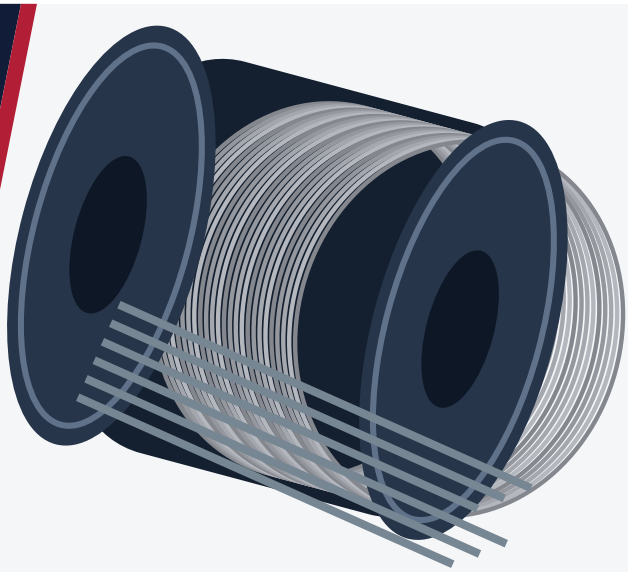
DAIKO

Welding Consumables

Range & Ordering Guide

Specialist fillers for joining and cladding, from duplex and nickel alloys to pressure and structural steels.



Find Your Material or Application

Austenitic Stainless Steels	02	High-Temperature Alloys	10
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Joining or Cladding?

For joining, match the parent alloy and welding procedure. For overlay, specify the required deposit and service conditions. For mechanised welding, specify the spool, wire or strip format as well as the grade.

Request a Quote

Quote the full grade reference, welding process, diameter and quantity. For strip, include width and thickness.

Manufacturer technical literature

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GRADE REFERENCES & TECHNICAL DATA

Austenitic Stainless Steels

Match the stainless grade and service conditions. Use a specified buffer or dissimilar filler where dilution changes the weld chemistry.

AUSTENITIC STAINLESS STEELS

307

Dissimilar joining and buffer layers on specified steels.

DAIKOWT 307 EN ISO 14343-A 18 8 Mn	TIG	
DAIKOWT 307Si EN ISO 14343-A 18 8 Mn	TIG	
DAIKOWM 307Si ER307SI (approx.) Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 307B E307-15	MMA	
G-TECH 307HR E307-26	MMA	
G-TECH 307 E307-16	MMA	
DAIKOFCW 307 EN ISO 17633-A T 18 8 Mn R M21 3	Cored Wire	
DAIKOWS 307 EN ISO 14343-A 18 8 Mn	SAW	

AUSTENITIC STAINLESS STEELS

312

Difficult-to-weld steels and specified repair deposits.

DAIKOWT 312 ER312	TIG	
DAIKOWM 312 ER312	MIG	
G-TECH 312 E312-16 Carton	MMA	**TDS**
G-TECH 312R E312-17 Carton	MMA	**TDS**
DAIKOFCW 312 E312T0-4	Cored Wire	
DAIKOWS 312 ER312	SAW	

AUSTENITIC STAINLESS STEELS

347

Nb-stabilised stainless joining and fabrication.

DAIKOWT 347 ER347 Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWT 347Si ER347SI	TIG	
DAIKOWM 347Si ER347SI	MIG	
DAIKOWM 347 ER347	MIG	
G-TECH 347R E347-17	MMA	
DAIKOFCW 347 E347T0-1/4	Cored Wire	
DAIKOFCW 347P	Cored Wire	
DAIKOWS 347 ER347	SAW	
DAIKOSTRIP 347 EQ347	ESW / SAW	

AUSTENITIC STAINLESS STEELS

308H

Higher-carbon grades for specified hot service.

DAIKOWT 308H ER308H	TIG	
DAIKOWM 308H ER308H	MIG	
G-TECH 308HB E308H-15	MMA	
G-TECH 308H E308H-16 Carton	MMA	**TDS**
DAIKOFCW 308HP E308HT1-1/4	Cored Wire	
DAIKOWS 308H ER308H Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Austenitic Stainless Steels

Match the stainless grade and service conditions. Use a specified buffer or dissimilar filler where dilution changes the weld chemistry.

AUSTENITIC STAINLESS STEELS

308L

Low-carbon fillers for compatible 304/304L.

DAIKOWT 308L ER308L Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWT 308LSi ER308LSI Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 308L ER308L	MIG	
DAIKOWM 308LSi ER308LSI	MIG	
G-TECH 308LB E308L-15	MMA	
G-TECH 308L E308L-16 Carton	MMA	**TDS**
G-TECH 308LR E308L-17 Carton	MMA	**TDS**
DAIKOFCW 308LP E308LT1-1/4	Cored Wire	
DAIKOFCW 308L E308LT0-1/4	Cored Wire	
DAIKOWS 308L ER308L Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**
DAIKOSTRIP 308L EQ308L	ESW / SAW	

AUSTENITIC STAINLESS STEELS

309L

Stainless-to-steel joints and specified buffers.

DAIKOWT 309L ER309L	TIG	
DAIKOWT 309LSi ER309LSI	TIG	
DAIKOWM 309LSi ER309LSI	MIG	
DAIKOWM 309L ER309L Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 309LB E309L-15	MMA	
G-TECH 309L E309L-16 Carton	MMA	**TDS**
G-TECH 309LR E309L-17	MMA	
DAIKOFCW 309LP E309LT1-1/4 Ø 1.2–1.6mm · BS300 spool	Cored Wire	**TDS**
DAIKOFCW 309L E309LT0-1/4	Cored Wire	
DAIKOWS 309L ER309L Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**
DAIKOSTRIP 309L EN	ESW / SAW	**TDS**

AUSTENITIC STAINLESS STEELS

317L

Mo-bearing fillers for compatible 317L service.

DAIKOWT 317L ER317L	TIG	
DAIKOWM 317L ER317L	MIG	
G-TECH 317L E317L-16 Carton	MMA	**TDS**
DAIKOFCW 317 E317LT0-1/4	Cored Wire	
DAIKOWS 317L ER317L	SAW	
DAIKOSTRIP 317 EQ317L	ESW / SAW	

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Austenitic Stainless Steels / Highly Alloyed Stainless Steels

AUSTENITIC STAINLESS STEELS

347H

Stabilised fillers for high-temperature stainless.

DAIKOWT 347H	TIG	
AIKOWM 347H	MIG	
G-TECH 347HB E347-15	MMA	
G-TECH 347H E347-16	MMA	
DAIKOWS 347H ER347 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

HIGHLY ALLOYED STAINLESS STEELS

310

Heat- and oxidation-resistant stainless work.

DAIKOWT 310Mn EN ISO 14343-A G 25 20	TIG	
DAIKOWT 310 ER310	TIG	
DAIKOWT 310Mo	TIG	
DAIKOWM 310Mn EN ISO 14343-A G 25 20	MIG	
DAIKOWM 310 ER310	MIG	
DAIKOWM 310Mo	MIG	
G-TECH 310 E310-16	MMA	
G-TECH 310B E310-15	MMA	
G-TECH 310Mn	MMA	
G-TECH 310Mo E310MO-16	MMA	
DAIKOFCW 310 E310T0-1/4	Cored Wire	

HIGHLY ALLOYED STAINLESS STEELS

310H

Higher-carbon filler for compatible hot-service alloys.

G-TECH 310H E310H-15	MMA	

HIGHLY ALLOYED STAINLESS STEELS

904L

High-alloy stainless for corrosive process service.

DAIKOWT 385 ER385	TIG	
DAIKOWM 385 ER385 Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 385 E385-16 (approx.)	MMA	
G-TECH 385B E385-15	MMA	
DAIKOMCW 385 EC385	Cored Wire	
DAIKOFCW 904L EN ISO 17633-A T Z 20 25 5 Cu L R M 3	Cored Wire	
DAIKOFCW 904LP EN ISO 17633-A T 20 25 5 Cu N L P M21 2	Cored Wire	
DAIKOWS 385 ER385	SAW	
DAIKOSTRIP 385 EQ385	ESW / SAW	

HIGHLY ALLOYED STAINLESS STEELS

ALLOY 20

Matching filler options for compatible Alloy 20.

DAIKOWT 320LR ER320LR	TIG	
DAIKOWM 320LR ER320LR	MIG	
G-TECH 320LHR E320LR-26	MMA	

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Ferritic & Martensitic Stainless / Nickel Alloys

FERRITIC & MARTENSITIC STAINLESS

410

Ferritic and martensitic chromium stainless.

DAIKOWT 410 ER410	TIG	
DAIKOWM 410 ER410	MIG	
G-TECH 410B E410-15	MMA	
G-TECH 410 E410-16	MMA	
G-TECH 410HR E410-26	MMA	
DAIKOWS 410 ER410 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

FERRITIC & MARTENSITIC STAINLESS

409Nb

Nb-stabilised ferritic stainless applications.

DAIKOWT 409Nb ER409NB	TIG	
DAIKOWM 409Nb ER409NB Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
DAIKOWS 409Nb ER409NB	SAW	

FERRITIC & MARTENSITIC STAINLESS

630 (17-4-PH)

Precipitation-hardening stainless fabrication and repair.

DAIKOWT 630 ER630 Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 630 ER630	MIG	
G-TECH 630 E630-16	MMA	
DAIKOWS 630 ER630	SAW	

NICKEL ALLOYS

625

Ni-Cr-Mo joining and corrosion-resistant overlays.

DAIKOWT 625 ERNICRMO-3 Ø 1.0–4.0mm · 5kg carton	TIG	**TDS**
DAIKOWM 625 ERNICRMO-3 Ø 0.8–1.6mm · 15kg BS300 spool; larger formats on request	MIG	
DAIKO 112 ENICRMO-3	MMA	
DAIKOFCW 625P ENICRMO3T1-4	Cored Wire	
DAIKOWS 625 EN ISO 18274 S Ni6625 Ø 1.6–4.0mm · 25kg K415 spool	SAW	
DAIKOSTRIP 625 EQNICRMO-3	ESW / SAW	

NICKEL ALLOYS

718

For compatible precipitation-hardening nickel alloy.

DAIKOWT 718 ERNIFECR-2 Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 718 ERNIFECR-2 Ø 0.8–1.6mm · Drums, DIN 760 reel, B300, D200 and D100 spools	MIG	**TDS**

NICKEL ALLOYS

50/50Nb

High-chromium nickel deposit for specified hot service.

DAIKOWT 657 ERNICR-4	TIG	
DAIKOWM 657 ERNICR-4	MIG	**TDS**
G-TECH 657 ENICR-4 Carton and tube	MMA	**TDS**

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Nickel Alloys

Specify the nickel alloy and service exposure. The range includes corrosion-resistant Ni-Cr-Mo, age-hardening grades, Ni-Cu and pure nickel.

NICKEL ALLOYS

C22

Matching Ni-Cr-Mo filler for compatible Alloy C-22.

DAIKOWT 622 ERNICRMO-10	TIG
DAIKOWM 622 ERNICRMO-10	MIG
DAIKO 122 ENICRMO-10	MMA
DAIKOFCW 622 ENICRMO10T1-1/4	Cored Wire
DAIKOWS 622 ERNICRMO-10	SAW
DAIKOSTRIP C22 EQNICRMO-10	ESW / SAW

NICKEL ALLOYS

C276

Matching Ni-Cr-Mo filler for compatible Alloy C-276.

DAIKOWT 276 ERNICRMO-4	TIG
DAIKOWM 276 ERNICRMO-4	MIG
DAIKO C276 ENICRMO-4	MMA
DAIKOFCW C276P ENICRMO4T1-4	Cored Wire
DAIKOFCW C276 ENICRMO4T0-4	Cored Wire
DAIKOWS 276 ERNICRMO-4	SAW
DAIKOSTRIP C276 EQNICRMO-4	ESW / SAW

NICKEL ALLOYS

Monel 400

Nickel-copper joining and surfacing.

DAIKOWT 418 ERNICU-7	TIG
DAIKOWM 418 ERNICU-7	MIG
DAIKO 190 ENICU-7	MMA
DAIKOWS 418 ERNICU-7	SAW
DAIKOSTRIP 418 EQNICU7	ESW / SAW

NICKEL ALLOYS

Pure Nickel

Joining and surfacing on compatible pure nickel.

DAIKOWT 208	TIG
DAIKOWM 208	MIG
DAIKO 141 ENI-1	MMA
DAIKOWS 208	SAW

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Duplex & Super Duplex / Creep-Resistant Steels

DUPLEX & SUPER DUPLEX

2209

Filler family for compatible 22Cr duplex steels.

DAIKOWT 2209 ER2209 Ø 1.0–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 2209 ER2209	MIG	
G-TECH 2209 E2209-16	MMA	
G-TECH 2209B E2209-15	MMA	
G-TECH 2209R E2209-17	MMA	
DAIKOFCW 2209P E2209T1-4 Ø 1.2–1.6mm · BS300 spool	Cored Wire	**TDS**
DAIKOFCW 2209 EN ISO 17633-A T 22 9 3 N L R M21 3	Cored Wire	
DAIKOWS 2209 ER2209	SAW	
DAIKOSTRIP 2209 EN	ESW / SAW	**TDS**

DUPLEX & SUPER DUPLEX

2507

Options for compatible 25Cr super duplex steels.

DAIKOWT 2594 ER2594	TIG	
DAIKOWM 2594 ER2594	MIG	
G-TECH 2594B E2594-15	MMA	
G-TECH 2594	MMA	
DAIKOFCW 2594P E2594T1-4	Cored Wire	
DAIKOWS 2594 ER2594	SAW	
DAIKOSTRIP 2594 EQ2594	ESW / SAW	

DUPLEX & SUPER DUPLEX

ZERON 100

Super duplex joining to the specified procedure.

DAIKOWT 2594Cu ER2594	TIG	
DAIKOWM 2594Cu ER2594	MIG	
G-TECH 2595B E2595-15	MMA	
DAIKOFCW 2595	Cored Wire	
DAIKOWS 2594Cu ER2594	SAW	

CREEP-RESISTANT STEELS

0.5Mo

Mo-bearing fillers for compatible pressure steels.

DAIKOWT Mo.B ER70S-A1 Ø 1.2–3.2mm · 5kg carton tube	TIG	**TDS**
DAIKOWM Mo.B ER70S-A1	MIG	
G-TECH Mo.B E7018-A1 Carton	MMA	**TDS**
DAIKOFCW Mo.B E80T5-M21P8-A1	Cored Wire	
DAIKOWS Mo.B EA2 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

CREEP-RESISTANT STEELS

12CrMoV

For compatible Cr-Mo-V heat-resistant steels.

DAIKOWT 12CrMoV EN ISO 21952-A W CRMoWV12SI Ø 1.2–3.2mm · 5kg carton tube	TIG	**TDS**
G-TECH 12CrMoV ISO 3580-A E Cr Mo W V12 B 3 2 HS	MMA	**TDS**

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Creep-Resistant Steels / High-Yield-Strength Steels

CREEP-RESISTANT STEELS

1CrMo

Chromium-molybdenum fillers for compatible steels.

DAIKOWT 1CrMo ER80S-B2	TIG	
DAIKOWT 1CrMoS ER80S-G	TIG	
DAIKOWM 1CrMo ER80S-B2	MIG	
DAIKOWM 1CrMoS ER80S-G	MIG	
G-TECH 1CrMo E8018-B2	MMA	
DAIKOFCW 1CrMoB	Cored Wire	
DAIKOMCW 1CrMo EN ISO 17632-A T CrMo1 M M 2	Cored Wire	
DAIKOWS 1CrMo EB2 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

CREEP-RESISTANT STEELS

2Cr1Mo

Creep-resistant Cr-Mo filler options.

DAIKOWT 2CrMo ER90S-B3	TIG	
DAIKOWT 2CrMoS ER90S-G Ø 1.2–3.2mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 2CrMo ER90S-B3	MIG	
DAIKOWM 2CrMoS ER90S-G	MIG	
G-TECH 2CrMo E9018-B3 Carton	MMA	**TDS**
DAIKOFCW 2CrMoB E90T5-M21PY-B3	Cored Wire	
DAIKOWS 2CrMo EB3 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

CREEP-RESISTANT STEELS

5CrMo

For compatible 5Cr-Mo process and pressure steels.

DAIKOWT 5CrMo ER80S-B6	TIG	
DAIKOWM 5CrMo ER80S-B6	MIG	
G-TECH 5CrMo E8015-B6/E8016-B6	MMA	
DAIKOFCW 5CrMo E81T1-B6C/M BS300 spool	Cored Wire	**TDS**
DAIKOWS 5CrMo EB6 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

CREEP-RESISTANT STEELS

9CrMo

For matching 9Cr-Mo high-temperature steels.

DAIKOWT 9CrMo ER80S-B8	TIG	
DAIKOWM 9CrMo ER80S-B8	MIG	
G-TECH 9CrMo E8015-B8 Carton	MMA	**TDS**
DAIKOFCW 9CrMo E81T1-B8	Cored Wire	
DAIKOWS 9CrMo EB8	SAW	

HIGH-YIELD-STRENGTH STEELS

100ksi

High-strength steel fabrication to specified strength.

DAIKOWT NiMo ER100S-G	TIG	
DAIKOWM NiMo ER100S-G	MIG	
G-TECH 109 E10018-G	MMA	
DAIKOMCW 109	Cored Wire	
DAIKOWS S3NiMo EF3 Ø 2.0–4.0mm · K415 spool and drums	SAW	**TDS**

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

High-Yield-Strength Steels / Cryogenic Steels

HIGH-YIELD-STRENGTH STEELS

110ksi

Higher-strength fabrication and lifting equipment.

DAIKOWT 96 ER110S-G Ø 1.2–3.2mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 96 ER110S-G Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 96 E11018-M Carton	MMA	**TDS**
DAIKOFCW 115B E110T5 Ø 1.2–1.6mm · BS300 spool	Cored Wire	**TDS**
DAIKOFCW 97 E111T1-K3MJ	Cored Wire	
DAIKOFCW 97S E111T1-GM	Cored Wire	
DAIKOMCW 115 E111T15	Cored Wire	
DAIKOWS 700 EG	SAW	

HIGH-YIELD-STRENGTH STEELS

120ksi

High-strength joints where this strength class is specified.

DAIKOWT 120 ER120S-G	TIG	
DAIKOWM 120 ER120S-G	MIG	
G-TECH 120 E12018-G Carton	MMA	**TDS**
DAIKOFCW 120B E120T5	Cored Wire	
DAIKOMCW 120 E120T15	Cored Wire	

HIGH-YIELD-STRENGTH STEELS

80-90ksi

Strength and toughness for specified structural grades.

DAIKOWT D2 ER80S-D2(1	TIG	
DAIKOWM D2 ER80S-D2 Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 80G E8018-G	MMA	
G-TECH 90G E9018-G	MMA	
DAIKOWS MnMo EA3	SAW	

CRYOGENIC STEELS

1Ni

Nickel-bearing fillers for cold-service steels.

DAIKOWT 1Ni ER80S-NI1	TIG
DAIKOWM 1Ni ER80S-NI1	MIG
G-TECH 1Ni E8018-C3	MMA
DAIKOFCW 1NiB E80T5-NI1	Cored Wire
DAIKOFCW 1Ni E81T1-M21A8-NI1-H4	Cored Wire
DAIKOMCW 1Ni EN ISO 17632-A T 50 6 1Ni M M 1	Cored Wire
DAIKOWS 1Ni ENI1	SAW

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Cryogenic Steels / High-Temperature Alloys / Copper Alloys

CRYOGENIC STEELS

2Ni

Nickel-bearing fillers for compatible low-temperature steels.

DAIKOWT 2Ni ER80S-NI2	TIG	
DAIKOWM 2Ni ER80S-NI2 Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	TDS
G-TECH 2Ni E8018-C1 Carton	MMA	TDS
DAIKOWS 2Ni ENI2	SAW	

CRYOGENIC STEELS

3Ni

For specified low-temperature steel applications.

DAIKOWT 3Ni ER80S-NI3 Ø 1.2–3.2mm · 5kg carton tube	TIG	TDS
DAIKOWM 3Ni ER80S-NI3	MIG	
G-TECH 3Ni E8018-C2 Carton	MMA	TDS
DAIKOFCW 3NiB EN ISO 17632-A T 46 10 3Ni B M 3 H5	Cored Wire	
DAIKOWS 3Ni ENI3 Ø 2.0–4.0mm · K415 spool and drums	SAW	TDS

HIGH-TEMPERATURE ALLOYS

253MA

Heat-resistant stainless fabrication and repair.

DAIKOWT 253MA EN ISO 14343-A 21 10 N	TIG	
DAIKOWM 253MA EN ISO 14343-A 21 10 N Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	TDS
G-TECH 253MA	MMA	

HIGH-TEMPERATURE ALLOYS

35.45

For compatible high-nickel furnace alloys.

DAIKOWT 35.45Nb	TIG	
DAIKOWM 35.45Nb	MIG	
G-TECH 35.45Nb EN ISO 3581-A EZ 35 45 Nb B 32 Carton	MMA	TDS

HIGH-TEMPERATURE ALLOYS

800/800H

For compatible 800 and 800H heat-resistant alloys.

DAIKOWT 21.33MnNb Ø 1.6–3.2mm · 5kg carton tube	TIG	TDS
DAIKOWM 21.33MnNb Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	TDS
G-TECH 800Nb EN ISO 3581-A EZ 21 32 MnNb B 32 Werkstoff Number ~ 1.4850 Carton	MMA	TDS
DAIKOWS 21.33MnNb Ø 2.0–4.0mm · K415 spool and drums	SAW	TDS

COPPER ALLOYS

Cu

Compatible pure copper joining and overlays.

DAIKOWT CuSn ERCU	TIG
DAIKOWM CuSn ERCU	MIG
G-TECH CuSn ECU	MMA

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Copper Alloys / Magnesium Alloys / Titanium Alloys

COPPER ALLOYS

CuAl

Aluminium-bronze joining and specified surfacing.

DAIKOWT CuAl8 ERCUAL-A1 5kg carton tube	TIG	**TDS**
DAIKOWT CuAl9Fe ERCUAL-A2 Ø 1.6–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM CuAl9Fe ERCUAL-A2	MIG	
DAIKOWM CuAl8 ERCUAL-A1	MIG	
G-TECH 405 ECUAL-A2 Carton	MMA	**TDS**
G-TECH 401 ECUAL-8	MMA	

COPPER ALLOYS

CuNi 70-30

For compatible 70/30 copper-nickel applications.

DAIKOWT 413 ERCUNI Ø 1.6–4.0mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 413 ERCUNI	MIG	
DAIKO 187 ECUNI Carton	MMA	**TDS**
G-TECH 413 ECUNI Carton	MMA	**TDS**
DAIKOSTRIP 413 EQCUNI	ESW / SAW	

COPPER ALLOYS

CuNi 90-10

For compatible 90/10 copper-nickel applications.

DAIKOWT 412	TIG	
DAIKOWM 412 ERCUNI Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**

COPPER ALLOYS

CuSi

Silicon-bronze joining and specified brazing work.

DAIKOWT CuSi3 ERCUSI-A	TIG	
DAIKOWM CuSi3 ERCUSI-A	MIG	

MAGNESIUM ALLOYS

Alloy AZ61A

Matching magnesium-alloy filler applications.

DAIKOWT MG 92-8	TIG	

TITANIUM ALLOYS

Gr. 1

Titanium filler for the corresponding parent alloy and procedure.

DAIKOWT Ti 1 ERTI-1 Ø 1.0–2.4mm	TIG	**TDS**
DAIKOWM Ti 1 ERTI-1	MIG	

TITANIUM ALLOYS

Gr. 2

Titanium filler for the corresponding parent alloy and procedure.

DAIKOWT Ti 2 ERTI-2	TIG	
DAIKOWM Ti 2 ERTI-2 Ø 0.8–1.6mm	MIG	**TDS**

TITANIUM ALLOYS

Gr. 12

Titanium filler for the corresponding parent alloy and procedure.

DAIKOWM Ti 12 ERTI-12 Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Titanium Alloys / Cobalt Alloys

TITANIUM ALLOYS

Gr. 5

Titanium filler for the corresponding parent alloy and procedure.

DAIKOWT Ti 5 ERTI-5 Ø 1.0–2.4mm · 5kg carton tube	TIG	**TDS**
DAIKOWM Ti 5 ERTI-5	MIG	

TITANIUM ALLOYS

Gr. 7

Titanium filler for the corresponding parent alloy and procedure.

DAIKOWT Ti 7 ERTI-7 Ø 1.0–2.4mm · 5kg carton tube	TIG	**TDS**
DAIKOWM Ti 7 ERTI-7	MIG	

COBALT ALLOYS

Gr. 1

For specified cobalt-alloy overlays and wear surfaces.

DAIKOWT 1010 ERCOCR-C	TIG	
DAIKOWM 1010 ECOCR-C Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 1010 ECOCR-C	MMA	
DAIKOFCW 1010	Cored Wire	

COBALT ALLOYS

Gr. 12

For specified cobalt-alloy overlays and wear surfaces.

DAIKOWT 1008 ERCOCR-B	TIG	
DAIKOWM 1008	MIG	
G-TECH 1008 ECOCR-B	MMA	
DAIKOFCW 1008	Cored Wire	

COBALT ALLOYS

Gr. 21

For specified cobalt-alloy overlays and wear surfaces.

DAIKOWT 1021 ERCOCR-E	TIG	
DAIKOWM 1021	MIG	
G-TECH 1021 ECOCR-E	MMA	
DAIKOFCW 1021	Cored Wire	

COBALT ALLOYS

Gr. 25

For specified cobalt-alloy overlays and wear surfaces.

DAIKOWT 1025	TIG	
DAIKOWM 1025	MIG	
G-TECH 1025 EN ISO 14700 E Z Co1 (L 605) Carton	MMA	**TDS**
DAIKOFCW 1025	Cored Wire	

COBALT ALLOYS

Gr. 6

For specified cobalt-alloy overlays and wear surfaces.

DAIKOWT 1006 ERCOCR-A	TIG	
DAIKOWM 1006	MIG	
G-TECH 1006	MMA	
DAIKOFCW 1006	Cored Wire	
DAIKOFCW 1006LC	Cored Wire	

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Alloy & Grade Directory

Cast Iron / Carbon Steels

CAST IRON

Ni CI

Nickel-deposit options for cast-iron repairs.

DAIKOWT 324	TIG	
DAIKOWT 99 ERNI-CI 5kg carton tube	TIG	**TDS**
DAIKOWM 324	MIG	
DAIKOWM 99 ERNI-CL	MIG	
G-TECH 324 ENI-CL	MMA	
G-TECH 99 ENI-CL	MMA	

CAST IRON

NiFe-CI

Nickel-iron deposits for compatible casting repairs.

DAIKOWT 55 ERNIFE-CI	TIG	
DAIKOWT 323S	TIG	
DAIKOWT 323	TIG	
DAIKOWM 55 ERNIFE-CL Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
DAIKOWM 323S	MIG	
DAIKOWM 323	MIG	
G-TECH 323S ENIFE-CL	MMA	
G-TECH 323 ENIFE-CL Carton	MMA	**TDS**
G-TECH 55 ENIFE-CL	MMA	
DAIKOFCW 321	Cored Wire	
DAIKOFCW 323S	Cored Wire	

CAST IRON

NiFe-CI · Continued

DAIKOFCW 345 EN ISO 1071 T C NiFe T3-CI M21 Ø 1.0–1.6mm · BS300, D200 spools	Cored Wire	**TDS**

CARBON STEELS

Structural Steel

Production welding, structural fabrication and flux selection.

DAIKOWT S2	TIG
DAIKOWT SG1	TIG
DAIKOWT SG2 HQ	TIG
DAIKOWT SG3 HQ	TIG
DAIKOWM SG1	MIG
DAIKOWM SG2 HQ	MIG
DAIKOWM S2	MIG
DAIKOWM SG3 HQ	MIG
G-TECH 102 E6013	MMA
G-TECH 108 E7018	MMA
G-TECH 107B E7018.1	MMA

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Carbon Steels

Separate structural and weathering steels. Check wire and flux compatibility on submerged arc work.

CARBON STEELS

Structural steel · continued

G-TECH 107HR E7028	MMA	
G-TECH 107 E7016	MMA	
G-TECH 107/S	MMA	
G-TECH 102HR E7024	MMA	
G-TECH 103 E6013	MMA	
G-TECH 101C E6010	MMA	
G-TECH 102C E7010-G	MMA	
DAIKOMCW 107S E7OC-6M	Cored Wire	
DAIKOFCW 107B E70T5	Cored Wire	
DAIKOMCW 107SP E70C-6M Ø 1.0–1.6mm · BS300, D200 spools	Cored Wire	**TDS**
DAIKOFCW 102R E71T1	Cored Wire	

CARBON STEELS

Structural steel · continued

DAIKOMCW 107LF E7OC-6M	Cored Wire	
DAIKOFCW 102SP E71T1M	Cored Wire	
DAIKOFCW 102S E71T1	Cored Wire	
DAIKOFCW 107OP E71T-GS	Cored Wire	
DAIKOMCW 107 E70C-6MH4 Ø 1.0–1.6mm · BS300, D200 spools	Cored Wire	**TDS**
DAIKOFLUX 470-W	SAW	
DAIKOWS S2 EM12K	SAW	
DAIKOWS S2Si EM12K	SAW	
DAIKOWS S4 EH14	SAW	
DAIKOWS S3Si EH12K	SAW	
DAIKOFLUX 480-W	SAW	

CARBON STEELS

Structural steel · continued

DAIKOFLUX 490-W	SAW	

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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GRADE REFERENCES & TECHNICAL DATA

Carbon Steels

Separate structural and weathering steels. Check wire and flux compatibility on submerged arc work.

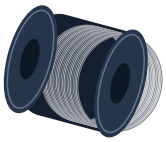
CARBON STEELS

Weathering Steel

For compatible weathering steel fabrication.

DAIKOWT 66 ER80S-G Ø 1.2–3.2mm · 5kg carton tube	TIG	**TDS**
DAIKOWM 66 ER80S-G Ø 0.8–1.6mm · Drums, B300, D200 and D100 spools	MIG	**TDS**
G-TECH 57B E8018-W2	MMA	
DAIKOFCW 66B E80T5	Cored Wire	
DAIKOFCW 66R E81T1-WC2 Ø 1.0–1.6mm · BS300, D200 spools	Cored Wire	**TDS**
DAIKOMCW 66 E81T15	Cored Wire	
DAIKOWS 66 EG Ø 2.0–4.8mm · K415 spool and drums	SAW	**TDS**

Specify the Full Format



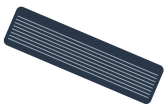
Wire & Spool

Give the wire diameter, spool or drum format and net weight.



Cut Rod

Give the rod diameter, cut length and pack weight.



Strip or SAW Wire

Give the strip width and thickness or the wire diameter. Specify the matched flux separately.

Quote the process, full grade reference, diameter and quantity.

Manufacturer literature

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