/mm^2$, like steels St E 550 V W. Nr. 1.8926 and St E 690 V W. Nr. 1.8928. Suitable shielding gas is mixture Ar and $CO_2$.

**MIG 18/86**

**TYPE OF WIRE**
ER 307

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 93110482 | 1,0 | WIRE MIG 307 SI (18/8/6 SI) | 15,0 |
| 93112482 | 1,2 | WIRE MIG 307 SI (18/8/6 SI) | 15,0 |

Solid wires for welding dissimilar steels, armour plate, austenitic manganese steels and generally difficult to weld steels. Buttering before hardsurfacing. The weld metal remains austenitic and tough also in diluted condition. The tough weld metal is able to absorb high welding stresses, which is important particularly when welding rigid structures. Good mechanical properties, excellent ductility.

**TIG VAC 65**

*More technical details available on request

| SKU | Diameter (mm) | Length | Name | Weight (kg) |
|---|---|---|---|---|
| 997251083 | 2,5 | 1000 | TIG VAC 65 25 R | 15,0 |

# WELDING RODS FOR OXYACETILENE WELDING

**VP 37**

**TENSILE STRENGTH**
340 N/MM2

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 991201083 | 2,0 | 1000 | VP 37 25R | 25,0 |
| 991251083 | 2,5 | 1000 | VP 37 25R | 25,0 |
| 991301083 | 3,0 | 1000 | VP 37 25R | 25,0 |
| 991401083 | 4,0 | 1000 | VP 37 25R | 25,0 |
| 991501083 | 5,0 | 1000 | VP 37 25R | 25,0 |

It's a copper-coated unalloyed rod for the gas welding of unalloyed steels with a minimum tensile strength of 40 MPa. It's suited in trade and industry for welding plates, pipes and other profiles for normal loading. Joints are homogenous and soft, the mechanical treatment is very good..

**VP 42**

*More technical details available on request

| SKU | Diameter (mm) | Length (mm) | Name | Weight (kg) |
|---|---|---|---|---|
| 991201083 | 2,0 | 1000 | VP 42 25R | 25,0 |
| 991251083 | 2,5 | 1000 | VP 42 25R | 25,0 |
| 991301083 | 3,0 | 1000 | VP 42 25R | 25,0 |

It's a copper-coated with Mn, Ni and Mo alloyed rod for gas welding of unalloyed general steels, pipe steels and boiler plates

# FLUX CORED WIRES (FCAW, MIG, MAG)

The wire is used for semi-automatic welding of steels in an atmosphere of shielding gases, the recommended combination of gases is M21. Compared to solid wire, they have better welding and technological properties. There are several main types:

- **Rutile flux** - cored wire. It is characterized by excellent weld seam appearance and slag removal.
- **Basic** - They are characterized by high mechanical properties of the weld metal.
- **Hardfacing** - The wire is used for surfacing the wear-resistant surface layer of parts operating in abrasive conditions.

| FILTUB DUR 212 | FILTUB DUR 16 |
|---|---|

# AGLOMERATED FLUXES FOR SUBMERGED WELDING

## *Welding fluxes and wires (SAW)*

This combination is used for automatic submerged arc welding of steels. Various combinations of wires and fluxes make them suitable for welding most types of steel. They are characterized by very high performance, which significantly reduces production costs.

**EPP2**

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 952251037 | 2,5 | WIRE EPP 2 K 435 | 25,0 |
| 952301037 | 3,0 | WIRE EPP 2 K 435 | 25,0 |
| 952401037 | 4,0 | WIRE EPP 2 K 435 | 25,0 |

Low alloyed, copper coated welding wires and high Cr and Ni alloyed welding wires for submerged arc welding. High alloyed strips for cladding.

**EPP3**

*More technical details available on request

| SKU | Diameter (mm) | Name | Weight (kg) |
|---|---|---|---|
| 953251037 | 2,5 | WIRE EPP 3 K 435 | 25,0 |
| 953301037 | 3,0 | WIRE EPP 3 K 435 | 25,0 |
| 953401037 | 4,0 | WIRE EPP 3 K 435 | 25,0 |

It's a copper-coated with Mn, Ni and Mo alloyed rod for gas welding of unalloyed general steels, pipe steels and boiler plates

## *AGLOMERATED WELDING FLUXES*

**ARD 1**

**GRAIN**
0,2-1,6MM
**SPECIFIC WEIGHT**
1,6KG/DM3

*More technical details available on request

| SKU | Name | Weight (kg) |
|---|---|---|
| 772200001 | FLUX ARD 1 | 25,0 |

It's an aluminate-rutil type flux for welding general structural steels, pressure vessel steels and pipe steels as

well as fine grain-steels with a yield strength of up to 355 N/mm$^2$. It's suited for twin-wire, tandem and multi-wire welding at high-speeds. It can be used also with the two-run technique, especially when welding thin-walled spiral tubes. Wires containing Mo increase the weld-metal toughness. It may equally well be used for welding tube-web-tube joints or finned tubes. Because of its good slag removal, it's very commonly used when welding fillets. The weld metal isn't susceptible to porosity when welding on surface contaminated by rust, scale… Grain size: 0.2 – 1.6 mm, Density: 1.6 kg/dm$^3$

**AB 123**

**GRAIN**
0,2-1,6MM
**SPECIFIC WEIGHT**
1,3 KG/DM3

*More technical details available on request

| SKU | Name | Weight (kg) |
|---|---|---|
| 773500001 | FLUX AB 123 | 25,0 |

It's an aluminate-basic type flux for welding general structural steels, pressure vessel steels, pipe steels as well as fine-grain steels. It can be used for single-wire and multi-wire welding as well as when welding with the two-run technique. The slag removes easily. rain size: 0.2 – 1,8 mm Density: 1.3 kg/dm$^3$

**ADDA**
**info@adda.si**
**www.adda.si**