PARWELD XP & WELDIBER

Welding consumables

Range & ordering guide

For fabrication, maintenance & repair



SELECT BY PROCESS & APPLICATION

Find your process below, then use the material headings to find the right grade, size and pack.

Process	Application	Codes	Pages
MIG/MAG wire	Solid wire for workshop fabrication and specialist alloys.	143	**2–10**
Cored wire	Self-shielded, gas-shielded and metal-cored options.	29	**11–13**
TIG filler rods	From general steel and stainless to specialist alloys.	178	**14–23**
MMA electrodes	Stick electrodes for general steelwork and higher deposition.	12	**24**
Brazing & oxy-fuel	Silver and copper brazing alloys, gas-welding rods and flux powders.	48	**25–27**
Tungsten electrodes	TIG electrodes by composition, tip colour, diameter and length.	144	**28–29**
Weldiber	SG2 MIG/MAG wire and E6013 stick electrodes.	6	**30**

NEED HELP SELECTING A CONSUMABLE?

Send us the parent material, process and service conditions. We can help with grade selection, pricing and availability.

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

MILD STEEL

2Si (ER 70S-3)

EN ISO 14341-A: G 42 4 M21 2Si | AWS A5.18: ER70S-3

Filler for carbon and carbon-manganese steels.

Use for: General fabrication and steelwork to the specified grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP10290	0.8	15 kg · BS300
XP10293	1.0	15 kg · BS300
XP10296	1.2	15 kg · BS300



Technical datasheet

MILD STEEL

2Ti (ER 70S-2)

EN ISO 14341-A: G 42 3 M21 2Ti | AWS A5.18: ER70S-2

Triple-deoxidised filler for carbon steel.

Use for: Carbon and C-Mn steels where extra deoxidising capacity is specified.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP10278	0.8	15 kg · BS300
XP10281	1.0	15 kg · BS300
XP10284	1.2	15 kg · BS300



Technical datasheet

MILD STEEL

SG2 (G3Si1)

EN ISO 14341-A: G 42 3 C1 3Si1 / G 42 4 M21 3Si1 | AWS A5.18: ER70S-6

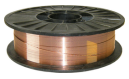
Solid steel filler for fabrication.

Use for: Mild and C-Mn steel joints to the specified wire grade.

Shielding gas: C1, M21 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP10200	0.6	1 kg
XP10209	0.6	5 kg
XP10244	0.6	15 kg · BASKET
XP10203	0.8	1 kg
XP10212	0.8	5 kg
XP10236	0.8	250 kg · DRUM
XP10245	0.8	15 kg · BASKET
XP10206	1.0	1 kg
XP10215	1.0	5 kg
XP10239	1.0	250 kg · DRUM
XP10246	1.0	15 kg · BASKET
XP10218	1.2	5 kg
XP10242	1.2	250 kg · DRUM
XP10247	1.2	15 kg · BASKET
XP10248	1.6	15 kg · BASKET



Technical datasheet

MILD STEEL

SG2 CF

EN ISO 14341-A: G 42 3 C1 3Si1 / G 42 4 M21 3Si1 | AWS A5.18: ER70S-6

Copper-free solid MAG wire for mild steel.

Use for: General fabrication where a copper-free wire is preferred.

Shielding gas: C1, M21 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP12205	0.8	15 kg
XP12210	1.0	15 kg
XP12220	1.0	250 kg · DRUM
XP12215	1.2	15 kg
XP12225	1.2	250 kg · DRUM



Technical datasheet

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

MILD STEEL

SG3 (G4Si1)

EN ISO 14341-A: G 42 3 C1 4Si1 / G 46 4 M21 4Si1 | AWS A5.18: ER70S-6

Solid steel filler for fabrication.

Use for: Mild and C-Mn steel joints to the specified wire grade.

Shielding gas: C1, M21 | DC+

Part number	Size mm	Pack / format
XP10254	0.8	15 kg · BASKET
XP10266	0.8	250 kg · DRUM
XP10257	1.0	15 kg · BASKET
XP10269	1.0	250 kg · DRUM
XP10260	1.2	15 kg · BASKET
XP10272	1.2	250 kg · DRUM



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 307Si

EN ISO 14343-A: G 18 8 Mn | AWS A5.9: ~ER307

Stainless filler for controlled weld-metal composition.

Use for: Stainless fabrication to the parent grade and welding procedure.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30200	0.8	15 kg · BS300
XP30202	1.0	15 kg · BS300
XP30204	1.2	15 kg · BS300



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 308LSi

EN ISO 14343-A: G 19 9 L Si | AWS A5.9: ER308LSi

Low-carbon stainless filler for 18/8 grades.

Use for: 304 and 304L stainless fabrication.

Shielding gas: M12, M13 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP30205	0.6	1 kg
XP30208	0.6	5 kg
XP30206	0.8	1 kg
XP30210	0.8	5 kg
XP30216	0.8	15 kg · BS300
XP30207	1.0	1 kg
XP30212	1.0	5 kg
XP30218	1.0	15 kg · BS300
XP30220	1.2	15 kg · BS300



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 309LSi

EN ISO 14343-A: G 23 12 L Si | AWS A5.9: ER309LSi

Higher chromium and nickel content for dissimilar joints.

Use for: Stainless-to-carbon steel joints where 309L is specified.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30226	0.8	15 kg · BS300
XP30228	1.0	15 kg · BS300
XP30230	1.2	15 kg · BS300



Technical datasheet

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

STAINLESS & DISSIMILAR STEELS

ER 310

EN ISO 14343-A: G 25 20 | AWS A5.9: ER310

Stainless filler for controlled weld-metal composition.

Use for: Stainless fabrication to the parent grade and welding procedure.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30236	0.8	15 kg · BS300
XP30238	1.0	15 kg · BS300
XP30240	1.2	15 kg · BS300



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 312

EN ISO 14343-A: G 29 9 | AWS A5.9: ER312

High-chromium stainless filler for difficult joints.

Use for: Dissimilar steel and repair joints where the procedure specifies 312.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30244	0.8	15 kg · BS300
XP30246	1.0	15 kg · BS300
XP30248	1.2	15 kg · BS300



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 316LSi

EN ISO 14343-A: G 19 12 3 L Si | AWS A5.9: ER316LSi

Low-carbon, molybdenum-bearing stainless filler.

Use for: 316 and 316L stainless fabrication to the service specification.

Shielding gas: M12, M13 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP30250	0.6	5 kg · S200
XP30265	0.6	1 kg
XP30252	0.8	5 kg · S200
XP30260	0.8	15 kg · BS300
XP30266	0.8	1 kg
XP30254	1.0	5 kg · S200
XP30262	1.0	15 kg · BS300
XP30267	1.0	1 kg
XP30264	1.2	15 kg · BS300



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 347Si

EN ISO 14343-A: G 19 9 Nb Si | AWS A5.9: ER347Si

Niobium-stabilised stainless filler.

Use for: Matching stabilised austenitic stainless grades.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30268	0.8	15 kg · BS300
XP30270	1.0	15 kg · BS300
XP30272	1.2	15 kg · BS300



Technical datasheet

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

STAINLESS & DISSIMILAR STEELS

ER 410

EN ISO 14343-A: G 13 | AWS A5.9: ER410

Stainless filler for controlled weld-metal composition.

Use for: Stainless fabrication to the parent grade and welding procedure.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30274	0.8	15 kg · BS300
XP30276	1.0	15 kg · BS300
XP30278	1.2	15 kg · BS300



Technical datasheet

DUPLEX & SUPER DUPLEX

ER 2209 DUPLEX

EN ISO 14343-A: G 22 9 3 N L | AWS A5.9: ER2209

Stainless filler for duplex grades.

Use for: Matching duplex or super-duplex fabrication to the specified grade.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30280	1.0	15 kg · BS300
XP30283	1.2	15 kg · BS300



Technical datasheet

DUPLEX & SUPER DUPLEX

ER 2594S SUPER DUPLEX

EN ISO 14343-A: G Z 25 9 4 N L W | AWS A5.9: ER2594

Stainless filler for duplex grades.

Use for: Matching duplex or super-duplex fabrication to the specified grade.

Shielding gas: M12, M13 | DC+

Part number	Size mm	Pack / format
XP30288	1.0	15 kg · BS300
XP30291	1.2	15 kg · BS300



Technical datasheet

HIGH STRENGTH

100 (ER 100S-G)

EN ISO 16834-A: G 55 5 M21 Mn3NiCrMo | AWS A5.28: ER100S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15254	0.8	15 kg · BS300
XP15257	1.0	15 kg · BS300
XP15260	1.2	15 kg · BS300



Technical datasheet

HIGH STRENGTH

110 (ER 110S-G)

EN ISO 16834-A: G 69 4 M21 Mn3Ni1CrMo | AWS A5.28: ER110S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15263	0.8	15 kg · BS300
XP15266	1.0	15 kg · BS300
XP15269	1.2	15 kg · BS300



Technical datasheet

HIGH STRENGTH

120 (ER 120S-G)

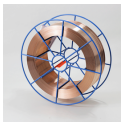
EN ISO 16834-A: G 89 4 M21 Mn4Ni2, 5CrMo | AWS A5.28: ER120S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15272	0.8	15 kg · BS300
XP15275	1.0	15 kg · BS300
XP15278	1.2	15 kg · BS300



Technical datasheet

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

HEAT RESISTING

2Mo (ER 70S-A1)

EN ISO 14341-A: G 50 4 M21 2Mo | AWS A5.28: ER70S-A1

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15200	0.8	15 kg · BS300
XP15201	1.0	15 kg · BS300
XP15202	1.2	15 kg · BS300



Technical datasheet

HEAT RESISTING

4Mo (ER 80S-D2)

EN ISO 14341-A: G 50 2 M21 4Mo | AWS A5.28: ER80S-D2

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15205	0.8	15 kg · BS300
XP15206	1.0	15 kg · BS300
XP15207	1.2	15 kg · BS300



Technical datasheet

HEAT RESISTING

CrMo1Si (ER 80S-G)

EN ISO 21952-A: G CrMo1Si | AWS A5.28: ER80S-G

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15209	0.8	15 kg · BS300
XP15212	1.0	15 kg · BS300
XP15215	1.2	15 kg · BS300



Technical datasheet

HEAT RESISTING

CrMo2Si (ER 90S-G)

EN ISO 21952-A: G CrMo2Si | AWS A5.28: ER90S-G

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15218	0.8	15 kg · BS300
XP15221	1.0	15 kg · BS300
XP15224	1.2	15 kg · BS300



Technical datasheet

LOW TEMPERATURE

Ni1 (ER 80S-Ni1)

EN ISO 14341-A: G 3Ni1 | AWS A5.28: ER80S-Ni1

Nickel-alloyed filler for low-temperature steelwork.

Use for: Joints with specified impact toughness at sub-zero temperatures.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15236	0.8	15 kg · BS300
XP15239	1.0	15 kg · BS300
XP15242	1.2	15 kg · BS300



Technical datasheet

LOW TEMPERATURE

Ni2 (ER 80S-Ni2)

EN ISO 14341-A: G 50 9 M23 2Ni2 | AWS A5.28: ER80S-Ni2

Nickel-alloyed filler for low-temperature steelwork.

Use for: Joints with specified impact toughness at sub-zero temperatures.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15245	0.8	15 kg · BS300
XP15248	1.0	15 kg · BS300
XP15251	1.2	15 kg · BS300



Technical datasheet

MIG/MAG WIRE / STEEL & IRON APPLICATIONS

WEATHERING STEEL

CORTEN (ER 80S-G)

EN ISO 14341-A: G 50 4 C1/M21 Z3Ni1 | AWS A5.28: ER80S-G

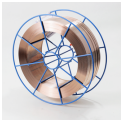
Filler for weathering steel.

Use for: Exposed structural steelwork where the procedure calls for a weathering grade.

Shielding gas: C1, M21 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP15226	0.8	5 kg · RND
XP15227	0.8	15 kg · BS300
XP15229	1.0	5 kg · RND
XP15230	1.0	15 kg · BS300
XP15233	1.2	15 kg · BS300



Technical datasheet

CAST IRON REPAIR

FN55 CAST (E NiFe-Cl)

Nickel-iron filler for cast iron.

Use for: Cast iron repairs using the specified preheat and welding procedure.

Part number	Size mm	Pack / format
XP35221	1.2	15 kg



Ask for technical data

HARDFACING

HF350 SOLID HARDFACING

DIN 8555: MSG 5-GZ-350

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP20206	1.2	15 kg · BS300



Technical datasheet

HARDFACING

HF600 SOLID HARDFACING

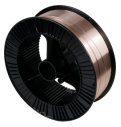
EN ISO 14700: S Fe 8 | DIN 8555: MSG 6-GZ-60-GP

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP20200	1.0	15 kg · BS300
XP20203	1.2	15 kg · BS300



Technical datasheet

HARDFACING

HF650 SOLID HARDFACING

DIN 8555: MSG 3-60

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP20209	1.2	15 kg · BS300



Technical datasheet

MIG/MAG WIRE / ALUMINIUM

ALUMINIUM

ER 1070 (Al99.7)

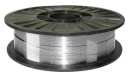
EN ISO 18273: S Al 1070 (Al99.7) | AWS A5.10: ER1070

High-purity aluminium filler.

Use for: Commercially pure aluminium where 1070 is specified.

Shielding gas: I1 | DC+

Part number	Size mm	Pack / format
XP25200	1.0	7 kg · BS300
XP25203	1.2	7 kg · BS300
XP25206	1.6	7 kg · BS300



Technical datasheet

ALUMINIUM

ER 4043 (AlSi5)

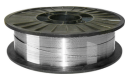
EN ISO 18273: S Al 4043 (AlSi5) | AWS A5.10: ER4043

Aluminium-silicon filler with good fluidity.

Use for: Compatible aluminium castings and wrought grades where AlSi5 is specified.

Shielding gas: I1 | DC+

Part number	Size mm	Pack / format
XP25209	0.8	0.5 kg · S100
XP25218	0.8	2 kg · S200
XP25227	0.8	7 kg · BS300
XP25212	1.0	0.5 kg · S100
XP25221	1.0	2 kg · S200
XP25230	1.0	7 kg · BS300
XP25215	1.2	0.5 kg · S100
XP25224	1.2	2 kg · S200
XP25233	1.2	7 kg · BS300



Technical datasheet

ALUMINIUM

ER 5183 (AlMg4.5Mn)

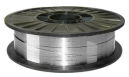
EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A)) | AWS A5.10: ER5183

Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1 | DC+

Part number	Size mm	Pack / format
XP25263	1.0	7 kg · BS300
XP25266	1.2	7 kg · BS300



Technical datasheet

ALUMINIUM

ER 5356 (AlMg5)

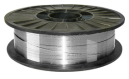
EN ISO 18273: S Al 5356 (AlMg5Cr(A)) | AWS A5.10: ER5356

Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1 | DC+

Part number	Size mm	Pack / format
XP25236	0.8	0.5 kg · S100
XP25245	0.8	2 kg · S200
XP25254	0.8	7 kg · BS300
XP25239	1.0	0.5 kg · S100
XP25248	1.0	2 kg · S200
XP25257	1.0	7 kg · BS300
XP25242	1.2	0.5 kg · S100
XP25251	1.2	2 kg · S200
XP25260	1.2	7 kg · BS300



Technical datasheet

MIG/MAG WIRE / ALUMINIUM

ALUMINIUM

ER 5556 (AlMg5Mn)

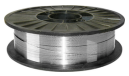
EN ISO 18273: S Al 5556 (AlMg5Mn1Ti(A)) | AWS A5.10: ER5556

Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1 | DC+

Part number	Size mm	Pack / format
XP25275	1.0	7 kg · BS300
XP25278	1.2	7 kg · BS300



Technical datasheet

MIG/MAG WIRE / OTHER NON-FERROUS ALLOYS

NICKEL ALLOYS

ALLOY 625 (NiCrMo-3)

EN ISO 18274: S Ni 6625 - NiCr22Mo9Nb | AWS A5.14: ERNiCrMo-3

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Shielding gas: I1, I3 | DC+

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP35204	1.0	15 kg · BS300
XP35206	1.2	15 kg · BS300
XP35208	1.2	Per kg



Technical datasheet

NICKEL ALLOYS

ALLOY 82 (NiCr-3)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35215	1.0	15 kg
XP35218	1.2	15 kg



Ask for technical data

COPPER ALLOYS

C9 (CuSi3Mn1)

EN ISO 24373: S Cu 6560 (CuSi3Mn1) | AWS A5.7: ERCuSi-A

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC+

Part number	Size mm	Pack / format
XP40205	0.8	5 kg · S200
XP40207	1.0	5 kg · S200
XP40210	1.0	15 kg · BS300
XP40212	1.2	15 kg · BS300



Technical datasheet

CORED WIRE / STEEL & IRON APPLICATIONS

MILD STEEL

70-MC SEAMLESS

EN ISO 17632-A: T 46 4 P M21 1 H5 | AWS A5.18: E70C-6M H4

Seamless metal-cored wire for gas-shielded welding.

Use for: General fabrication and steelwork to the specified grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15421	1.2	16 kg · BS300

Technical datasheet



MILD STEEL

71-RC SEAMLESS

EN ISO 17632-A: T 46 4 P M21 1 H5 | AWS A5.20: E71T-1M/T-9M H4

Seamless rutile flux-cored wire for gas-shielded welding.

Use for: General fabrication and steelwork to the specified grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15412	1.2	5 kg · S200
XP15415	1.2	16 kg · BS300

Technical datasheet



STAINLESS & DISSIMILAR STEELS

308L-T0 STAINLESS

Stainless cored wire for flat and horizontal welding.

Use for: 304 and 304L stainless fabrication.

Part number	Size mm	Pack / format
XP30422	1.2	15 kg

Ask for technical data



STAINLESS & DISSIMILAR STEELS

308L-T1 STAINLESS

Stainless cored wire for all-position welding.

Use for: 304 and 304L stainless fabrication.

Part number	Size mm	Pack / format
XP30424	1.2	15 kg

Ask for technical data



STAINLESS & DISSIMILAR STEELS

309L-T0 STAINLESS

Stainless cored wire for flat and horizontal welding.

Use for: Stainless-to-carbon steel joints where 309L is specified.

Part number	Size mm	Pack / format
XP30426	1.2	15 kg

Ask for technical data



STAINLESS & DISSIMILAR STEELS

309L-T1 STAINLESS

Stainless cored wire for all-position welding.

Use for: Stainless-to-carbon steel joints where 309L is specified.

Part number	Size mm	Pack / format
XP30428	1.2	15 kg

Ask for technical data



STAINLESS & DISSIMILAR STEELS

316L-T0 STAINLESS

Stainless cored wire for flat and horizontal welding.

Use for: 316 and 316L stainless fabrication to the service specification.

Part number	Size mm	Pack / format
XP30430	1.2	15 kg

Ask for technical data



STAINLESS & DISSIMILAR STEELS

316L-T1 STAINLESS

Stainless cored wire for all-position welding.

Use for: 316 and 316L stainless fabrication to the service specification.

Part number	Size mm	Pack / format
XP30432	1.2	15 kg

Ask for technical data



CORED WIRE / STEEL & IRON APPLICATIONS

HIGH STRENGTH

110-MC SEAMLESS

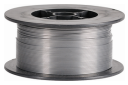
EN ISO 18276-A: T 69 4 Mn2NiMo M M21 1 H5 | AWS A5.28: E110C-K4 H4

Seamless metal-cored wire for gas-shielded welding.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15424	1.2	16 kg · BS300



Technical datasheet

HIGH STRENGTH

111-RC SEAMLESS

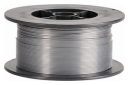
EN ISO 18276-A: T 69 4 Mn2NiMo P M21 1 H5 | AWS A5.29: E111T1-K3M H4

Seamless rutile flux-cored wire for gas-shielded welding.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15430	1.2	16 kg · BS300



Technical datasheet

LOW TEMPERATURE

81-RC SEAMLESS

EN ISO 17632-A: T 50 6 1Ni P M21 1 H5 | AWS A5.29: E81T1-Ni1M-J H4

Seamless rutile flux-cored wire for gas-shielded welding.

Use for: Joints with specified impact toughness at sub-zero temperatures.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP15418	1.2	16 kg · BS300



Technical datasheet

HARDFACING

DUR 55-O HARDFACING

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Part number	Size mm	Pack / format
XP20416	1.2	15 kg
XP20418	1.6	15 kg



Ask for technical data

HARDFACING

DUR 600 SEAMLESS HARDFACING

EN ISO 14700: T Fe8

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Shielding gas: M21 | DC+

Part number	Size mm	Pack / format
XP20410	1.2	5 kg · S200
XP20411	1.2	15 kg · BS300



Technical datasheet

SELF-SHIELDED

E71T-GS

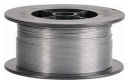
AWS A5.20: E71T-GS

Flux-cored wire that runs without an external gas supply.

Use for: General steelwork and site work within the wire's rated applications.

Shielding gas: not required | DC- * Confirm marked size or weight when ordering.

Part number	Size mm	Pack / format
XP10400*	0.8	0.5 kg · S100
XP10406	0.8	5 kg · S200
XP10403*	0.9	0.5 kg · S100
XP10409	0.9	5 kg · S200
XP10418	1.0	15 kg · S300



Technical datasheet

CORED WIRE / COBALT SURFACING

COBALT SURFACING

COBALT 1-G

Cobalt-based cored wire for specialist overlays.

Use for: Select by the specified wear, corrosion and service-temperature requirements.

Part number	Size mm	Pack / format
XP45402	1.2	13 kg
XP45408	1.6	13 kg



Ask for technical data

COBALT SURFACING

COBALT 12-G

Cobalt-based cored wire for specialist overlays.

Use for: Select by the specified wear, corrosion and service-temperature requirements.

Part number	Size mm	Pack / format
XP45426	1.2	13 kg
XP45432	1.6	13 kg



Ask for technical data

COBALT SURFACING

COBALT 21-G

Cobalt-based cored wire for specialist overlays.

Use for: Select by the specified wear, corrosion and service-temperature requirements.

Part number	Size mm	Pack / format
XP45438	1.2	13 kg
XP45444	1.6	13 kg



Ask for technical data

COBALT SURFACING

COBALT 6-G

Cobalt-based cored wire for specialist overlays.

Use for: Select by the specified wear, corrosion and service-temperature requirements.

Part number	Size mm	Pack / format
XP45414	1.2	13 kg
XP45420	1.6	13 kg



Ask for technical data

TIG FILLER RODS / STEEL & IRON APPLICATIONS

MILD STEEL

A15 (ER 70S-2)

EN ISO 636-A: W 2Ti | AWS A5.18: ER70S-2

Triple-deoxidised filler for carbon steel.

Use for: Carbon and C-Mn steels where extra deoxidising capacity is specified.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP10300	1.0 × 1000	5 kg · Tube
XP10303	1.2 × 1000	5 kg · Tube
XP10306	1.6 × 1000	5 kg · Tube
XP10309	2.0 × 1000	5 kg · Tube
XP10312	2.4 × 1000	5 kg · Tube
XP10315	3.2 × 1000	5 kg · Tube



Technical datasheet

MILD STEEL

A18 (ER 70S-6)

EN ISO 636-A: W 42 4 3Si1 | AWS A5.18: ER70S-6

Filler for carbon and carbon-manganese steels.

Use for: General fabrication and steelwork to the specified grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP10324	1.0 × 1000	5 kg · Tube
XP10327	1.2 × 1000	5 kg · Tube
XP10330	1.6 × 1000	5 kg · Tube
XP10333	2.0 × 1000	5 kg · Tube
XP10336	2.4 × 1000	5 kg · Tube
XP10339	3.2 × 1000	5 kg · Tube



Technical datasheet

MILD STEEL

SG1 (ER 70S-3)

EN ISO 636-A: W 42 4 2Si | AWS A5.18: ER70S-3

Filler for carbon and carbon-manganese steels.

Use for: General fabrication and steelwork to the specified grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP10346	1.6 × 1000	5 kg · Tube
XP10349	2.4 × 1000	5 kg · Tube
XP10352	3.2 × 1000	5 kg · Tube



Technical datasheet

MILD STEEL

SG3 (ER 70S-6)

EN ISO 636-A: W 4Si1 | AWS A5.18: ER70S-6

Solid steel filler for fabrication.

Use for: Mild and C-Mn steel joints to the specified wire grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP10358	1.6 × 1000	5 kg · Tube
XP10361	2.4 × 1000	5 kg · Tube
XP10364	3.2 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 307Si

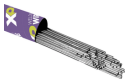
EN ISO 14343-A: W 18 8 Mn | AWS A5.9: ~ER307

Stainless filler for controlled weld-metal composition.

Use for: Stainless fabrication to the parent grade and welding procedure.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30304	1.6 × 1000	5 kg · Tube
XP30306	2.4 × 1000	5 kg · Tube
XP30308	3.2 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 308L

EN ISO 14343-A: W 19 9 L | AWS A5.9: ER308L

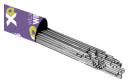
Low-carbon stainless filler for 18/8 grades.

Use for: 304 and 304L stainless fabrication.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP30310	1.0	5 kg
XP30312	1.2	5 kg
XP30314	1.6 × 1000	5 kg · Tube
XP30316	2.0	5 kg
XP30318	2.4 × 1000	5 kg · Tube
XP30320	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / STEEL & IRON APPLICATIONS

STAINLESS & DISSIMILAR STEELS

ER 309L

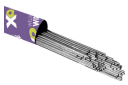
EN ISO 14343-A: W 23 12 L | AWS A5.9: ER309L

Higher chromium and nickel content for dissimilar joints.

Use for: Stainless-to-carbon steel joints where 309L is specified.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30330	1.6 × 1000	5 kg · Tube
XP30332	2.4 × 1000	5 kg · Tube
XP30336	3.2 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 310

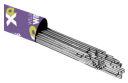
EN ISO 14343-A: W 25 20 | AWS A5.9: ER310

Stainless filler for controlled weld-metal composition.

Use for: Stainless fabrication to the parent grade and welding procedure.

Shielding gas: M12, M13 | DC-

Part number	Size mm	Pack / format
XP30342	1.6 × 1000	5 kg
XP30344	2.4 × 1000	5 kg
XP30346	3.2 × 1000	5 kg



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 312

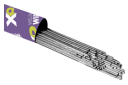
EN ISO 14343-A: W 29 9 | AWS A5.9: ER312

High-chromium stainless filler for difficult joints.

Use for: Dissimilar steel and repair joints where the procedure specifies 312.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30352	1.6 × 1000	5 kg · Tube
XP30354	2.4 × 1000	5 kg · Tube
XP30356	3.2 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 316L

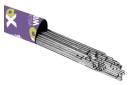
EN ISO 14343-A: W 19 12 3 L | AWS A5.9: ER316L

Low-carbon, molybdenum-bearing stainless filler.

Use for: 316 and 316L stainless fabrication to the service specification.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30362	0.8 × 1000	5 kg · Tube
XP30364	1.0 × 1000	5 kg · Tube
XP30366	1.2 × 1000	5 kg · Tube
XP30368	1.6 × 1000	5 kg · Tube
XP30370	2.0 × 1000	5 kg · Tube
XP30372	2.4 × 1000	5 kg · Tube
XP30374	3.2 × 1000	5 kg · Tube
XP30375	4.0 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 317L

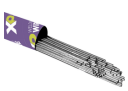
EN ISO 14343-A: W 18 15 3 L | AWS A5.9: ER317L

Low-carbon stainless filler with added molybdenum.

Use for: Matching 317L and specified corrosion-resistant stainless work.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30376	1.6 × 1000	5 kg · Tube
XP30377	2.4 × 1000	5 kg · Tube
XP30378	3.2 × 1000	5 kg · Tube



Technical datasheet

STAINLESS & DISSIMILAR STEELS

ER 347Si

EN ISO 14343-A: W 19 9 Nb Si | AWS A5.9: ER347Si

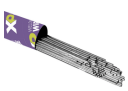
Niobium-stabilised stainless filler.

Use for: Matching stabilised austenitic stainless grades.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP30380	1.0	5 kg
XP30382	1.6 × 1000	5 kg · Tube
XP30384	2.4 × 1000	5 kg · Tube
XP30385	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / STEEL & IRON APPLICATIONS

DUPLEX & SUPER DUPLEX

ER 2209 DUPLEX

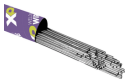
EN ISO 14343-A: W 22 9 3 N L | AWS A5.9: ER2209

Stainless filler for duplex grades.

Use for: Matching duplex or super-duplex fabrication to the specified grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30386	1.6 × 1000	5 kg · Tube
XP30388	2.4 × 1000	5 kg · Tube
XP30390	3.2 × 1000	5 kg · Tube



Technical datasheet

DUPLEX & SUPER DUPLEX

ER 2594 SUPER DUPLEX

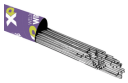
EN ISO 14343-A: W 25 9 4 N L | AWS A5.9: ER2594

Stainless filler for duplex grades.

Use for: Matching duplex or super-duplex fabrication to the specified grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP30392	1.6 × 1000	5 kg · Tube
XP30394	2.4 × 1000	5 kg · Tube
XP30396	3.2 × 1000	5 kg · Tube



Technical datasheet

HIGH STRENGTH

100 (ER 100S-G)

EN ISO 16834-A: W Mn3NiCrMo | AWS A5.28: ER100S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15350	1.6 × 1000	5 kg · Tube
XP15352	2.4 × 1000	5 kg · Tube
XP15354	3.2 × 1000	5 kg · Tube



Technical datasheet

HIGH STRENGTH

110 (ER 110S-G)

EN ISO 16834-A: W Mn3Ni1CrMo | AWS A5.28: ER110S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15358	1.6 × 1000	5 kg · Tube
XP15360	2.4 × 1000	5 kg · Tube
XP15362	3.2 × 1000	5 kg · Tube



Technical datasheet

HIGH STRENGTH

120 (ER 120S-G)

EN ISO 16834-A: W Mn4Ni2, 5CrMo | AWS A5.28: ER120S-G

Filler for high-strength steel weldments.

Use for: Structural work where the welding procedure specifies this strength grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15366	1.6 × 1000	5 kg · Tube
XP15368	2.4 × 1000	5 kg · Tube
XP15370	3.2 × 1000	5 kg · Tube



Technical datasheet

HEAT RESISTING

A30 (ER 70S-A1)

EN ISO 636-A: W 2Mo | AWS A5.28: ER70S-A1

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: I1 | DC- * Confirm marked size or weight when ordering.

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP15300*	1.0 × 1000	5 kg · Tube
XP15302*	1.2 × 1000	5 kg · Tube
XP15304*	1.6 × 1000	5 kg · Tube
XP15306	2.4	5 kg
XP15308	3.2	5 kg



Technical datasheet

TIG FILLER RODS / STEEL & IRON APPLICATIONS

HEAT RESISTING

A31 (ER 80S-D2)

EN ISO 636-A: W Z2Mo | AWS A5.28: ER80S-D2

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP15312	1.0	5 kg
XP15314	1.2	5 kg
XP15316	1.6 × 1000	5 kg · Tube
XP15318	2.4 × 1000	5 kg · Tube
XP15320	3.2 × 1000	5 kg · Tube



Technical datasheet

HEAT RESISTING

A32 (ER 80S-G)

EN ISO 21952-A: W CrMo1Si | AWS A5.28: ER80S-G

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP15324	1.0	5 kg
XP15326	1.2	5 kg
XP15328	1.6 × 1000	5 kg · Tube
XP15330	2.4 × 1000	5 kg · Tube
XP15332	3.2 × 1000	5 kg · Tube



Technical datasheet

HEAT RESISTING

A33 (ER 90S-G)

EN ISO 21952-A: W CrMo2Si | AWS A5.28: ER90S-G

Low-alloy filler for elevated-temperature service.

Use for: Boiler, pipework and process equipment to the specified alloy and procedure.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP15336	1.0	5 kg
XP15338	1.2	5 kg
XP15340	1.6 × 1000	5 kg · Tube
XP15342	2.4 × 1000	5 kg · Tube
XP15344	3.2 × 1000	5 kg · Tube



Technical datasheet

LOW TEMPERATURE

Ni1 (ER 80S-Ni1)

EN ISO 636: W 3Ni1 | AWS A5.28: ER80S-Ni1

Nickel-alloyed filler for low-temperature steelwork.

Use for: Joints with specified impact toughness at sub-zero temperatures.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15374	1.6 × 1000	5 kg · Tube
XP15376	2.4 × 1000	5 kg · Tube
XP15378	3.2 × 1000	5 kg · Tube



Technical datasheet

LOW TEMPERATURE

Ni2 (ER 80S-Ni2)

EN ISO 636-A: W 2Ni2 | AWS A5.28: ER80S-Ni2

Nickel-alloyed filler for low-temperature steelwork.

Use for: Joints with specified impact toughness at sub-zero temperatures.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15382	1.6 × 1000	5 kg · Tube
XP15384	2.4 × 1000	5 kg · Tube
XP15386	3.2 × 1000	5 kg · Tube



Technical datasheet

WEATHERING STEEL

CORTEN (ER 80S-G)

EN ISO 636-A: W Z3Ni1 | AWS A5.28: ER80S-G

Filler for weathering steel.

Use for: Exposed structural steelwork where the procedure calls for a weathering grade.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP15390	1.6 × 1000	5 kg · Tube
XP15392	2.4 × 1000	5 kg · Tube
XP15394	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / STEEL & IRON APPLICATIONS

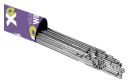
CAST IRON REPAIR

FN55 CAST (E NiFe-Cl)

Nickel-iron filler for cast iron.

Use for: Cast iron repairs using the specified preheat and welding procedure.

Part number	Size mm	Pack / format
XP35354	1.6	5 kg
XP35356	2.4	5 kg



Ask for technical data

HARDFACING

HF600

EN ISO 14700: S Fe 8 | DIN 8555: MSG 6-GZ-60

Surfacing consumable for wear resistance.

Use for: Build-up or wear overlays to the required hardness and wear mechanism.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP20300	1.6 × 1000	5 kg · Tube
XP20303	2.4 × 1000	5 kg · Tube
XP20306	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / ALUMINIUM

ALUMINIUM

ER 1070 (Al99.7)

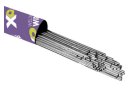
EN ISO 18273: S Al 1070 (Al99.7) | AWS A5.10: ER1070

High-purity aluminium filler.

Use for: Commercially pure aluminium where 1070 is specified.

Shielding gas: I1

Part number	Size mm	Pack / format
XP25300	1.6 × 1000	2.5 kg · Tube
XP25302	2.4 × 1000	2.5 kg · Tube
XP25304	3.2 × 1000	2.5 kg · Tube



Technical datasheet

ALUMINIUM

ER 4043 (AlSi5)

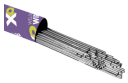
EN ISO 18273: S Al 4043 (AlSi5) | AWS A5.10: ER4043

Aluminium-silicon filler with good fluidity.

Use for: Compatible aluminium castings and wrought grades where AlSi5 is specified.

Shielding gas: I1

Part number	Size mm	Pack / format
XP25308	1.6 × 1000	2.5 kg · Tube
XP25310	2.4 × 1000	2.5 kg · Tube
XP25312	3.2 × 1000	2.5 kg · Tube



Technical datasheet

ALUMINIUM

ER 5183 (AlMg4.5Mn)

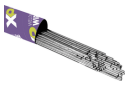
EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A)) | AWS A5.10: ER5183

Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1

Part number	Size mm	Pack / format
XP25313	1.6 × 1000	2.5 kg · Tube
XP25314	2.4 × 1000	2.5 kg · Tube
XP25315	3.2 × 1000	2.5 kg · Tube



Technical datasheet

ALUMINIUM

ER 5356 (AlMg5)

EN ISO 18273: S Al 5356 (AlMg5Cr(A)) | AWS A5.10: ER5356

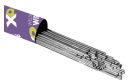
Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP25316	1.6 × 1000	2.5 kg · Tube
XP25318	2.0	2.5 kg
XP25320	2.4 × 1000	2.5 kg · Tube
XP25322	3.2 × 1000	2.5 kg · Tube



Technical datasheet

ALUMINIUM

ER 5556 (AlMg5Mn)

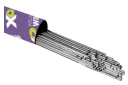
EN ISO 18273: S Al 5556 (AlMg5Mn1Ti(A)) | AWS A5.10: ER5556

Aluminium-magnesium filler.

Use for: Compatible aluminium alloys. Match the filler to the required joint strength and service.

Shielding gas: I1

Part number	Size mm	Pack / format
XP25326	1.6 × 1000	2.5 kg · Tube
XP25328	2.4 × 1000	2.5 kg · Tube
XP25330	3.2 × 1000	2.5 kg · Tube



Technical datasheet

TIG FILLER RODS / OTHER NON-FERROUS ALLOYS

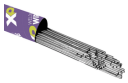
NICKEL ALLOYS

ALLOY 200 (Ni-1)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35350	1.6	5 kg
XP35352	2.4	5 kg



Ask for technical data

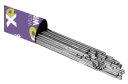
NICKEL ALLOYS

ALLOY 400 Monel (NiCu-7)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35344	1.6	5 kg
XP35346	2.4	5 kg
XP35348	3.2	5 kg



Ask for technical data

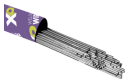
NICKEL ALLOYS

ALLOY 59 (NiCrMo-13)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35328	1.6	5 kg
XP35330	2.4	5 kg
XP35332	3.2	5 kg



Ask for technical data

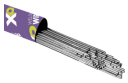
NICKEL ALLOYS

ALLOY 617 (NiCrCoMo-1)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35334	1.6	5 kg
XP35336	2.4	5 kg
XP35338	3.2	5 kg



Ask for technical data

NICKEL ALLOYS

ALLOY 625 (NiCrMo-3)

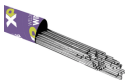
EN ISO 18274: S Ni 6625 - NiCr22Mo9Nb | AWS A5.14: ERNiCrMo-3

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Shielding gas: I1 | DC-

Part number	Size mm	Pack / format
XP35310	1.6 × 1000	5 kg
XP35312	2.4 × 1000	5 kg
XP35314	3.2 × 1000	5 kg



Technical datasheet

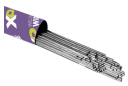
NICKEL ALLOYS

ALLOY 82 (NiCr-3)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35340	1.6	5 kg
XP35342	2.4	5 kg
XP35343	3.2	5 kg



Ask for technical data

TIG FILLER RODS / OTHER NON-FERROUS ALLOYS

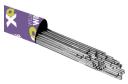
NICKEL ALLOYS

ALLOY 825 (NiFeCr-1)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35358	1.6	5 kg
XP35360	2.4	5 kg
XP35362	3.2	5 kg



Ask for technical data

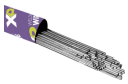
NICKEL ALLOYS

ALLOY C22 (NiCrMo-10)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35322	1.6	5 kg
XP35324	2.4	5 kg
XP35326	3.2	5 kg



Ask for technical data

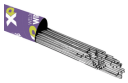
NICKEL ALLOYS

ALLOY C276 (NiCrMo-4)

Nickel-based filler for alloy fabrication.

Use for: Match to the base alloy and corrosion or temperature requirements.

Part number	Size mm	Pack / format
XP35316	1.6	5 kg
XP35318	2.4	5 kg
XP35320	3.2	5 kg



Ask for technical data

COPPER ALLOYS

C1 (CuAg1)

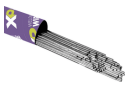
EN ISO 24373: S Cu 1897 (CuAg1) | AWS A5.7: ERCu

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40305	1.6 × 1000	5 kg · Tube
XP40306	2.4 × 1000	5 kg · Tube
XP40307	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

C11 (CuSn6P)

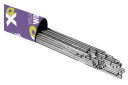
EN ISO 24373: S Cu 5180A (CuSn6P) | AWS A5.7: ERCuSn-A

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40331	1.6 × 1000	5 kg · Tube
XP40332	2.4 × 1000	5 kg · Tube
XP40333	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

C13 (CuAl10Fe)

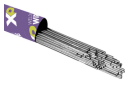
EN ISO 24373: S Cu 6180 (CuAl10Fe) | AWS A5.7: ERCuAl-A2

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40344	1.6 × 1000	5 kg · Tube
XP40345	2.4 × 1000	5 kg · Tube
XP40346	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / OTHER NON-FERROUS ALLOYS

COPPER ALLOYS

C27 (CuSn12P)

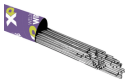
EN ISO 24373: S Cu 5410 (CuSn12P)

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40353	1.6 × 1000	5 kg · Tube
XP40354	2.4 × 1000	5 kg · Tube
XP40355	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

C28 (CuAl7)

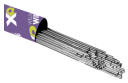
EN ISO 24373: S Cu 6100 (CuAl7) | AWS A5.7: ERCuAl-A1

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40367	1.6 × 1000	5 kg · Tube
XP40368	2.4 × 1000	5 kg · Tube
XP40369	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

C7 (CuSn1)

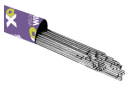
EN ISO 24373: S Cu 1898 (CuSn1) | AWS A5.7: ERCu

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40316	1.6 × 1000	5 kg · Tube
XP40317	2.4 × 1000	5 kg · Tube
XP40318	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

C9 (CuSi3Mn1)

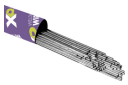
EN ISO 24373: S Cu 6560 (CuSi3Mn1) | AWS A5.7: ERCuSi-A

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40325	1.6 × 1000	5 kg · Tube
XP40326	2.4 × 1000	5 kg · Tube
XP40327	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

CuNi10 (Cu7061)

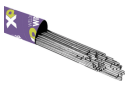
EN ISO 24373: S Cu 7061 (CuNi10)

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40377	1.6 × 1000	5 kg · Tube
XP40378	2.4 × 1000	5 kg · Tube
XP40379	3.2 × 1000	5 kg · Tube



Technical datasheet

COPPER ALLOYS

CuNi30Mn (Cu7158)

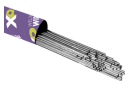
EN ISO 24373: S Cu 7158 (CuNi30Mn1FeTi) | AWS A5.7: ERCuNi

Copper-alloy filler.

Use for: Copper and compatible copper alloys, selected to the joint and service.

Shielding gas: I1, I3 | DC-

Part number	Size mm	Pack / format
XP40381	1.6 × 1000	5 kg · Tube
XP40382	2.4 × 1000	5 kg · Tube
XP40383	3.2 × 1000	5 kg · Tube



Technical datasheet

TIG FILLER RODS / OTHER NON-FERROUS ALLOYS

TITANIUM

ER Ti2 TITANIUM

EN ISO 24034: S Ti 0120 (Ti99,6) | AWS A5.16: ERTi2

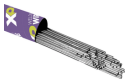
Commercially pure titanium filler.

Use for: Grade 2 titanium fabrication to an approved procedure.

Shielding gas: I1 | DC-

Datasheet covers the grade. Check the table for ordering variants.

Part number	Size mm	Pack / format
XP35379	1.0	1 kg
XP35385	1.6 × 1000	1 kg · Tube
XP35388	2.4 × 1000	1 kg · Tube



Technical datasheet

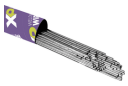
MAGNESIUM

AZ92A (MAGNESIUM)

Magnesium-alloy TIG filler.

Use for: Compatible magnesium alloys, including suitable castings.

Part number	Size mm	Pack / format
XP55342	1.6	1 kg
XP55346	2.4	1 kg
XP55349	3.2	1 kg



Ask for technical data

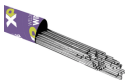
MAGNESIUM

AZ61A (MAGNESIUM)

Magnesium-alloy TIG filler.

Use for: Compatible magnesium alloys, including suitable castings.

Part number	Size mm	Pack / format
XP55333	1.6	1 kg
XP55336	2.4	1 kg
XP55338	3.2	1 kg



Ask for technical data

MMA ELECTRODES

RUTILE ELECTRODES

E6013

EN ISO 2560-A: E 38 0 R 12 | AWS A5.1: E6013

E6013 rutile stick electrode for mild steel.

Use for: General steel fabrication and workshop repairs.

Supplier carton: 15 kg, 3 × 5 kg packs.

Part number	Size mm	Pack / format
XP10115	2.5 × 350	5 kg
XP10118	3.2 × 350	5 kg
XP10121	4.0 × 350	5 kg



Technical datasheet

RUTILE ELECTRODES

E6013 M

Grade designation: E6013

E6013 rutile stick electrode for mild steel.

Use for: General steel fabrication and workshop repairs.

Part number	Size mm	Pack / format
XP10160	2.5 × 350	5 kg
XP10163	3.2 × 350	5 kg
XP10169	4.0 × 350	5 kg



Ask for technical data

RUTILE ELECTRODES

E6013 VD

Grade designation: E6013

E6013 rutile stick electrode for mild steel.

Use for: General steel fabrication and workshop repairs.

Part number	Size mm	Pack / format
XP10182	2.5 × 350	5 kg
XP10185	3.2 × 350	5 kg
XP10188	4.0 × 350	5 kg



Ask for technical data

HIGH DEPOSITION

E7024

Grade designation: E7024

High-recovery iron-powder stick electrode.

Use for: Flat and horizontal mild-steel welding where deposition rate matters.

Part number	Size mm	Pack / format
XP10130	3.2 × 450	5 kg
XP10133	4.0 × 450	5 kg
XP10136	5.0 × 450	5 kg



Ask for technical data

BRAZING & OXY-FUEL

GAS WELDING

CCMS (R45) GAS WELDING

EN ISO 20378: O I | AWS A5.2: R45

Carbon steel filler rod for oxy-fuel welding.

Use for: Gas welding mild steel where an R45 rod is specified.

Part number	Size mm	Pack / format
XP10600	1.6 × 1000	5 kg · Tube
XP10603	2.4 × 1000	5 kg · Tube
XP10606	3.2 × 1000	5 kg · Tube



Technical datasheet

SILVER BRAZING

Ag BRAZE 140 / Flux Coated

EN ISO 17672: Ag 140

Silver-bearing filler for brazed joints.

Use for: Compatible metals where the specified alloy and flux suit the joint.

Part number	Size mm	Pack / format
XP50608	1.5 × 500	1 kg
XP50609	2.0 × 500	1 kg



Technical datasheet

SILVER BRAZING

Ag BRAZE 155 / Flux Coated

EN ISO 17672: Ag 155

Silver-bearing filler for brazed joints.

Use for: Compatible metals where the specified alloy and flux suit the joint.

Part number	Size mm	Pack / format
XP50630	1.5 × 500	1 kg
XP50635	2.0 × 500	1 kg



Technical datasheet

SILVER BRAZING

Ag BRAZE 140 / Bare

EN ISO 17672: Ag 140

Silver-bearing filler for brazed joints.

Use for: Compatible metals where the specified alloy and flux suit the joint.

Part number	Size mm	Pack / format
XP50603	1.5 × 500	1 kg · Tube
XP50605	2.0 × 500	1 kg · Tube



Technical datasheet

SILVER BRAZING

Ag BRAZE 155 / Bare

EN ISO 17672: Ag 155

Silver-bearing filler for brazed joints.

Use for: Compatible metals where the specified alloy and flux suit the joint.

Part number	Size mm	Pack / format
XP50610	1.5 × 500	1 kg · Tube
XP50615	2.0 × 500	1 kg · Tube



Technical datasheet

COPPER-PHOSPHORUS BRAZING

CuP BRAZE 179 / Bare

EN ISO 17672: CuP 179

Copper-phosphorus filler for brazing.

Use for: Copper joints and pipework where this alloy is specified.

Part number	Size mm	Pack / format
XP50645	1.5 × 500	1 kg · Tube
XP50647	2.0 × 500	1 kg · Tube
XP50648	2.5 × 500	1 kg · Tube
XP50649	3.0 × 500	1 kg · Tube



Technical datasheet

BRAZING & OXY-FUEL

COPPER-PHOSPHORUS BRAZING

CuP BRAZE 182 / Bare

EN ISO 17672: CuP 182

Copper-phosphorus filler for brazing.

Use for: Copper joints and pipework where this alloy is specified.

Part number	Size mm	Pack / format
XP50650	1.5 × 500	1 kg · Tube
XP50651	2.0 × 500	1 kg · Tube
XP50652	2.5 × 500	1 kg · Tube
XP50653	3.0 × 500	1 kg · Tube



Technical datasheet

COPPER-PHOSPHORUS BRAZING

CuP BRAZE 279 / Bare

EN ISO 17672: CuP 279

Copper-phosphorus filler for brazing.

Use for: Copper joints and pipework where this alloy is specified.

Part number	Size mm	Pack / format
XP50655	1.5 × 500	1 kg · Tube
XP50656	2.0 × 500	1 kg · Tube
XP50657	2.5 × 500	1 kg · Tube
XP50658	3.0 × 500	1 kg · Tube



Technical datasheet

COPPER-PHOSPHORUS BRAZING

CuP BRAZE 281 / Bare

EN ISO 17672: CuP 281 | AWS - A5.8: BCuP-2

Copper-phosphorus filler for brazing.

Use for: Copper joints and pipework where this alloy is specified.

Part number	Size mm	Pack / format
XP50660	1.5 × 500	1 kg · Tube
XP50661	2.0 × 500	1 kg · Tube
XP50662	2.5 × 500	1 kg · Tube
XP50663	3.0 × 500	1 kg · Tube



Technical datasheet

COPPER-PHOSPHORUS BRAZING

CuP BRAZE 284 / Bare

EN ISO 17672: CuP 284 | AWS - A5.8: BCuP-5

Copper-phosphorus filler for brazing.

Use for: Copper joints and pipework where this alloy is specified.

Part number	Size mm	Pack / format
XP50665	1.5 × 500	1 kg · Tube
XP50666	2.0 × 500	1 kg · Tube
XP50667	2.5 × 500	1 kg · Tube
XP50668	3.0 × 500	1 kg · Tube



Technical datasheet

BRASS BRAZING

Cu BRAZE 470 / Bare

EN ISO 17672: Cu 470 | AWS - A5.8: RBCuZn-A

Copper-based brazing rod in the specified coating format.

Use for: Compatible steel or copper-alloy assemblies to the specified brazing procedure.

Part number	Size mm	Pack / format
XP50671	1.6 × 1000	2.5 kg · Tube
XP50672	2.4 × 1000	2.5 kg · Tube
XP50673	3.2 × 1000	2.5 kg · Tube



Technical datasheet

BRASS BRAZING

Cu BRAZE 470 / Flux Coated

EN ISO 17672: Cu 470 | AWS - A5.8: RBCuZn-A

Copper-based brazing rod in the specified coating format.

Use for: Compatible steel or copper-alloy assemblies to the specified brazing procedure.

Part number	Size mm	Pack / format
XP50675	2.5 × 1000	2.5 kg
XP50676	3.0 × 1000	2.5 kg



Technical datasheet

BRAZING & OXY-FUEL

BRASS BRAZING

Cu BRAZE 470 / Micro Coated

EN ISO 17672: Cu 470 | AWS - A5.8: RBCuZn-A

Copper-based brazing rod in the specified coating format.

Use for: Compatible steel or copper-alloy assemblies to the specified brazing procedure.

Part number	Size mm	Pack / format
XP50678	2.5 × 500	2.5 kg
XP50679	3.0 × 500	2.5 kg



Technical datasheet

BRASS BRAZING

Cu BRAZE 773 / Bare

EN ISO 17672: Cu 773 | AWS - A5.8: RBCuZn-D

Copper-based brazing rod in the specified coating format.

Use for: Compatible steel or copper-alloy assemblies to the specified brazing procedure.

Part number	Size mm	Pack / format
XP50682	1.6 × 1000	2.5 kg · Tube
XP50683	2.4 × 1000	2.5 kg · Tube
XP50684	3.2 × 1000	2.5 kg · Tube



Technical datasheet

BRASS BRAZING

Cu BRAZE 773 / Flux Coated

EN ISO 17672: Cu 773 | AWS - A5.8: RBCuZn-D

Copper-based brazing rod in the specified coating format.

Use for: Compatible steel or copper-alloy assemblies to the specified brazing procedure.

Part number	Size mm	Pack / format
XP50686	2.5 × 1000	2.5 kg
XP50687	3.0 × 1000	2.5 kg



Technical datasheet

BRAZING & WELDING FLUX

FLUX AG1

EN ISO 18496 - FH10

Flux powder. Working range 530°C–780°C.

Use for: General brazing.

Part number	Size mm	Pack / format
XP50690	–	500 g



Ask for technical data

BRAZING & WELDING FLUX

FLUX AG3

EN ISO 18496 - FH12

Flux powder. Working range 600°C–1000°C.

Use for: Silver brazing - high temperature.

Part number	Size mm	Pack / format
XP50691	–	500 g



Ask for technical data

BRAZING & WELDING FLUX

FLUX AL1

EN ISO 18496 - FL20

Flux powder. Working range 520°C–630°C.

Use for: Aluminium brazing.

Part number	Size mm	Pack / format
XP50692	–	500 g



Ask for technical data

BRAZING & WELDING FLUX

FLUX AL2

EN ISO 18496 - FL20

Flux powder. Working range 590°C–660°C.

Use for: Aluminium welding.

Part number	Size mm	Pack / format
XP50693	–	500 g



Ask for technical data

BRAZING & WELDING FLUX

FLUX CU1

EN ISO 18496 - FH21

Flux powder. Working range 750°C–1030°C.

Use for: Copper brazing.

Part number	Size mm	Pack / format
XP50694	–	500 g



Ask for technical data

TUNGSTEN ELECTRODES

NON-CONSUMABLE TIG ELECTRODES

0.8% zirconiated / White

Tungsten electrode identified by composition and tip colour.

Use for: AC setups where the machine manufacturer specifies this type.

Dia. mm	150 mm code	175 mm code
1.0	XPT6100	XPT6105
1.2	XPT6120	XPT6125
1.6	XPT6160	XPT6165
2.0	XPT6200	XPT6205
2.4	XPT6240	XPT6245
3.2	XPT6320	XPT6325
4.0	XPT6400	XPT6405
4.8	XPT6480	XPT6485
6.4	XPT6640	XPT6645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

1% lanthanated / Black

Tungsten electrode identified by composition and tip colour.

Use for: Select for the current type, material and machine settings.

Dia. mm	150 mm code	175 mm code
1.0	XPT3100	XPT3105
1.2	XPT3120	XPT3125
1.6	XPT3160	XPT3165
2.0	XPT3200	XPT3205
2.4	XPT3240	XPT3245
3.2	XPT3320	XPT3325
4.0	XPT3400	XPT3405
4.8	XPT3480	XPT3485
6.4	XPT3640	XPT3645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

1.5% lanthanated / Gold

Tungsten electrode identified by composition and tip colour.

Use for: Select for the current type, material and machine settings.

Dia. mm	150 mm code	175 mm code
1.0	XPT4100	XPT4105
1.2	XPT4120	XPT4125
1.6	XPT4160	XPT4165
2.0	XPT4200	XPT4205
2.4	XPT4240	XPT4245
3.2	XPT4320	XPT4325
4.0	XPT4400	XPT4405
4.8	XPT4480	XPT4485
6.4	XPT4640	XPT4645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

2% ceriated / Grey

Tungsten electrode identified by composition and tip colour.

Use for: Low-current DC TIG and compatible AC setups.

Dia. mm	150 mm code	175 mm code
1.0	XPT7100	XPT7105
1.2	XPT7120	XPT7125
1.6	XPT7160	XPT7165
2.0	XPT7200	XPT7205
2.4	XPT7240	XPT7245
3.2	XPT7320	XPT7325
4.0	XPT7400	XPT7405
4.8	XPT7480	XPT7485
6.4	XPT7640	XPT7645



Parweld tungsten selection

TUNGSTEN ELECTRODES

NON-CONSUMABLE TIG ELECTRODES

2% lanthanated / Blue

Tungsten electrode identified by composition and tip colour.

Use for: Select for the current type, material and machine settings.

Dia. mm	150 mm code	175 mm code
1.0	XPT5100	XPT5105
1.2	XPT5120	XPT5125
1.6	XPT5160	XPT5165
2.0	XPT5200	XPT5205
2.4	XPT5240	XPT5245
3.2	XPT5320	XPT5325
4.0	XPT5400	XPT5405
4.8	XPT5480	XPT5485
6.4	XPT5640	XPT5645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

2% thoriated / Red

Tungsten electrode identified by composition and tip colour.

Use for: DC TIG. Follow the supplier's handling and grinding guidance.

Dia. mm	150 mm code	175 mm code
1.0	XPT1100	XPT1105
1.2	XPT1120	XPT1125
1.6	XPT1160	XPT1165
2.0	XPT1200	XPT1205
2.4	XPT1240	XPT1245
3.2	XPT1320	XPT1325
4.0	XPT1400	XPT1405
4.8	XPT1480	XPT1485
6.4	XPT1640	XPT1645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

Pure tungsten / Green

Tungsten electrode identified by composition and tip colour.

Use for: AC setups where the machine manufacturer specifies this type.

Dia. mm	150 mm code	175 mm code
1.0	XPT2100	XPT2105
1.2	XPT2120	XPT2125
1.6	XPT2160	XPT2165
2.0	XPT2200	XPT2205
2.4	XPT2240	XPT2245
3.2	XPT2320	XPT2325
4.0	XPT2400	XPT2405
4.8	XPT2480	XPT2485
6.4	XPT2640	XPT2645



Parweld tungsten selection

NON-CONSUMABLE TIG ELECTRODES

Three-element rare earth / Purple

Tungsten electrode identified by composition and tip colour.

Use for: AC and DC TIG where the machine settings suit this electrode.

Dia. mm	150 mm code	175 mm code
1.0	XPT8100	XPT8105
1.2	XPT8120	XPT8125
1.6	XPT8160	XPT8165
2.0	XPT8200	XPT8205
2.4	XPT8240	XPT8245
3.2	XPT8320	XPT8325
4.0	XPT8400	XPT8405
4.8	XPT8480	XPT8485
6.4	XPT8640	XPT8645



Parweld tungsten selection

WELDIBER

MILD STEEL

SG2 MIG/MAG wire

EN ISO 14341-A: G 42 3 C1 3Si1 / G 42 4 M21 3Si1 | AWS A5.18: ER70S-6

Copper-coated solid wire for carbon and C-Mn steels.

Use for: General steel fabrication with C1 or M21 shielding gas.

Shielding gas: C1, M21 | DC+

Part number	Size mm	Pack / format
WBR-1508	0.8	15 kg · S300 plastic
WBR-1510	1.0	15 kg · S300 plastic
WBR-1512	1.2	15 kg · S300 plastic



Technical datasheet

RUTILE ELECTRODES

E6013 MMA electrodes

Grade designation: E6013

E6013 rutile stick electrode for mild steel.

Use for: General fabrication and workshop repairs.

Part number	Size mm	Pack / format
WBR-2525	2.5 × 350	15 kg
WBR-2532	3.2 × 350	15 kg
WBR-2540	4.0 × 350	15 kg



Ask for technical data