HYUNDAI WELDING

Electrodes, cored wire and solid filler metals



Find the Right Filler

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Ordering & Technical Support

Quote the order code, diameter and pack size. Include the cut length for electrodes and TIG rods.

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HYUNDAI WELDING

Carbon Steel Electrodes

Select rutile for everyday fabrication, cellulosic for a qualified open-root procedure, and low-hydrogen grades where toughness or hydrogen control matters.

S-6013.LF · E6013



Light steel fabrication, thin plate and repair. The rutile coating helps with restrikes and slag removal.

EN ISO 2560-A E38 0 R 1 2 · AC or DC+

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10006173	2.6mm	350mm	5kg
HY-10006174	3.2mm	350mm	5kg
HY-10006176	4.0mm	350mm	5kg
HY-10006177	5.0mm	450mm	5kg
HY-10006236	2.6mm	350mm	2.5kg
HY-10006237	3.2mm	350mm	2.5kg

Technical datasheet

S-6010.D · E6010



Cellulosic electrode for qualified open-root pipe procedures.

EN ISO 2560-A E38 0 C 2 1 · DC+ · pipe root and positional work

Positions: 1G, 2F, 3G and 4G · pipe 5G up and down

Order reference	Diameter	Cut length	Pack
HY-10002924	2.6mm	350mm	5kg
HY-10000018	3.2mm	350mm	5kg
HY-10000021	4.0mm	400mm	5kg

Product specifications

S-7016.O · E7016



Basic electrode for one-sided welding where the procedure calls for E7016.

EN ISO 2560-A E42 2 B 1 2

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10000140	3.2mm	350mm	5kg
HY-10000143	4.0mm	400mm	5kg

Product specifications

S-7018.1H · E7018-1 H4R



Structural and offshore work where low-temperature toughness and hydrogen control are specified.

EN ISO 2560-A E42 4 B 3 2 H5 · AC or DC+

Positions: 1G, 2F, 3G and 4G

1.5kg vacuum packs in 2.6mm, 3.2mm and 4.0mm.

Order reference	Diameter	Cut length	Pack
HY-10004092	2.6mm	350mm	1.5kg
HY-10000249	3.2mm	350mm	1.5kg
HY-10004328	4.0mm	350mm	1.5kg

Technical datasheet

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HYUNDAI WELDING

Carbon Steel Electrodes (cont.)

Select rutile for everyday fabrication, cellulosic for a qualified open-root procedure, and low-hydrogen grades where toughness or hydrogen control matters.

S-7018.G · E7018



Structural fabrication with a low-hydrogen, iron-powder electrode.

EN ISO 2560-A E42 3 B 1 2 · AC or DC+

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10000160	2.6mm	350mm	5kg
HY-10000166	3.2mm	350mm	5kg
HY-10000176	4.0mm	400mm	5kg
HY-10000180	5.0mm	400mm	5kg

Technical datasheet

S-7024.F · E7024



High-deposition flat and horizontal fillets.

EN ISO 2560-A E42 0 RR 7 4 · flat and horizontal fillets · AC or electrode-positive DC

Order reference	Diameter	Cut length	Pack
HY-10004575	2.6mm	400mm	5kg
HY-10000118	3.2mm	400mm	5kg
HY-10000121	4.0mm	450mm	5kg
HY-10000125	5.0mm	450mm	5kg

Technical datasheet

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HYUNDAI WELDING

Stainless Steel Electrodes

Select 308L for compatible 304/304L, 309L for specified stainless-to-steel joints, and 316L for compatible molybdenum-bearing stainless.

S-308L-17 · E308L-17



Compatible 304 and 304L stainless steel fabrications.

EN ISO 3581-A E 19 9 L R · AC, electrode-positive DC or electrode-negative DC

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10003721	2.5mm	350mm	2.5kg
HY-10003722	3.2mm	350mm	2.5kg
HY-10003723	4.0mm	350mm	2.5kg
HY-10004216	5.0mm	350mm	2.5kg

Product specifications

S-309L-17 · E309L-17



Join stainless steel to carbon steel where the procedure specifies 309L.

EN ISO 3581-A E 23 12 L R · AC, electrode-positive DC or electrode-negative DC

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10003708	2.5mm	300mm	2.5kg
HY-10003709	3.2mm	350mm	2.5kg
HY-10003733	4.0mm	350mm	2.5kg

Product specifications

S-316L-17 · E316L-17



Compatible molybdenum-bearing stainless steels such as 316L.

EN ISO 3581-A E 19 12 3 L R · AC, electrode-positive DC or electrode-negative DC

Positions: 1G, 2F, 3G and 4G

Order reference	Diameter	Cut length	Pack
HY-10003753	3.2mm	350mm	2.5kg
HY-10003684	4.0mm	350mm	2.5kg

Product specifications

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HYUNDAI WELDING

Steel Flux-Cored Wires

Check the grade’s shielding gas and positional classification. Use self-shielded wire where the approved procedure calls for operation without external gas.

SL-71MAG · E71T-1M/-9M H4



All-position low-hydrogen wire for structural steel, shipbuilding and offshore fabrication.

EN ISO 17632-A T46 4 P M21 1 H5

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-30004616	1.2mm	15kg

Technical datasheet

Supercored 71 MAG



All-position wire for general and structural fabrication. A smooth arc and low spatter help reduce cleanup.

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10001833	1.2mm	15kg

Technical datasheet

SC-71LHM · E71T-1M/-9M



All-position low-hydrogen wire for structural fabrication. Fast-freezing slag helps control the pool out of position.

EN ISO 17632-A T46 3 P M21 1 H5

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10001847	1.2mm	

Technical datasheet

Supercored 81 MAG



All-position nickel-bearing wire for higher-strength steel when low-temperature toughness is specified.

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10002136	1.2mm	15kg

Product specifications

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HYUNDAI WELDING

Steel Flux-Cored Wires (cont.)

Check the grade’s shielding gas and positional classification. Use self-shielded wire where the approved procedure calls for operation without external gas.

Supershield 11 · E71T-11



All-position self-shielded wire for thin plate, light fabrication and short assembly welds.

EN ISO 17632-A T42 Z Z NO 1

No external shielding gas · DC−

Order reference	Diameter	Pack
HY-10002285	1.2mm	15kg

Technical datasheet

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HYUNDAI WELDING

Stainless Flux-Cored Wires

Match the filler to the joint metallurgy, then check the Supercored or SW datasheet for shielding gas and welding positions.

Supercored 308L



High-deposition wire for flat welds and horizontal fillets on 304 and 304L stainless steel.

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004311	1.2mm	15kg

Technical datasheet

Supercored 309L



High-deposition wire for flat welds and horizontal fillets on dissimilar steel joints and stainless overlay buffer layers.

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004315	0.9mm	15kg
HY-10004319	1.2mm	15kg

Technical datasheet

Supercored 316L



High-deposition wire for flat welds and horizontal fillets on 316 and 316L stainless steel.

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004300	0.9mm	15kg
HY-10004304	1.2mm	15kg

Technical datasheet

SW-308L · E308LT1-1/-4



All-position wire for 304 and 304L stainless steel fabrication.

EN ISO 17633-A T 19 9 L P M21/C1 2

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004541	1.2mm	15kg

Technical datasheet

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HYUNDAI WELDING

Stainless Flux-Cored Wires (cont.)

Match the filler to the joint metallurgy, then check the Supercored or SW datasheet for shielding gas and welding positions.

SW-309L



All-position wire for stainless-to-carbon or low-alloy steel joints and for buffer layers under stainless overlays.

AWS E309LT1-1/-4

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004524	1.2mm	15kg

Technical datasheet

SW-316L



All-position wire for 316 and 316L stainless steel fabrication, including vertical-up and overhead joints.

AWS E316LT1-1/-4

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10004542	1.2mm	15kg

Technical datasheet

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HYUNDAI WELDING

Solid MIG, TIG & Metal-Cored Wire

Use solid MIG for general steel fabrication, TIG rod for controlled manual deposition, and metal-cored wire where the process can use its higher deposition potential.

ST-50.6 · ER70S-6



Carbon-steel TIG welding with argon shielding.

EN ISO 636-A W3Si1 · 100% argon · DC−

Order reference	Diameter	Cut length	Pack
HY-10001267	2.4mm	1000mm	5kg
HY-10001270	3.2mm	1000mm	5kg

Technical datasheet

SM-70



Solid wire for general mild-steel MIG/MAG fabrication.

Order reference	Diameter	Pack
HY-30005277	0.8mm	15kg
HY-10001014	1.0mm	15kg
HY-10001038	1.2mm	15kg

Technical datasheet

SM-70MT Endless Ballpac



Continuous wire feeding in production cells.

Order reference	Diameter	Pack
HY-10007754	1.0mm	250kg drum

Technical datasheet

Eco Plus II Ballpac



Bulk feed for production welding. Verify the consumable grade against the procedure.

Order reference	Diameter	Pack
HY-10010786	1.0mm	300kg drum

Product specifications

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HYUNDAI WELDING

Solid MIG, TIG & Metal-Cored Wire (cont.)

Use solid MIG for general steel fabrication, TIG rod for controlled manual deposition, and metal-cored wire where the process can use its higher deposition potential.

SC-70ML · E70C-6M



All-position metal-cored wire for structural and heavy equipment fabrication. High deposition with minimal slag.

EN ISO 17632-A T46 4 M M21 2 H5

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10002085	1.2mm	15kg

Product specifications

SC-70T · E70C-3C / E70C-6M



All-position metal-cored wire for thin-plate fabrication, with high deposition and low slag coverage.

100% CO2 or Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10002006	1.6mm	15kg

Product specifications

Supercored 70NS



Flat-position metal-cored wire for high-deposition structural and heavy equipment fabrication, with minimal slag coverage.

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10002023	1.2mm	15kg

Technical datasheet

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HYUNDAI WELDING

Submerged Arc & Hardfacing

Order submerged-arc wire and flux as a qualified combination. For hardfacing, specify the substrate and whether the dominant wear is abrasion, impact or a combination.

M-12K



Submerged-arc welding with the qualified flux and procedure.

Order reference	Diameter	Pack
HY-10001496	2.4mm	25kg
HY-10001506	3.2mm	25kg
HY-10001522	4.0mm	25kg

Product specifications

S-717



Submerged-arc flux for the specified wire and procedure.

Order reference	Diameter	Pack
HY-10001633	—	20kg

Product specifications

SC-600HM



Metal-cored hardfacing wire for abrasion on rollers, shear blades and screw conveyors. Flat and horizontal fillets.

Ar + 20–25% CO2 · DC+

Order reference	Diameter	Pack
HY-10002335	1.2mm	15kg

Technical datasheet

Supershield CrCW



Self-shielded chromium-carbide hardfacing wire for wear plates, screw conveyors and bucket teeth.

No external shielding gas · DC+

53–56 HRC at 1.2mm after at least four layers

Order reference	Diameter	Pack
HY-10002379	1.2mm	

Technical datasheet

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