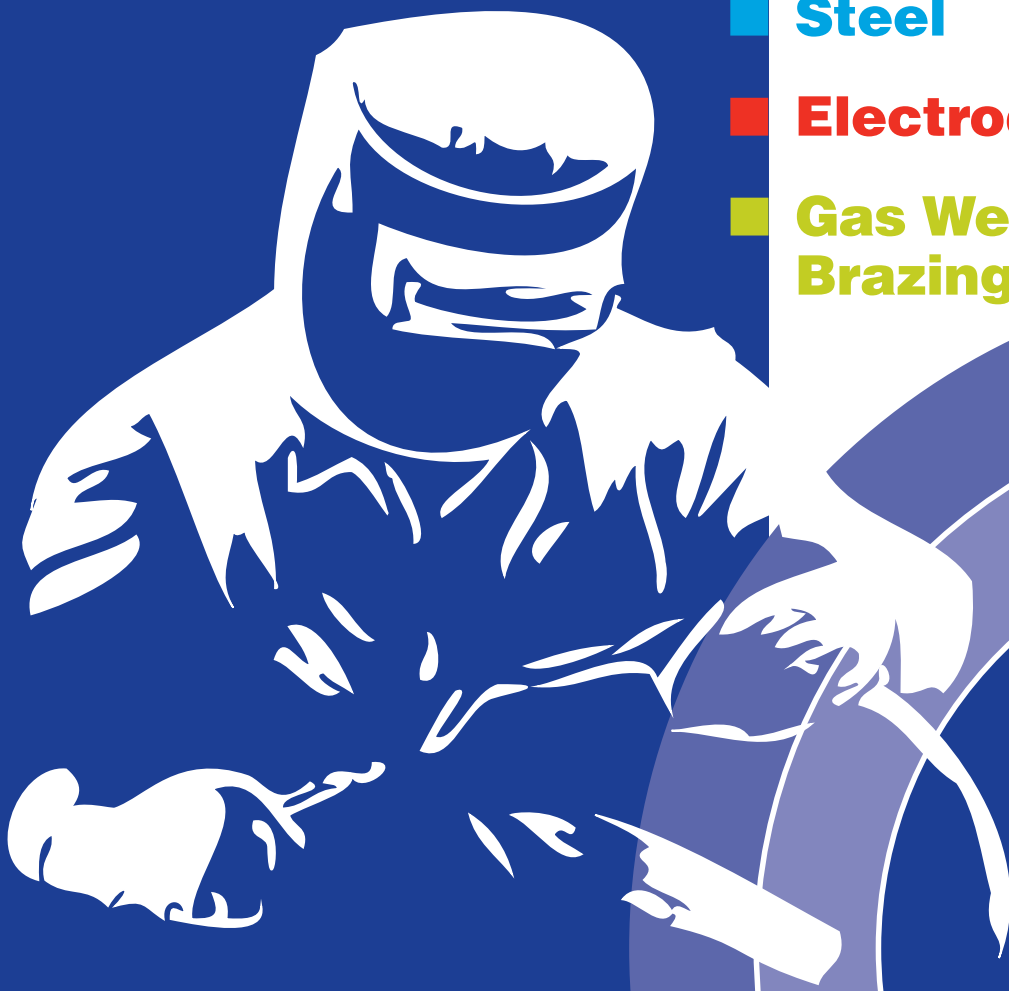


The *Super* 6

- Aluminium
- Copper
- Stainless Steel
- Steel
- Electrodes
- Gas Welding & Brazing



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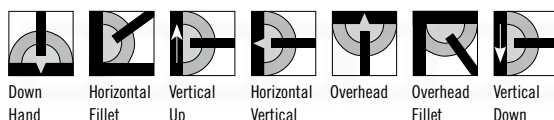
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Super6 1050

Features and Applications

- Pure Aluminium wire (99.5%min) producing a ductile weld which can be stretched, drawn or hammered without fracture
- Ideal for use in chemical, electronics and food industries

Standards

AWS : A5.10 ER 1100
EN ISO 18273-S AL1070 (AL 99.7)
BS: 2901 1050A (G1B)

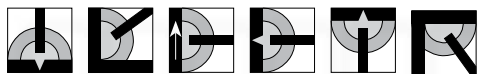
Mechanical Properties

Melting Point °C	650
UTS N/mm ²	90
Hardness BHN	15

Chemical Composition

Al	Fe	Cu
99.5	0.40	0.10

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

6.0kg Spool

Diameter	Part No.
0.8mm	7000
1.0mm	7001
1.2mm	7002
1.6mm	7003

Super6 4043

Features and Applications

- Aluminium alloy containing 5% silicon, for welding duraluminium, cast and wrought alloys
NB: Weld will discolour if anodised
- General fabrication and construction, shipbuilding, automotive industry, repair and maintenance

Standards

AWS : A5.10 ER 4043
EN ISO 18273-S AL4043 (AL SI 5)
BS 2901 4043A, (NG21)

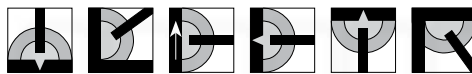
Mechanical Properties

Melting Point °C	630
UTS N/mm ²	120
Hardness BHN	45

Chemical Composition

Al	Si
95.0	5.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

0.5kg Spool

2.0kg Spool

6.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.8mm	7004	0.8mm	7008	0.8mm	7012
1.0mm	7005	1.0mm	7009	1.0mm	7013
1.2mm	7006	1.2mm	7010	1.2mm	7014
				1.6mm	7015



Super6 4047

Features and Applications

- Excellent corrosion resistance and a low melting point which allows thin Aluminium sheet to be successfully MIG welded
NB: Weld will discolour if anodised
- Automotive, ship building and offshore, repair and maintenance
- Aluminium alloy containing 12% Silicon

Standards

AWS : A5.10 ER 4047
EN ISO 18273 S AL 4047A (AL SI 12)
BS : 2901 4047A (NG2)

Mechanical Properties

Melting Point °C	580
UTS N/mm ²	130
Hardness BHN	50

Chemical Composition

Al	Si
88.0	12.0

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

6.0kg Spool

Diameter	Part No.
0.8mm	7018
1.0mm	7019
1.2mm	7020

Super6 5356

Features and Applications

- A general purpose Aluminium wire containing 5% magnesium, giving excellent corrosion resistance and high joint strength
- Shipbuilding and offshore, power generation, repair and maintenance and railway industry

Standards

AWS : A5.10 ER 5356
EN ISO 18273 S AL5356 (AL Mg 5)
BS : 2901 5356 (NG 6)

Mechanical Properties

Melting Point °C	635
UTS N/mm ²	250
Hardness BHN	65

Chemical Composition

Al	Mg
95.0	5.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

0.5kg Spool

2.0kg Spool

6.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.8mm	7023	0.8mm	7030	0.8mm	7034
1.0mm	7024	1.0mm	7031	1.0mm	7035
1.2mm	7025	1.2mm	7032	1.2mm	7036
				1.6mm	7037



Super6 5183

Features and Applications

- Special Aluminium alloy giving improved strength, used when high seawater corrosion resistance is required
- Shipbuilding and offshore, cryogenic plants, power generation and railway industry

Standards

AWS : A5.10 ER 5183
EN ISO 18273 S AL 5183 (AL Mg 4.5 Mn 0.7)
BS : 2901 5183

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	270
Hardness BHN	65

Chemical Composition

Al	Mg	Mn
94.0	5.00	0.75

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

6.0kg Spool

Diameter	Part No.
1.0mm	7040
1.2mm	7041

Super6 5556

Features and Applications

- Aluminium alloy containing 5.3% Magnesium, all elements are closely controlled for optimum weld strength
- Military industry, power generation, railway industry, shipbuilding and offshore

Standards

AWS : A5.10 ER 5556
EN ISO 18273 S AL 5556 (AL Mg5 Mn)
BS : 2901 5556

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	300
Hardness BHN	70

Chemical Composition

Al	Mg	Mn	Cr	Ti
93.0	5.30	0.80	0.10	0.01

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

6.0kg Spool

Diameter	Part No.
1.0mm	7042
1.2mm	7043
1.6mm	7044



Super6 1050

Features and Applications

- A pure Aluminium (99.5%) rod producing a ductile weld that can be stretched, drawn or hammered without fracture
- Chemical, food and electronics industries, repair and general maintenance

Standards

AWS : A5.10 ER 1100
EN ISO 18273-S AL 1070 (Al 99.7)
BS 2901 1050A (GIB)

Mechanical Properties

Melting Point °C	650
UTS N/mm ²	90
Hardness BHN	15

Chemical Composition

Al	Fe	Cu
99.5	0.40	0.10

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7047
2.4mm	7048
3.2mm	7049

Super6 4043

Features and Applications

- Aluminium alloy with 5% silicon gives excellent flow and penetration. Suitable for joining duraluminium, cast and wrought alloys. NB: Weld will discolour if anodised
- Ship building, automotive and food industries, repair and maintenance

Standards

AWS : A5.10 ER 4043
EN ISO 18273 S Al 4043A (Al Si 5)
BS 2901 4043A (NG 21)

Mechanical Properties

Melting Point °C	630
UTS N/mm ²	120
Hardness BHN	45

Chemical Composition

Al	Si
95.0	5.00

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7050
2.4mm	7051
3.2mm	7052



Super6 4047

Features and Applications

- Excellent corrosion resistance and low melting point
NB: Weld will discolour if anodised
- Melts at 80 °C lower than pure Aluminium, can be used as a gas brazing rod
- Automotive, shipbuilding, offshore, repair and maintenance

Standards

AWS : A5.10 ER 4047
EN ISO 18273 S AL 4047A (AL SI 12)
BS 2901 4047A (NG2)

Mechanical Properties

Melting Point °C	580
UTS N/mm ²	130
Hardness BHN	50

Chemical Composition

Al	Si
88.0	12.0

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7054
2.4mm	7055
3.2mm	7056

Super6 5356

Features and Applications

- A general purpose Aluminium rod containing 5% magnesium, giving excellent corrosion resistance and high joint strength
- Shipbuilding, offshore, power generation and railway industries, repair and maintenance

Standards

AWS : A5.10 ER 5356
EN ISO 18273 S AL 5356 (AL Mg 5)
BS 2901 5356 (NG6)

Mechanical Properties

Melting Point °C	635
UTS N/mm ²	250
Hardness BHN	65

Chemical Composition

Al	Mg
95.0	5.00

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7057
2.4mm	7058
3.2mm	7059



Super6 5183

Features and Applications

- Special Aluminium alloy giving improved strength
- Used when high seawater corrosion resistance is required
- Shipbuilding, offshore, power generation, cryogenic plants and railway industries

Standards

AWS : A5.10 ER 5183

EN ISO 18273 AL 5183 (AL Mg 4.5 Mn 0.7)

BS 2901 5183

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	300
Hardness BHN	65

Chemical Composition

Al	Mg	Mn
94.0	5.00	0.75

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7060
2.4mm	7061
3.2mm	7062

Super6 5556

Features and Applications

- Aluminium alloy containing 5.3% Magnesium
- All elements closely controlled for optimum weld strength
- Military industry, power generation, railway industry, shipbuilding and offshore.

Standards

AWS : A5.10 ER 5556

EN ISO 18273 S AL 5556A (Al Mg5 Mn)

BS 2901 5556

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	300
Hardness BHN	70

Chemical Composition

Al	Mg	Mn	Cr	Ti
93.0	5.30	0.80	0.10	0.01

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7063
2.4mm	7064
3.2mm	7065

Super6 AZ 61 A

Features and Applications

- Magnesium rod with 6% Aluminium
- Suitable for welding magnesium Aluminium alloy castings, crank cases, gear boxes, sumps, wheels etc.

Standards

Mechanical Properties

Melting Point °C	610
UTS N/mm ²	280

Chemical Composition

Mg	Al	Zn	Mn
93.0	6.00	0.60	0.30

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
3.0mm	7066



Super6 C11

Features and Applications

- A phosphor bronze wire containing 7% tin suitable for fusion welding, bronze castings, cast iron and copper alloys. Also recommended for brazing ferrous and dissimilar metal joints
- Ship building, process industry, repair and maintenance and artistic foundries

Standards

AWS : A5.7 ER Cu Sn – C
EN 24373 Cu5180 (Cu Sn 6P)
BS 2901 C11

Mechanical Properties

Melting Point °C	930
UTS N/mm ²	260
Hardness BHN	80

Chemical Composition

Cu	Sn
93.0	7.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

4.0kg Spool 12.5kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7103	0.8mm	7106
1.0mm	7104	1.0mm	7107
1.2mm	7105	1.2mm	7108

Super6 C28

Features and Applications

- Ideal for joining and repairing Aluminium bronze castings of similar composition and for depositing bearing and corrosion resistant surfaces, brazing ferrous and dissimilar joints
- Shipbuilding, automotive, chemical industries, repair and maintenance

Standards

AWS : A5.7 ER Cu AL – A1
EN 24373 Cu6100 (Cu Al 8)
BS 2901 C28

Mechanical Properties

Melting Point °C	1020
UTS N/mm ²	430
Hardness BHN	80

Chemical Composition

Cu	Al
92.0	8.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

4.0kg Spool 12.5kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7110	0.8mm	7113
1.0mm	7111	1.0mm	7114
1.2mm	7112	1.2mm	7115

Super6 C7

Features and Applications

- High quality wire containing a minimum of 98.5% copper with deoxidizing elements suitable for joining oxygen free copper and copper materials subject to high strain
- Copper boilers, brewing industry, power generation

Standards

AWS : A5.7 ER Cu
EN 24373 Cu1898 (Cu Sn1)
BS 2901 C7

Mechanical Properties

Melting Point °C	1050
UTS N/mm ²	220
Hardness BHN	70

Chemical Composition

Cu	Mn	Si
99.5	0.25	0.25

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

12.5kg Spool

Diameter	Part No.
0.8mm	7120
1.0mm	7121
1.2mm	7122

Super6 C9

Features and Applications

- Ideal for fusion welding materials of similar composition eg copper alloy (brass). Frequently used in artistic foundries where good colour match is required, also for MIG brazing zinc coated steel sheets in the automotive industry
- Automotive industry, artistic foundries, repair & maintenance

Standards

AWS : A5.7 ER Cu Si - A
EN 24373 Cu 6560 (Cu Si3 Mn1)
BS 2901 C9

Mechanical Properties

Melting Point °C	980
UTS N/mm ²	350
Hardness BHN	90

Chemical Composition

Cu	Mn	Si
96.0	1.00	3.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

4.0kg Spool 12.5kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7126	0.8mm	7129
1.0mm	7127	1.0mm	7130
1.2mm	7128	1.2mm	7131



Super6 CuNi 10

Features and Applications

- A copper nickel wire suitable for joining highly stressed corrosion-resistant material and for surfacing unalloyed and low alloyed steel. Also used for surfacing and joining cast iron
- Shipbuilding, pipelines, chemical industry
- Structural/general fabrication

Standards

EN ISO 24373 Cu7061 (CuNi10FE)

Mechanical Properties

Melting Point °C	1180
UTS N/mm ²	300
Hardness BHN	80

Chemical Composition

Ni	Fe	Cu
10.0	1.50	89

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

12.5kg Spool

Diameter	Part No.
0.8mm	7070
1.0mm	7071
1.2mm	7072

Super6 CuNi 30

Features and Applications

- A copper nickel wire suitable for joining highly stressed corrosion-resistant material and for surfacing unalloyed and low alloyed steel. Also used for surfacing and joining cast iron
- Shipbuilding, pipelines, chemical industry
- Structural/general fabrication

Standards

EN ISO 24373 Cu7061 (CuNi30FE)

Mechanical Properties

Melting Point °C	1180
UTS N/mm ²	300
Hardness BHN	80

Chemical Composition

Ni	Fe	Cu
30.0	1.50	69

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

12.5kg Spool

Diameter	Part No.
0.8mm	7075
1.0mm	7076
1.2mm	7077



Super6 C1

Features and Applications

- Easy flowing high quality copper rod for fusion welding of deoxidised copper components. The rod contains essential deoxidising elements in addition to a percentage of silver – giving a weld free from porosity and copper oxide inclusions
- Brewing, power generation and shipbuilding industries

Standards

AWS : RCu

EN 24373 Cu 1897 (Cu Ag1)

BS 1453 C1

Mechanical Properties

Melting Point °C	1050
UTS N/mm ²	200
Hardness BHN	75

Chemical Composition

Cu	Ag
99.0	1.00

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7135
2.4mm	7136
3.2mm	7137

Super6 C11

Features and Applications

- Phosphor bronze rod containing 7% tin, produced for fusion welding phosphor bronze castings where a good colour match is required and for building up worn bearing surfaces. Also ideal for TIG brazing and welding dissimilar joints
- Shipbuilding, processing industry, artistic foundries

Standards

AWS : A5.7 ER Cu Sn - c

EN 24373 Cu5180 (Cu Sn 6P)

BS 2901 C11

Mechanical Properties

Melting Point °C	930
UTS N/mm ²	260
Hardness BHN	80

Chemical Composition

Cu	Sn
93.0	7.00

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7140
2.4mm	7141
3.2mm	7142

Super6 C27

Features and Applications

- Phosphor bronze rod with 12% tin for improved colour match on brass and bronze. Low melting point makes this rod ideal for TIG brazing thin sheet on ferrous and dissimilar joints
- Artistic foundries, brewing, chemical and automotive industries, repair and maintenance

Standards

EN 24373 Cu 5410 (Cu Sn 12P)

BS 2901 C27

Mechanical Properties

Melting Point °C	850
UTS N/mm ²	320
Hardness BHN	120

Chemical Composition

Cu	Sn	P
87.8	12.0	0.20

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7144
2.4mm	7145

Super6 C13

Features and Applications

- Aluminium bronze rod for joining and repair welding of Aluminium bronze castings of similar composition and depositing bearing surfaces. Wear and corrosion resistant, also excellent for TIG brazing on ferrous and dissimilar metals
- Copper boilers, brewing and power generation industries

Standards

AWS : A5.7 ER Cu AL – A2

EN 24373 Cu 6180 (Cu Al 10 Fe)

BS 2901 C13

Mechanical Properties

Melting Point °C	1030
UTS N/mm ²	500
Hardness BHN	95

Chemical Composition

Cu	Al	Fe
89.0	10.0	1.00

Welding Positions



Current Type

AC

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7147
2.4mm	7148
3.2mm	7149



Super6 C9

Features and Applications

- Ideal for fusion welding materials of similar composition eg copper alloy (brass). Frequently used in artistic foundries where good colour match is required, also TIG brazing ferrous and dissimilar materials
- Artistic foundries, automotive industry, repair and maintenance

Standards

AWS : A5.7 ER Cu Si - A
EN 24373 Cu 6560 (Cu Si 3 Mn 1)
BS 2901 C9

Mechanical Properties

Melting Point °C	980
UTS N/mm ²	350
Hardness BHN	90

Chemical Composition

Cu	Si	Mn
96.0	3.00	1.00

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7154
2.4mm	7155
3.2mm	7156

Super6 C7

Features and Applications

- High quality rod containing a minimum of 98.5% copper with deoxidizing elements suitable for joining oxygen free copper and copper materials subject to high strain
- Copper boilers, brewing industry and power generation

Standards

AWS : A5.7 ER Cu
EN 24373 Cu 1898 (Cu Sn1)
BS 2901 C7

Mechanical Properties

Melting Point °C	1025
UTS N/mm ²	220
Hardness BHN	70

Chemical Composition

Cu	Mn	Si
99.5	0.25	0.25

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7158
2.4mm	7159
3.2mm	7160

Super6 CuNi 10

Features and Applications

- A copper nickel wire suitable for joining highly stressed corrosion-resistant material and for surfacing unalloyed and low alloyed steel. Also used for surfacing and joining cast iron
- Shipbuilding, pipelines, chemical industry
- Structural/general fabrication

Standards

EN ISO 24373 Cu7061 (CuNi10FE)

Mechanical Properties

Melting Point °C	1180
UTS N/mm ²	300
Hardness BHN	80

Chemical Composition

Ni	Fe	Cu
10.0	1.50	89

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7080
2.4mm	7081
3.2mm	7082

Super6 CuNi 30

Features and Applications

- A copper nickel wire suitable for joining highly stressed corrosion-resistant material and for surfacing unalloyed and low alloyed steel. Also used for surfacing and joining cast iron
- Shipbuilding, pipelines, chemical industry
- Structural/general fabrication

Standards

EN ISO 24373 Cu7061 (CuNi30FE)

Mechanical Properties

Melting Point °C	1180
UTS N/mm ²	300
Hardness BHN	80

Chemical Composition

Ni	Fe	Cu
30.0	1.50	69

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7085
2.4mm	7086
3.2mm	7087



Super6 347

Features and Applications

- Niobium stabilized stainless steel wire prevents weld decay and offers excellent corrosion resistance. Suitable for use on 18/8 type stainless steel and where the weld is subjected to temperatures above 400 °C
- Chemical, food and power generation industries

Standards

AWS : 5.9 ER 347

EN ISO 14343 : 19 9NbSi

BS 2901 347 S96

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr	Nb
0.04	0.80	1.5	10.0	20.0	0.60

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
0.8mm	7180
1.0mm	7181
1.2mm	7182

Super6 308 LSI

Features and Applications

- For welding 18/8 (304) austenitic stainless steels providing good corrosion and wear resistance
- Chemical, food and power generation industries

Standards

AWS : 5.9 ER 308 LSI

EN ISO 14343 : 19 9 LSI

BS 2901 308 S 93

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	640
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr
0.02	0.80	1.50	10.0	21.0

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

0.7kg Spool

5.0kg Spool

15.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.6mm	7183	0.6mm	7186	0.8mm	7190
0.8mm	7184	0.8mm	7187	1.0mm	7191
1.0mm	7185	1.0mm	7188	1.2mm	7192
		1.2mm	7189		



Super6 309 LSI

Features and Applications

- Stainless steel wire ideal for joining material of similar composition and also dissimilar stainless steel
- Chemical, power generation, repair and maintenance

Standards

AWS : 5.9 ER 309LSI
EN ISO 14343 : 23 12 LSI
BS 2901 309 S93

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr
0.10	0.40	1.50	13.0	26.0

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7193	0.8mm	7195
1.0mm	7194	1.0mm	7196
		1.2mm	7197

Super6 310

Features and Applications

- Chromium/Nickel welding wire for welding heat-resistant austenitic steels of the 25Cr/20Ni type
- Chemical industry, power generation

Standards

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

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	590
Hardness BHN	200

Chemical Composition

C	Mn	Ni	Cr
0.01	1.80	21.0	26.0

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
0.8mm	7175
1.0mm	7176
1.2mm	7177



Super6 312

Features and Applications

- A 29 – 9 stainless steel suitable for joining difficult to weld steels such as tool and spring steel. Also for dissimilar materials and has a high resistance to weld metal cracking
- Repairs to tool/spring/manganese/high speed and cast steels Recommended for repairs to dies and moulds

Standards

AWS : 5.9 ER 312
EN ISO 14343 : 29 9
BS 2901 312 S94

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	750
Hardness BHN	200

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.10	0.40	1.70	9.00	30.0	0.10

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.
0.8mm	7208	0.8mm	7210
1.0mm	7209	1.0mm	7211

Super6 316 LSI

Features and Applications

- A molybdenum bearing stainless steel with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steel
- Power generation, chemical, food industries

Standards

AWS : 5.9 ER 316 LSI
EN ISO 14343 : 19 12 3 LSI
BS 2901 316 S93

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.02	0.80	1.50	12.0	19.0	2.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

0.7kg Spool 5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.6mm	7198	0.6mm	7201	0.6mm*	7204
0.8mm	7199	0.8mm	7202	0.8mm	7205
1.0mm	7200	1.0mm	7203	1.0mm	7206
				1.2mm	7207

*Supplied on 12.5kg spool



Super6 347

Features and Applications

- Niobium stabilised stainless steel rod prevents weld decay and offers excellent corrosion resistance. Suitable for use on 18/8 type stainless steel and where the weld is subjected to temperatures above 400 °C
- Chemical, food and power generation industries

Standards

AWS : 5.9 ER 347
EN ISO 14343 : 19 9 Nb
BS 2901 347 S96

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr	Nb
0.04	0.40	1.50	10.0	20.0	0.60

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.2mm	7213
1.6mm	7214
2.4mm	7215

Super6 308 L

Features and Applications

- Suitable for joining 18/8 (304) austenitic stainless steels providing good corrosion and wear resistance
- Chemical, food and power generation industries

Standards

AWS : 5.9 308L
EN ISO 14343 :19 9L
BS 2901 308 S92

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	640
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr
0.02	0.40	1.50	10.0	21.0

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7216
2.4mm	7217
3.2mm	7218



Super6 309 L

Features and Applications

- Stainless steel rod containing higher amounts of chromium and nickel. Can be used for joining material of similar composition and dissimilar stainless steels
- Chemical, power generation, repair and maintenance

Standards

AWS : 5.9 ER 309 L

EN ISO 14343 – A W23 12L

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr
0.10	0.40	1.50	13.0	26.0

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7219
2.4mm	7220
3.2mm	7221

Super6 310

Features and Applications

- Chromium/Nickel welding wire for welding heat-resistant austenitic steels of the 25Cr/20Ni type
- Chemical industry, power generation

Standards

AWS : A5.9 ER 310

EN ISO 14343 : A 25 20

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	590
Hardness BHN	200

Chemical Composition

C	Mn	Ni	Cr
0.01	1.80	21.0	26.0

Welding Positions



Current Type

D–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7229
2.4mm	7230
3.2mm	7231



Super6 312

Features and Applications

- A 29-9 stainless steel rod suitable for joining difficult to weld steel such as tool, spring steel and dissimilar materials and has a high resistance to weld metal cracking
- Repairs to tool/spring/manganese/high speed and cast steels
Also recommended for repairs to dies and moulds

Standards

AWS : 5.9 ER 312
EN ISO 14343 : 29-9
BS 2901 312 S94

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	750
Hardness BHN	200

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.10	0.40	1.70	9.00	30.0	0.10

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7227
2.4mm	7228

Super6 316 L

Features and Applications

- A molybdenum bearing stainless steel rod with low carbon content. It is corrosion resistant for joining molybdenum bearing austenitic stainless steel
- Nuclear, chemical and food industries

Standards

AWS : 5.9 ER 316L
EN ISO 14343 : 19123L
BS 2901 316 S92

Mechanical Properties

Melting Point °C	1440
UTS N/mm ²	650
Hardness BHN	180

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.02	0.40	1.50	12.0	19.0	2.00

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.0mm	7222
1.2mm	7223
1.6mm	7224
2.4mm	7225
3.2mm	7226



STAINCORED 308 L

Features and Applications

- Cr Ni alloyed cored wire suited to MIG welding stabilised and unstabilised 19/9 Cr Ni steels. Excellent weldability and slag release, attractive weld appearance and little discolouration to reduce pickling costs
- Power generation, food industry, oil and gas industries

Standards

AWS : E 308LT 1 – 1 4
EN ISO 17633 T 19 9 LPC/M2

Mechanical Properties

Melting Point °C 1450
UTS N/mm² 550

Chemical Composition

C	Si	Cr	Ni	Mn
0.03	0.60	20.0	10.0	1.40

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.2mm	7232

STAINCORED 309 L

Features and Applications

- Alloyed cored wire for MIG welding corrosion and heat resistant Cr Ni steel and dissimilar steels. Excellent weldability and slag release with attractive weld appearance and little discolouration to reduce pickling costs
- Power generation, food, oil and gas industries

Standards

AWS : E 309LT 1 – 1 4
EN 17633 : T23 12 LR MI

Mechanical Properties

Melting Point °C 1450
UTS N/mm² 520-600

Chemical Composition

C	Si	Cr	Ni	Mn
0.03	0.70	23.0	12.8	1.30

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.2mm	7234

STAINCORED 316 L

Features and Applications

- Alloyed cored wire suited to MIG welding of stabilised and unstabilised corrosion resistant 19/12/3 Cr Ni Mo steel. Excellent weldability and slag release, attractive weld appearance and little discolouration to reduce pickling cost
- Power generation, oil and gas industry, food industry

Standards

AWS : E 316L T1 – 14
EN 17633 : T 19 12 3 LP 1 (C1)

Mechanical Properties

Melting Point °C 1450
UTS N/mm² 540-560

Chemical Composition

C	Si	Mn	Ni	Cr	Mo
0.03	0.70	1.30	12.5	19.5	2.60

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.2mm	7236





Super6 SG2

Features and Applications

- A copper coated mild steel MIG wire for welding mild and medium tensile steels
- General construction, shipbuilding and automotive industries

Standards

AWS : A5.18 ER70 S-6
BS : 2901 : A18
EN ISO 14341-A-G 42 4 C1/M21 3Si1
EN 10204 : 3.1

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	500
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.10	0.80	1.30

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

0.7kg Spool 5.0kg Spool 15.0kg Spool

Diameter	Part No.	Diameter	Part No.	Diameter	Part No.
0.6mm	7300	0.6mm	7303	0.6mm	7306
0.8mm	7301	0.8mm	7304	0.8mm	7307
1.0mm	7302	1.0mm	7305	1.0mm	7308
				1.2mm	7309
				1.6mm	7310

Super6 SG2 – SuperPAK

Features and Applications

- A copper coated mild steel MIG wire for welding mild and medium tensile steels
- General construction, shipbuilding and automotive industries

Standards

AWS : A5.18 ER70 S-6
BS : 2901 : A18
EN ISO 14341-A-G 42 4 C1/M21 3Si1
EN 10204 : 3.1

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	500
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.10	0.80	1.30

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

250kg Spool

Diameter	Part No.
0.8mm	7312
1.0mm	7313
1.2mm	7314



Super6 SG3

Features and Applications

- A copper coated steel Mig wire with increased silicon and manganese for improved UTS
- General fabrication, shipbuilding, power generation

Standards

AWS : A5.18 ER70 S – 6
EN ISO 636 – A W4 Si1
EN ISO 14341-A-G 46 4 M21/42 4 C1 4Si1
EN 10204 : 3.1

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	600
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.10	1.00	1.75

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
0.8mm	7320
1.0mm	7321
1.2mm	7322

Super6 A15

Features and Applications

- Triple deoxidised mild steel wire. Typical applications include vessels, pipelines root runs on multipass welds
- Shipbuilding, offshore, chemical and military industries

Standards

BS 2901 A15

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	440
Hardness BHN	120

Chemical Composition

C	Si	Mn	Al
0.10	0.60	1.30	0.20

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
0.8mm	7325
1.0mm	7326
1.2mm	7327



Super6 A32

Features and Applications

- A copper coated alloy steel wire containing 1.0% chromium and 0.5% molybdenum for welding low alloy and creep resistant steels
- Shipbuilding, offshore, chemical and power generation industries

Standards

BS 2901 A32

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	500
Hardness BHN	180

Chemical Composition

C	Si	Mn	Cr	Mo
0.10	0.60	1.00	1.30	0.50

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.0mm	7329
1.2mm	7330

METAL CORED E70 C-6M

Features and Applications

- A metal cored wire for welding mild and high tensile steels. Ideal for multi-run welds in all positions
- Shipbuilding, offshore and general fabrications

Standards

SFA/AWS : A5.18 E 70C-6M

EN ISO 17632-A-T42 4 MM 3 H5

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	550
Hardness BHN	105

Chemical Composition

C	Si	Mn	Po	S
0.05	0.63	1.58	0.02	0.01

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.2mm	7331



Super6 E71T-1

Features and Applications

- A rutile flux cored wire for welding structures fabricated in mild steel and low alloyed structural steel in all positions
- Shipbuilding, offshore and general fabrications

Standards

AWS : E 71 T-1

EN ISO 17632-A-T 42 4 R C/M 2 H10

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	510
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.05	0.60	1.30

Welding Positions



Current Type

DC+

Shielding Gas

Argon / CO₂ mix

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.2mm	7332

GASLESS FLUX CORED WIRE

Features and Applications

- Self shielding steel MIG wire. Ideal for DIY use
- Automotive repair, general repair and maintenance

Standards

AWS : E71T – GS

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	400
Hardness BHN	120

Chemical Composition

C	Si	Mn	Al
0.25	0.40	0.70	2.40

Welding Positions



Current Type

AC/DC+

Shielding Gas

None required

Manufacturer's Approvals

Approvals on request

Product Information

0.45kg Spool

1.0kg Spool

4.5kg Spool

Diameter	Part No.
0.8mm	7335
0.9mm	7336

Diameter	Part No.
0.8mm	7337

Diameter	Part No.
0.8mm	7338
0.9mm	7339



Super6 600 MC

Features and Applications

- A metal cored wire for high wear resistance, ideal for metal to metal wear impact and/or compression stresses
- Agricultural, earthmoving, quarries

Standards

Din 8555 : MSG 6 – 60

Mechanical Properties

Melting Point °C	1450
Hardness BHN	600

Chemical Composition

C	Si	Mn	Cr	Mo
0.50	0.60	1.50	5.00	0.06

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.6mm	7348

Super6 600S

Features and Applications

- Solid hard facing MIG wire for high wear resistance
- Agricultural, earth moving and stone crushing industries

Standards

Din 8555 : MSG 6 – GZ – 60

Mechanical Properties

Melting Point °C	1450
Hardness BHN	580/650

Chemical Composition

C	Si	Mn	Cr
0.45	3.00	0.40	9.00

Welding Positions



Current Type

DC+

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

15.0kg Spool

Diameter	Part No.
1.0mm	7345
1.2mm	7346

Super6 A15

Features and Applications

- A copper coated mild steel rod with a high level of deoxidants (triple deoxidised) to enable sound porosity free welds to be made on mild and low alloy steels
- General fabrication, power generation and chemical industries

Standards

AWS : ER 70S-2
EN 1668 W2 Ti
BS 2901 A15

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	440
Hardness BHN	120

Chemical Composition

C	Si	Mn	Al
0.10	0.60	1.30	0.20

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.0mm	7350
1.2mm	7351
1.6mm	7352
2.4mm	7353
3.2mm	7354

Super6 A17

Features and Applications

- A low carbon double deoxidised rod for TIG welding mild steel
- General fabrication and shipbuilding

Standards

BS 2901 A17

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	400
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.10	0.30	1.00

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7356
2.4mm	7357



Super6 A18

Features and Applications

- Copper coated deoxidised steel rod for TIG welding mild steel
- General fabrication and ship building

Standards

AWS : ER 70S – 6

BS 2901 A18

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	400
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.10	1.00	1.30

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.0mm	7360
1.2mm	7361
1.6mm	7362
2.4mm	7363
3.2mm	7364

Super6 A31

Features and Applications

- A copper coated alloy steel rod containing 0.5% molybdenum. Suitable for use on low temperature pressure vessel and pipe work applications
- Shipbuilding, offshore, chemical and power generation industries

Standards

AWS : ER 80S – D2

BS 2901 A31

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	450
Hardness BHN	180

Chemical Composition

C	Si	Mn	Mo
0.10	0.70	1.80	0.50

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7366
2.4mm	7367

Super6 A32

Features and Applications

- A copper coated alloy steel rod containing 1.0% chromium and 0.5% molybdenum for welding low alloy and creep resistant steels
- Shipbuilding, offshore, chemical, power generation industries

Standards

AWS : ER 80S – B2
BS 2901 A32

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	460
Hardness BHN	180

Chemical Composition

C	Si	Mn	Cr	Mo
0.10	0.55	1.00	1.30	0.5

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7370
2.4mm	7371
3.2mm	7372

Super6 A33

Features and Applications

- A copper coated alloy steel rod containing 2.5% chromium, 1.0% molybdenum, suitable for high temperature and pressure vessel applications
- Ship building, offshore, chemical, power generation industries

Standards

AWS : ER 90 S – B3
BS 2901 A33

Mechanical Properties

Melting Point °C	1450
UTS N/mm ²	525
Hardness BHN	200

Chemical Composition

C	Si	Mn	Cr	Mo
0.10	0.50	1.00	2.40	1.00

Welding Positions



Current Type

DC–

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7374
2.4mm	7375

TIG HF6

Features and Applications

- Hard surfacing rod for metal to metal wear, such as wire guides, high speed steel and tool steels
- Quarries, plant operation, repair and maintenance

Standards

Mechanical Properties

Hardness BHN 60

Chemical Composition

C	Si	Mn	Cr	Mo	V	W
1.00	0.55	0.30	4.00	8.00	2.00	1.50

Welding Positions



Current Type

DC-

Shielding Gas

Pure Argon

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
1.6mm	7377
2.4mm	7378





TUNGSTEN ELECTRODES

Applications

Tungsten	Material	Current
Ceriated	Any Material	AC-DC
Thoriated	Stainless or Mild Steel	DC
Zirconiated	Aluminium and Alloys	AC
Lanthanated	Any Material	AC-DC
Multi-Type	Any Material	AC-DC

Standards

EN26848



Electrode Diameter	2% Thoriated Red	0.8% Zirconiated White	2% Ceriated Grey	1% Lanthanated Black	Multi-Type Gold	Pack
mm	Part No.	Part No.	Part No.	Part No.	Part No.	Quantity
1.0	1104	1121	1094	1132	1560	10
1.2	1105	1123	1095	1142	1561	10
1.6	1106	1111	1097	1170	1562	10
2.0	1117	1124	1096	1143	1149	10
2.4	1107	1112	1098	1171	1563	10
3.2	1108	1113	1099	1172	1564	10
4.0	1109	1114	1100	1173	1565	10
4.8	1110	1115	1101	1174	1566	5
6.4	1118	1116	1102	1175	1567	5

Head Office Sales: Tel: **01420 588180** Fax: **01420 588184** Email: **sales@swp.uk.net**

Northern Depot Sales: Tel: **01942 719930** Fax: **01942 729937** Email: **airsales@swp.uk.net**



Super6 E6013

Features and Applications

- Rutile cellulosic coated electrode for welding in all positions, especially suitable for where one single type of electrode is required
- Ship building, offshore, General fabrication, repair and maintenance

Standards

AWS : E 6013

EN ISO 2560 : E420 RC11

EN 1024 : 3.1

Mechanical Properties

Yield Point N/mm 410-450

Tensile Strength N/mm 460-510

Elongation % 24-28

Chemical Composition

C	Si	Mn
0.12	0.40	0.60

Welding Positions



Current Type

AC/DC+

Arc Voltage

42V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton & 2.5kg Packet / 15.0kg Carton

Diameter	5.0kg	2.5kg	1.0kg	Dia x Length	Current
2.0mm	7400			2.0 x 300	45-80
2.5mm	7401	4500	7397	2.5 x 350	60-110
3.2mm	7402	4501	7398	3.2 x 350	100-140
4.0mm	7403	4502	7399	4.0 x 400	140-180
5.0mm	7404			5.0 x 400	130-220

Super Optimal E6013 VERTICAL DOWN

Features and Applications

- Super Optimal is a vacuum packed, superior E6013 general purpose electrode for welding mild and low-alloyed structural steels. It deposits smooth weld beads in all positions including vertical down. It is very easy to strike and restrike with self-peeling slag
- Structural/general fabrication

Standards

ENISO 2560-A E38 0 RC11

AWS A5.1 E6013

Mechanical Properties

Yield Point N/mm ≥ 380

Tensile Strength N/mm 470-540

Elongation % 24

Chemical Composition

C	Si	Mn	P
0.08	0.20	0.50	0.03

Welding Positions



Current Type

AC/DC-

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg

Diameter	5.0kg	Diameter x Length	Welding Current
2.5mm	7601	2.5 x 350	80-100
3.2mm	7602	3.2 x 350	100-140
4.0mm	7603	4.0 x 400	130-190



Super6 E7018

Features and Applications

- Universal basic coated low hydrogen electrode for applications where high demands on impact value (even at low temperatures) are required. Excellent welding characteristics in all positions (except vertically downward)
- Ship building, offshore gas and oil industries, power generation

Standards

AWS : E7018

EN ISO 2560 : E42 5 B 32H5

Mechanical Properties

Yield Point N/mm	460-490
Tensile Strength N/mm	560
Elongation %	25-30

Chemical Composition

C	Si	Mn
0.05	0.55	1.00

Welding Positions



Current Type

AC/DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton (Sold by Carton)

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7408	2.5 x 350	80-100
3.2mm	7409	3.2 x 350	100-140
4.0mm	7410	4.0 x 400	130-190
5.0mm	7411	5.0 x 400	190-240

Super Optimal E7018-1

Features and Applications

- Super Optimal E7018-1 is a basic coated, vacuum packed low hydrogen electrode suitable for use in welding high strength fine grained steels and for welding restrained structures where high welding stresses cannot be avoided. It will also give high ductility at low temperatures, down to -45°C

Standards

ENISO 2560-A E46 6B 42 H5

AWSA5.1 E7018-1H4

Mechanical Properties

Yield Point N/mm	450
Tensile Strength N/mm	550-620
Elongation %	28

Chemical Composition

C	Si	Mn
0.08	0.40	1.40

Welding Positions



Current Type

AC/DC+

Arc Voltage

70V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton (Sold by Carton)

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7605	2.5 x 350	80-100
3.2mm	7606	3.2 x 350	100-140
4.0mm	7607	4.0 x 400	130-190



Super6 E6010

Features and Applications

- Cellulosic electrode for pipe welding in the vertical down position, particularly recommended for welding root passes
- Ship building, oil and gas industry

Standards

AWS : A5 1 : 6010

EN ISO 2560 A E38 3 C 21

Mechanical Properties

Yield Point N/mm	420
Tensile Strength N/mm	510
Elongation %	22

Chemical Composition

C	Si	Mn
0.15	0.20	0.60

Welding Positions



Current Type

AC/DC+

Arc Voltage

70V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7405	2.5 x 350	50-90
3.2mm	7406	3.2 x 350	80-130
4.0mm	7407	4.0 x 400	120-180

Super6 E7016

Features and Applications

- Basic coated low hydrogen electrode for all welding positions except vertical down position. Excellent welding characteristics, good slag release, smooth weld appearance
- Ship building, offshore oil and gas construction, power generation, general fabrication

Standards

AWS : E7016

EN ISO 2560 – A : E42 3B 12

Mechanical Properties

Yield Point N/mm	420
Tensile Strength N/mm	510
Elongation %	22

Chemical Composition

C	Si	Mn
0.06	0.70	0.90

Welding Positions



Current Type

AC/DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7412	2.5 x 350	80-100
3.2mm	7413	3.2 x 350	100-140
4.0mm	7414	4.0 x 400	140-200



Super6 E7024

Features and Applications

- A high efficiency (recovery 160%) electrode, specially suited to fillet welding and filling V-buts. Excellent welding characteristics and self releasing slag
- Ship building, offshore, power generation and general fabrication

Standards

AWS : E7024

EN ISO 2560: E420 RR53

Mechanical Properties

Yield Point N/mm	450-490
Tensile Strength N/mm	500-540
Elongation %	24-28

Chemical Composition

C	Si	Mn
0.10	0.40	0.60

Welding Positions



Current Type

AC/DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Packet / 20.0kg Carton (Sold by Carton)

Diameter	Part No.	Diameter x Length	Welding Current
3.2mm	7415	3.2 x 350	120-180
4.0mm	7416	4.0 x 400	160-240
5.0mm	7417	5.0 x 400	200-280

Super6 BRONZE SN

Features and Applications

- A tin bronze electrode for joining and surfacing copper and copper alloys. It can also be used for minor repair work on cast iron
- Ship building, repair and maintenance

Standards

AWS : E Cu Sn – C

DIN 1733 : EI – Cu Sn 7

Mechanical Properties

Tensile Strength N/mm	300-350
Elongation %	25-30
Hardness	90-120 HV

Chemical Composition

Mn	Si	Sn	Fe	P	Cu
1.50	0.50	7.50	0.20	0.10	90.2

Welding Positions



Current Type

DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

4.0kg Packet / 12.0kg Carton

Diameter	Part No.	Diameter x Length	Welding Current
3.2mm	7418	3.2 x 350	80-120



Super6 CUTTING / GOUGING

Features and Applications

- Ideal for cutting, grooving and gouging steels, stainless steel, copper alloy, cast iron and cast steels

Standards

Mechanical Properties

Chemical Composition

Welding Positions



Current Type

AC/DC

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

4.5kg Packet¹ / 6.0kg Packet²

Diameter	Part No.	Diameter x Length	Welding Current
3.2mm ¹	7420	3.2 x 350	180-240
4.0mm ²	7421	4.0 x 450	240-320
5.0mm ²	7422	5.0 x 450	320-450

Super6 HARDFACING 600S

Features and Applications

- Basic coated electrode for wear resistant surfacing of steel, cast steel and high Mn – steels that are subjected to abrasion and metal-to-metal wear

Standards

Din 8555 : E6 – UM – 60 GP

EN 14700 E Fe 8

Mechanical Properties

Hardness HRC

54-58

Chemical Composition

C	Si	Cr
0.50	1.80	9.00

Welding Positions



Current Type

DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

4.5kg Packet¹ / 6.0kg Packet²

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm ¹	7423	2.5 x 350	80-110
3.25mm ¹	7424	3.25 x 350	100-140
4.0mm ²	7425	4.0 x 450	130-180



Super6 PURE NICKEL

Features and Applications

- An Electrode with a pure nickel core for welding grey cast iron and joining cast irons to other ferrous or non ferrous metals. Heat affected zone and weld metal easily machinable. Specially suited to welding contaminated cast iron
- Repair and maintenance

Standards

AWS : E Ni Cl

EN ISO 1071 EC Ni – Cl – 1

Mechanical Properties

Hardness 150-175 HB

Chemical Composition

C	Ni
0.50	99.5

Welding Positions



Current Type

AC/DC–

Arc Voltage

60V

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7430	2.5 x 300	60-90
3.2mm	7431	3.2 x 300	90-110
4.0mm	7432	4.0 x 400	110-130

Super6 NICKEL IRON (Cast Iron)

Features and Applications

- Electrode with nickel iron core for repair welding and joining all types of cast iron. Recommended for joints in which severe demands are made on the strength of the weld
- Repair and maintenance

Standards

AWS : E Ni Fe Cl

EN ISO 1071 EC Ni Fe Cl 1

Mechanical Properties

Hardness 190 HB

Chemical Composition

Ni	Fe
45.0	40.0

Welding Positions



Current Type

AC/DC–

Arc Voltage

60V

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7434	2.5 x 300	60-90
3.2mm	7435	3.2 x 300	80-120
4.0mm	7436	4.0 x 400	110-150



Super6 E308L

Features and Applications

- Stainless electrode for welding corrosion resistant 18/10 and similar Cr/Ni steels with a working temperature up to 350 °C. Excellent corrosion resistance against nitric acid and highly resistant against inter granular corrosion
- Food industry, power generation

Standards

AWS : E308L – 17
EN 1600 E 199LR 32

Mechanical Properties

Yield Point N/mm	420
Tensile Strength N/mm	550
Elongation %	35

Chemical Composition

C	Si	Mn	Cr	Ni
0.30	0.80	0.80	19.8	10.2

Welding Positions



Current Type

AC/DC+

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

2.5mm – 3.0kg Packet / 3.2mm, 4.0mm – 4.5kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7438	2.5 x 250	50-80
3.2mm	7439	3.2 x 350	80-110
4.0mm	7440	4.0 x 350	110-140

Super6 E309L

Features and Applications

- Stainless electrode for welding corrosion resistant and heat resistant Cr/Ni steels and for welding Cr/Ni steels to unalloyed and low alloyed steel
- Power generation, oil and gas industry, repair and maintenance

Standards

AWS : E309L – 17
EN 1600 E23 12 LR 32

Mechanical Properties

Yield Point N/mm	440
Tensile Strength N/mm	560
Elongation %	30

Chemical Composition

C	Si	Mn	Cr	Ni
0.04	0.80	0.80	24.5	13.0

Welding Positions



Current Type

AC/DC+

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

2.5mm – 3.0kg Packet / 3.2mm, 4.0mm – 4.5kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7442	2.5 x 250	60-90
3.2mm	7443	3.2 x 350	80-120
4.0mm	7444	4.0 x 350	110-160



Super6 E309 MoL

Features and Applications

- Stainless electrode for joining similar and dissimilar stainless steels, buffering joining hardenable and difficult steels
- Power generation, oil and gas industries, repair and maintenance

Standards

AWS : E309 MOL – 17
EN 1600 E23 12 2 LR 32

Mechanical Properties

Yield Point N/mm	490
Tensile Strength N/mm	630
Elongation %	30

Chemical Composition

C	Si	Mn	Cr	Ni	Mo
0.02	0.70	0.80	23.0	12.0	2.70

Welding Positions



Current Type

AC/DC+

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

2.5mm – 3.0kg Packet / 3.2mm, 4.0mm – 4.5kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7446	2.5 x 250	60-90
3.2mm	7447	3.2 x 350	80-120
4.0mm	7448	4.0 x 350	100-160

Super6 E316L

Features and Applications

- Stainless electrode for welding molybdenum alloyed 18/12 and similar Cr/Ni/Mo steel. High resistance against general and intergranular corrosion
- Food industry, power generation

Standards

AWS : E316L – 17
EN 1600 E19 12 3 LR 12

Mechanical Properties

Yield Point N/mm	320
Tensile Strength N/mm	550
Elongation %	35

Chemical Composition

C	Si	Mn	Cr	Ni	Mo
0.30	0.80	0.90	19.0	12.5	2.60

Welding Positions



Current Type

AC/DC+

Arc Voltage

50V

Manufacturer's Approvals

Approvals on request

Product Information

2.5mm – 3.0kg Packet / 3.2mm, 4.0mm – 4.5kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7450	2.5 x 250	50-90
3.2mm	7451	3.2 x 350	80-120
4.0mm	7452	4.0 x 350	110-160



Super6 E312 (Dissimilar)

Features and Applications

- High Cr/Ni electrode for welding of difficult-to-weld steel eg armour plate, austenitic Mn steel, high carbon steel and Cr/Ni steels, such as spring steel
- Power generation, repair and maintenance

Standards

AWS : E312 – 17

EN 1600 E 29 9 R 32

Mechanical Properties

Yield Point N/mm	490
Tensile Strength N/mm	700
Elongation %	20

Chemical Composition

C	Si	Mn	Cr	Ni
0.10	1.10	0.80	29.0	9.00

Welding Positions



Current Type

AC/DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

2.5mm – 3.0kg Packet / 3.2mm, 4.0mm – 4.5kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
2.5mm	7454	2.5 x 250	60-80
3.2mm	7455	3.2 x 350	80-110
4.0mm	7456	4.0 x 350	110-160

Super6 AL SI 5

Features and Applications

- Aluminium electrode with 5% silicon for welding, repairing and surfacing forged and cast Al/Si alloys and joining dissimilar Aluminium alloys with maximum 7% Si content
- Ship building, repair and maintenance

Standards

AWS : E4043

DIN 1732 EL AL SI5

Mechanical Properties

Tensile Strength N/mm	120-150
Elongation %	12-25

Chemical Composition

Si	Mn	Cu	Al
5.00	0.05	0.05	94

Welding Positions



Current Type

DC+

Arc Voltage

65V

Manufacturer's Approvals

Approvals on request

Product Information

2.0kg Packet

Diameter	Part No.	Diameter x Length	Welding Current
3.2mm	7458	3.2 x 350	70-100
4.0mm	7459	4.0 x 350	90-130



C C M S

Features and Applications

- An oxygen/acetylene copper coated mild steel rod for all types of mild steel and wrought iron welding
- Particularly suitable for welding sheet metal panels, plates and tubes

Standards

AWS : A5.2 R45

BS 1453 A1

Mechanical Properties

Melting Point °C	1450
UTS N/mm	350
Hardness BHN	120

Chemical Composition

C	Si	Mn
0.07	0.10	0.40

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7460
2.4mm	7461
3.2mm	7462

SILICON BRONZE C2

Features and Applications

- A multi purpose silicon bronze brazing rod suited to all types of fabrication work involving steel, cast iron, copper and dissimilar metal joints. Use a general brazing flux for best results
- Automotive, wheelchair, tubular furniture and bicycle industries, repair and maintenance

Standards

EN 1044 : CU 302

BS 1845 CZ6A 1453 C2

Mechanical Properties

Melting Point °C	875
UTS N/mm ²	420
Hardness BHN	120

Chemical Composition

Cu	Si	Sn	Zn
60.0	0.30	0.30	34.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
1.6mm	7468
2.4mm	7469
3.2mm	7470



FLUX COATED BRONZE C2FC

Features and Applications

- Flux coated silicon bronze rod for continuous brazing through not having to flux dip the rod. Ideal for general mild steel, galvanised steel, dissimilar joints and DIY enthusiasts
- Automotive, tubular furniture, repair and maintenance DIY

Standards

EN 1044 : Cu302

BS 1845 CZ6A 1453 C2

Mechanical Properties

Melting Point °C	875
UTS N/mm ²	420
Hardness BHN	120

Chemical Composition

Cu	Si	Sn	Zn
60.0	0.30	0.30	34.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg Tube

Diameter	Part No.
2.4mm	7473
3.2mm	7474

BRONZE C2 K (FLUX IMPREGNATED)

Features and Applications

- A flux impregnated silicon bronze rod which is perfect for brazing clean mild steel components and is ideally suited for use in motor body shops and sheet metal fabrications
- Automotive, sheet metal and tubular furniture manufacturers

Standards

EN 1044 : Cu 302

BS 1845 CZ 6A 1453 C2

Mechanical Properties

Melting Point °C	875
UTS N/mm ²	420
Hardness BHN	120

Chemical Composition

Cu	Si	Sn	Zn
60.0	0.30	0.30	34.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

2.5kg (500mm length) Tube

Diameter	Part No.
2.4mm	7476
3.0mm	7477

BRONZE Mn

Features and Applications

- A brazing rod with additions of manganese and tin giving a free flowing characteristic. Use a general brazing flux or liquid gas flux
- Automotive, wheelchair, bicycle industries

Standards

AWS : RB Cu Zn – C

Mechanical Properties

Melting Point °C	870
UTS N/mm ²	460
Hardness BHN	130

Chemical Composition

Cu	Si	Mn	Sn	Zn
60.0	0.20	0.20	0.10	35.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.5mm	7480
2.0mm	7481
2.5mm	7482
3.0mm	7483

BRONZE C5

Features and Applications

- Nickel bronze rod for use on cast iron, copper alloy, stainless steel and alloy steels. Gives excellent wearing properties and is ideal for structures requiring a high tensile strength. Use a general brazing flux or a stainless steel brazing flux
- Bicycle, tubular structures repair and maintenance

Standards

EN 1044 : Cu 305

BS : 1845 CZ8 1453 C5

Mechanical Properties

Melting Point °C	950
UTS N/mm ²	540
Hardness BHN	200

Chemical Composition

Cu	Si	Ni	Zn
48.0	0.30	10.0	39.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
1.6mm	7485
2.4mm	7486
3.2mm	7487



BRONZE C5 FC

Features and Applications

- A flux coated nickel bronze for use on cast iron, copper alloys, stainless steel and alloy steel. The nickel content makes this rod ideal for joints requiring high strength
- Tubular structures, repair and maintenance

Standards

EN 1044 : Cu 305

BS : 1845 CZ 8 1453 C5

Mechanical Properties

Melting Point °C	950
UTS N/mm ²	540
Hardness BHN	200

Chemical Composition

Cu	Si	Ni	Zn
48.0	0.30	10.0	39.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

5.0kg Tube

Diameter	Part No.
2.4mm	7530
3.2mm	7531

CP3

Features and Applications

- A copper phosphorous rod with good electrical conductivity and corrosion resistance. It is self-fluxing on copper. A copper flux is required on brass joints
- Artistic foundries and general copper and brass fabrications

Standards

AWS : B Cu P-2

EN 1044 : CP201

BS : 1845 CP3

Mechanical Properties

Melting Point °C	710
UTS N/mm ²	500
Hardness BHN	200

Chemical Composition

P	CU
7.00	93.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
1.5mm	7533
2.4mm	7534
3.2mm	7535



CP2

Features and Applications

- A copper phosphorous rod with 2% silver to give improved ductility and easier flowing characteristics. It is also highly resistant to corrosion. The rod is self fluxing on copper but a copper flux is required on brass joints
- Electric motors, hot water cylinders, copper/brass fabrication

Standards

AWS : B Cu P-6
EN 1044 : CP105
BS 1845 CP2

Mechanical Properties

Melting Point °C	650
UTS N/mm ²	420
Hardness BHN	190

Chemical Composition

Ag	P	Cu
2.00	6.00	92.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
2.4mm	7537
3.2mm	7538

CP4

Features and Applications

- A copper phosphorous rod with 5% silver to give excellent flow and ductility (greater than CP2). The rod is self-fluxing on copper but a copper flux is required when joining brass
- General copper/brass fabrications

Standards

AWS : B Cu P – 3
EN 1044 : CP 104
BS 1845 CP4

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	600
Hardness BHN	190

Chemical Composition

Ag	P	Cu
5.00	6.00	89.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
1.6mm	7499
2.4mm	7500



CP1

Features and Applications

- 15% silver, copper phosphorous rod for stressed application such as poor fitting of joints
- General copper/brass fabrications

Standards

EN 1044 : CP 102
BS 1845 CP1

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	640
Hardness BHN	180

Chemical Composition

Ag	P	Cu
15.0	5.00	80.0

Welding Positions



Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

Diameter	Part No.
2.4mm	7502

SILVER AG28

Features and Applications

- Cadmium-free 40% silver solder suitable for all ferrous and non ferrous metals except Aluminium and its alloys
- Artistic foundries, power generation, general copper/ brass fabrications

Standards

AWS : A5.8-92 B Ag-28
EN 1044 Ag 105

Mechanical Properties

Melting Point °C	640
UTS N/mm ²	440
Hardness BHN	130

Chemical Composition

Ag	Cu	Zn	Sn
40.0	30.0	28.0	2.00

Welding Positions

Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube

0.25kg Tube

Diameter	Part No.	Diameter	Part No.
1.5mm	7505	1.5mm	7503
2.5mm	7506	2.5mm	7504



SILVER AG14

Features and Applications

- Cadmium-free 55% silver solder which is free flowing and ideal for close fitting capillary joints. It gives a good colour match on stainless steel
- Artistic foundries, food industry, power generation

Standards

AWS : A5.8 Bag 7
EN 1044 AG103
BS 1845 AG14

Mechanical Properties

Melting Point °C	630
UTS N/mm ²	415
Hardness BHN	145

Chemical Composition

Ag	Cu	Zn	Sn
55.0	21.0	22.0	2.00

Welding Positions

Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube		0.25kg Tube	
Diameter	Part No.	Diameter	Part No.
1.5mm	7508	1.5mm	7515
2.5mm	7509	2.5mm	7516

SILVER AG14 FC

Features and Applications

- Cadmium free 55% flux coated silver solder
- Artistic foundries, food industry, power generation

Standards

AWS : A5.8 Bag 7
EN 1044 AG103
BS 1845 AG 14

Mechanical Properties

Melting Point °C	630
UTS N/mm ²	415
Hardness BHN	145

Chemical Composition

Ag	Cu	Zn	Sn
55.0	21.0	22.0	2.00

Welding Positions

Current Type

Recommended Gas

Oxygen/Acetylene

Manufacturer's Approvals

Approvals on request

Product Information

1.0kg Tube		0.25kg Tube	
Diameter	Part No.	Diameter	Part No.
1.5mm	7511	1.5mm	7517
2.5mm	7512	2.5mm	7518

Chemicals

FLUX POWDER



Part No. Description

- | | |
|-------------|---|
| 7520 | Aluminium Welding – 500g
<i>Powder Flux for gas welding Aluminium</i> |
| 7521 | Aluminium Brazing – 500g
<i>Powder Flux for gas brazing Aluminium and its alloys</i> |
| 7522 | General Brazing – 500g
<i>Powder Flux for gas brazing steel and cast iron</i> |
| 7523 | Copper Welding and Brazing – 500g
<i>Powder Flux for welding and brazing copper and its alloys</i> |
| 7524 | Silver Solder – 500g
<i>Powder Flux (boric acid and borates free) for silver solder operations</i> |

Removal of Flux Residues

FERROUS METALS

Flux residues can be removed with a hot water wash and mechanical cleaning with a wire brush

On certain applications – due to the workpiece, size or shape – it may be necessary to use a weak solution (5%) of hydrochloric acid

COPPER ALLOYS

Use 10-15% sulphuric acid solution

Aluminium ALLOYS

Immerse work piece in a 10-20% caustic soda solution for approximately one minute

PLEASE NOTE

When using chemicals ensure that all parts are thoroughly washed after treatment

TIP DIP



Part No. **1490**

Anti-spatter paste for MIG and TIG welding torch protection and weld spatter minimization – 500g (20 per case)

PASTES

Part No. **1669**

Standard Pickling Paste
2.0kg (6 per case)

Part No. **1670**

Rapid Pickling Paste
2.0kg (6 per case)

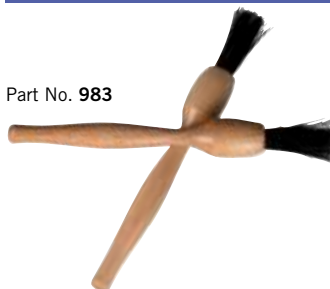
Part No. **1671**

Neutralisation Paste
2.0kg (6 per case)



PICKLING PASTE BRUSHES

Part No. **983**



PREMIUM ANTI-SPATTER SPRAY

Part No. **1362**
 Premium Anti-Spatter Spray
 300ml
Bag on valve pressure spray gives up to 3 times the life of aerosols with no noxious fumes and no harmful solvents. Propelled by compressed air with a constant 360° spray. Reduces heat discolouration and contains a corrosion inhibitor.
 Qty. 12



Part No. **1394**
 Cleanweld Anti-Spatter Spray
 600ml
Bag on valve pressure spray, outperforms by far and lasts three times as long as conventional aerosols.
 Qty. 12



Part No. **1397**
 Super 6 Anti-Spatter Spray
 600ml
Vegetable oil based, specially formulated to prevent spatter adherence and does not affect further processes. It is ideal for use on welding equipment and to prevent the adhesion of weld spatter to work surfaces, shrouds, jigs and tools.
 Qty. 12



ANTI-SPATTER SPRAY

Part No. **1357**
 Anti-Spatter Spray
 300ml
Best replacement for DCM solvent based aerosol. Water based and highly effective.
 Qty. 12



Part No. **1358**
 Anti-Spatter Spray
 300ml
Silicone Free - Solvent Based. Prolongs tip and shroud life and prevents the adhesion of weld spatter to the surrounding area.
 Qty. 12



WATER BASED ANTI-SPATTER

Part No. **1365**
 5 litres
 Qty. 1-4

Part No. **1366**
 25 litres
 Qty. 1



CRACK DETECTOR / METAL WORKING SPRAYS

Item	Part No.	Description	Qty.
1	1800	Crack Detector Penetrant – 300ml	12
2	1801	Crack Detector Developer – 300ml	12
3	1802	Crack Developer Cleaner – 300ml	12
4	1803	Leak Detector Spray – 300ml	12
5	1807	Tapping and Cutting Oil – 300ml	12
6	1808	Galvanising Spray – 300ml	12
7	1809	Safe Solvent Cleaner – 300ml	12



FLAME SETTINGS

Typical Flame Temperatures

Oxy-Acetylene	3200°C
Oxy-Propane	2500°C
Oxy-natural gas	2200°C
Air-Acetylene	2460°C
Air-natural gas	1870°C
Air-Propane	1750°C



Neutral Flame

(balanced oxygen and acetylene)

For mild steel and general welding



Oxydising Flame

(excess oxygen)

For welding brass and bronzing



Carburising Flame

(excess acetylene)

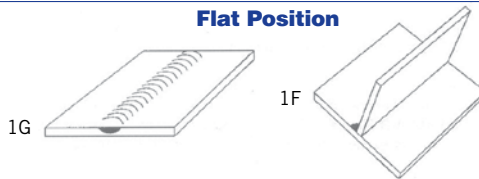
For Aluminium, stainless steels and for hardfacing

FEATURED CHEMICAL ELEMENTS

Aluminiumum Al	Molybdenum Mo
Argon Ar	Nickel Ni
Cadmium Cd	Niobium Nb
Carbon C	Nitrogen N
Chromium Cr	Nobelium No
Copper Cu	Phosphorus P
Iron Fe	Silicon Si
Lead Pb	Silver Ag
Magnesium Mg	Tin Sn
Manganese Mn	Titanium Ti
Mercury Hg	Zinc Zn

WELDING POSITIONS EN & AWS Standards

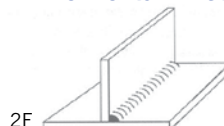
Flat Position



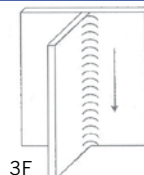
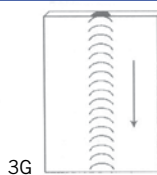
Horizontal Vertical



Horizontal Fillet



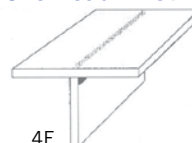
Vertical Down



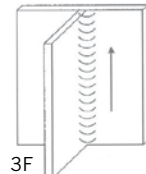
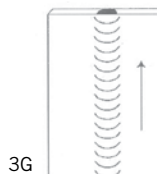
Overhead



Overhead Fillet



Vertical Up



APPROVALS

ABS	American Bureau of Shipping
BV	Bureau Veritas
DB + U	Deutsche Bundesbahn + Überwachungsvertrag
DNV	Det Norske Veritas
GL	Germanischer Lloyds
LR	Lloyds Register of Shipping
T U V	Technische Überwachungs Verein
FORCE	Force Institute (Danish Standard)