WELDABILITY SIF FILLER METALS



Welding, brazing and soldering

Range and ordering guide

Select solid and cored wire, rods, electrodes, brazing alloys or solder by parent metal and process. The handbook links take you to the supplier's detailed grade and ordering data.

Range	Typical application	Page
Aluminium MIG	Cast and wrought aluminium fabrication	4
Aluminium TIG	Aluminium sheet, castings and precision repair	5
Copper alloy MIG	Copper and bronze welding or MIG brazing	6
Copper alloy TIG	Copper, bronze and copper-nickel joints	7–8
Stainless MIG	Stainless fabrication, duplex and dissimilar joints	9–10
Stainless TIG	Stainless, duplex and controlled-root welding	11–13
Steel MIG & cored	Carbon and low-alloy steel, cored and hardfacing wire	14–16
Steel TIG	Carbon steel, low-alloy steels and hardfacing	17
Specialist TIG	Magnesium, titanium and wear-resistant overlays	18
MMA electrodes	Workshop stick welding and repair	19–20
Gas welding & brazing	Gas welding, bronze brazing and copper work	21
Brazing & soldering	Bronze, copper-phosphorus, silver and aluminium fillers	22–24
Tungsten electrodes	Non-consumable TIG electrodes by type and size	25
Fluxes	Match flux chemistry and temperature to the joint	26

Specify the parent metal, filler grade, diameter, pack and part number when ordering.

Need help selecting a filler?

For technical advice and availability, call 023 8033 9443 or email sales@rhdaveywelding.co.uk.

Filler Selector by Workpiece Material and Process Pages 2–3

© R H Davey Welding Supplies Ltd · Design and editorial content

FILLER SELECTOR / CHOOSE THE WORKPIECE MATERIAL

Carbon Steel, Stainless & Cast Iron

Find the process and the job, then click the grade for sizes and ordering codes. Match the exact parent alloy and welding procedure for the joint.

Aluminium & Other Non-Ferrous Metals →

Carbon & Low-Alloy Steel

Process	Use For	Start With	Page
MIG	General mild-steel fabrication	SIFMIG SG2/A18	14
MIG	Higher Si/Mn filler where specified	SIFMIG SG3/G4Si1	14
MIG Brazing	Silicon bronze for suitable thin coated steel	SIFMIG C9 / 968	06
Flux-Cored	Self-shielded mild-steel work	SIFMIG E71T-GS	15
Flux-Cored	Gas-shielded, all-position fabrication	SIFCORED E71T-1M	15
TIG	Deoxidised filler for compatible pipe and fabrication	SIFTIG A15 / 70S-2	17
MMA	General-purpose rutile electrode	SIFTRODE 6013	19
MMA	Low-hydrogen root passes	SIFTRODE 7016	19
MMA	Low-hydrogen steel fabrication	SIFTRODE 7018	19
MMA	Wear-resistant overlays on suitable components	SIFTRODE HF-600	19
Gas Welding	Low-carbon steel fabrication and repairs	SIFSTEEL No. 11 / A1	21
Brazing	Bare bronze rod with separate flux	SIFBRONZE C2 / No. 1	22
Brazing	Flux-coated bronze for repairs and fabrication	SIFREDICOTE C2 / No. 1	22

Stainless Steel & Dissimilar Joints

Process	Use For	Start With	Page
MIG	304 / 304L stainless	SIFMIG 308LSi	09
TIG	304 / 304L stainless	SIFTIG 308L	11
MIG	316 / 316L stainless	SIFMIG 316LSi	09
TIG	316 / 316L stainless	SIFTIG 316L	12
MIG	Stainless to carbon steel, where specified	SIFMIG 309LSi	09
TIG	Stainless to carbon steel, where specified	SIFTIG 309L	11
MMA	Stainless to carbon steel, where specified	SIFTRODE E309L	20
TIG	22% chromium duplex stainless	SIFTIG 2209	13
MIG	Matching heat-resistant 310 stainless	SIFMIG 310	10
MMA	Selected difficult-to-weld steels and repairs	SIFTRODE E312	20
Silver Brazing	Close-fitting stainless capillary joints	SIF Silver Solder 55%	23

Cast Iron

Process	Use For	Start With	Page
MMA	Compatible grey and malleable castings	SIFTRODE Ni	19
MMA	Specified cast-iron repairs and cast iron to steel	SIFTRODE NiFe	19
Gas Welding	Fusion repair on suitable castings	SUPERSILICON No. 9	21
Bronze Brazing	Braze repairs with a compatible flux	SIFBRONZE C2 / No. 1	22

For cast iron, identify the casting and agree the repair method before choosing nickel, nickel-iron, gas fusion or bronze brazing.

Weldability SIF Consumables Handbook

© R H Davey Welding Supplies Ltd · Design and editorial content

FILLER SELECTOR / CHOOSE THE WORKPIECE MATERIAL

Aluminium & Other Non-Ferrous Metals

Find the process and the job, then click the grade for sizes and ordering codes. Match the exact parent alloy and welding procedure for the joint.

← Carbon Steel, Stainless & Cast Iron

Aluminium

Process	Use For	Start With	Page
MIG	Commercially pure aluminium	SIFMIG 1050	04
TIG	Commercially pure aluminium	SIFTIG 1050A / No. 14	05
MIG	Aluminium-silicon filler for compatible alloys	SIFMIG 4043	04
TIG	Aluminium-silicon filler for compatible alloys	SIFTIG 4043A / No. 15	05
TIG	Higher-silicon filler for compatible castings	SIFTIG 4047A / No. 16	05
MIG	Compatible aluminium-magnesium alloys	SIFMIG 5356	04
TIG	Compatible aluminium-magnesium alloys	SIFTIG 5356 / No. 27	05
MIG	Higher-strength joint where 5183 is specified	SIFMIG 5183	04
TIG	Higher-strength joint where 5183 is specified	SIFTIG 5183 / No. 28	05
MIG	Higher-strength joint where 5556 is specified	SIFMIG 5556	04
TIG	Higher-strength joint where 5556 is specified	SIFTIG 5556 / No. 37	05
Soldering	Low-temperature repair on compatible aluminium	SIF 555 Aluminium Solder	23

Copper & Copper-Nickel

Process	Use For	Start With	Page
MIG	Deoxidised copper fusion welding	SIFMIG C7 / 985	06
TIG	Deoxidised copper fusion welding	SIFTIG C7 / 985	07
Gas Welding	Compatible copper sheet and fittings	SIFSILCOPPER No. 7 C1	21
Brazing	Compatible copper-to-copper tube joints	SIFCUPRON CP3	23
TIG	Matching 90/10 copper-nickel	SIFTIG CuNi10 90/10 / No. 79	08

Brass & Bronze

Process	Use For	Start With	Page
MIG	Compatible phosphor bronze repairs	SIFMIG C11 / No. 8	06
TIG	Compatible phosphor bronze repairs	SIFTIG C11 / No. 8	07
TIG Brazing	Silicon bronze filler for specified joints	SIFTIG C9 / 968	07
Silver Brazing	Close-fitting brass and compatible dissimilar joints	SIF Silver Solder 55%	23

Magnesium & Titanium

Process	Use For	Start With	Page
TIG	Compatible magnesium alloys and castings	SIFTIG AZ61A / No. 23	18
TIG	Commercially pure Grade 2 titanium	SIFTIG TI2	18
TIG	Titanium where Grade 5 filler is specified	SIFTIG Ti5 6-4 / No. 75	18

For aluminium, verify the parent alloy before choosing the filler. Use copper-phosphorus on suitable copper-to-copper joints.

Weldability SIF Consumables Handbook

© R H Davey Welding Supplies Ltd · Design and editorial content

Aluminium MIG

SIFMIG 1050

EN ISO 18273: S Al 1050 (Al99.5) / AWS A5.10 - ER1050A
Commercially pure aluminium components where a ductile weld is required.

Part number	Size / pack
WO140865	0.8mm / 6.5kg
WO141065	1.0mm / 6.5kg
WO141265	1.2mm / 6.5kg
WO141665	1.6mm / 6.5kg



Handbook datasheet

SIFMIG 4047

EN ISO 18273: S Al 4047A (AlSi12)
Compatible high-silicon aluminium castings and automotive repair.

Part number	Size / pack
WO161020	1.0mm / 2kg
WO161065	1.0mm / 6.5kg
WO161265	1.2mm / 6.5kg
WO161665	1.6mm / 6.5kg



Handbook datasheet

SIFMIG 5356

EN ISO 18273: S Al 5356 (AlMg5) / AWS A5.10 : ER5356
General Al-Mg fabrication where corrosion resistance and weld strength are needed.

Part number	Size / pack
WO270805	0.8mm / 0.5kg
WO270820	0.8mm / 2kg
WO270865	0.8mm / 6.5kg
WO271005	1.0mm / 0.5kg
WO271020	1.0mm / 2kg
WO271065	1.0mm / 6.5kg
WO271205	1.2mm / 0.5kg
WO271220	1.2mm / 2kg
WO271265	1.2mm / 6.5kg
WO271665	1.6mm / 6.5kg



Handbook datasheet

SIFMIG 4043

EN ISO 18273: S Al 4043 (AlSi5) / AWS A5.10 ER4043
Compatible cast and wrought Al-Si work. The 5% silicon filler promotes good weld-pool flow.

Part number	Size / pack
WO150805	0.8mm / 0.5kg
WO150820	0.8mm / 2kg
WO150865	0.8mm / 6.5kg
WO151005	1.0mm / 0.5kg
WO151020	1.0mm / 2kg
WO151065	1.0mm / 6.5kg
WO151205	1.2mm / 0.5kg
WO151220	1.2mm / 2kg
WO151265	1.2mm / 6.5kg
WO151665	1.6mm / 6.5kg



Handbook datasheet

SIFMIG 5183

EN ISO 18273: S Al 5183
High-strength Al-Mg joints in compatible marine and structural grades.

Part number	Size / pack
WO281065	1.0mm / 6.5kg
WO281265	1.2mm / 6.5kg



Handbook datasheet

SIFMIG 5556

EN ISO 18273 S Al 5556A / AWS A5.10 ER5556
Higher-strength Al-Mg welds on compatible alloys.

Part number	Size / pack
WO371065	1.0mm / 6.5kg
WO371205	1.2mm / 0.5kg
WO371220	1.2mm / 2kg
WO371265	1.2mm / 6.5kg
WO371665	1.6mm / 6.5kg



Handbook datasheet

Choose flow or strength to suit the alloy

4043 gives a fluid weld pool on compatible Al-Si applications. 5356 suits compatible Al-Mg fabrication where joint strength and corrosion resistance matter. Check the parent alloy before switching.

© R H Davey Welding Supplies Ltd · Design and editorial content

Aluminium TIG

SIFTIG 1050A / No. 14

EN ISO 18273 : S Al 1050A (Al99.5)
Commercially pure aluminium and compatible components requiring a ductile weld.

Part number	Size / pack
RO141625	1.6mm / 2.5kg
RO142425	2.4mm / 2.5kg
RO143225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 4047A / No. 16

EN ISO 18273 S Al 4047A (AlSi12)
Compatible high-silicon aluminium alloys and castings.

Part number	Size / pack
RO161625	1.6mm / 2.5kg
RO162425	2.4mm / 2.5kg
RO163225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 5183 / No. 28

EN ISO 18273-S Al 5183 (AlMg4.5Mn0.7)
Higher-strength welds on compatible marine-grade Al-Mg alloys.

Part number	Size / pack
RO281625	1.6mm / 2.5kg
RO282425	2.4mm / 2.5kg
RO283225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 4043A / No. 15

EN ISO 18273-S Al 4043A (AlSi5)
Compatible Al-Si cast and wrought alloys. A fluid choice for suitable casting repairs.

Part number	Size / pack
RO151625	1.6mm / 2.5kg
RO152425	2.4mm / 2.5kg
RO153225	3.2mm / 2.5kg
RO155025	5.0mm / 2.5kg



Handbook datasheet

SIFTIG 5356 / No. 27

EN ISO 18273-S Al 5356 (AlMg5)
General Al-Mg fabrication for compatible marine and structural alloys.

Part number	Size / pack
RO271625	1.6mm / 2.5kg
RO272425	2.4mm / 2.5kg
RO273225	3.2mm / 2.5kg
RO272401	5356mm / 1kg
RO272450	5356mm / 5kg



Handbook datasheet

SIFTIG 5556 / No. 37

EN ISO 18273: S Al 5556A (AlMg5Mn)
High-strength compatible Al-Mg fabrication where 5556 is specified.

Part number	Size / pack
RO371625	1.6mm / 2.5kg
RO372425	2.4mm / 2.5kg
RO373225	3.2mm / 2.5kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Copper alloy MIG

SIFMIG C11 / No. 8

EN ISO 24373 Cu 5180A (CuSn6P)
Phosphor bronze castings and compatible copper alloys.

Part number	Size / pack
WO080812	0.8mm / 12.5kg
WO081012	1.0mm / 12.5kg
WO081212	1.2mm / 12.5kg
WO080807	0.8mm / 0.7kg
WO080840	0.8mm / 4kg
WO081007	1.0mm / 0.7kg
WO081040	1.0mm / 5kg
WO081207	1.2mm / 0.7kg
WO081240	1.2mm / 4kg



Handbook datasheet

SIFMIG Cu6511 / 967

EN ISO 24373 Cu 6511 (CuSi2Mn1)
Silicon bronze joining and specified MIG brazing.

Part number	Size / pack
WO970840	0.8mm / 4kg
WO970812	0.8mm / 12.5kg
WO9708200	0.8mm / 200kg
WO971040	1.0mm / 4kg
WO971012	1.0mm / 12.5kg
WO9710200	1.0mm / 200kg
WO971240	1.2mm / 4kg
WO971212	1.2mm / 12.5kg
WO9712200	1.2mm / 200kg



Handbook datasheet

SIFMIG C7 / 985

EN ISO 24373 Cu 1898 (CuSn1P)
Deoxidised copper welding where the procedure calls for a high-copper filler.

Part number	Size / pack
WO980840	0.8mm / 4kg
WO980812	0.8mm / 12.5kg
WO981040	1.0mm / 4kg
WO981012	1.0mm / 12.5kg
WO981240	1.2mm / 4kg
WO981212	1.2mm / 12.5kg



Handbook datasheet

SIFMIG C20/26 / No. 44

EN ISO 24373 Cu 6328 (CuAl9Ni5Fe3Mn2) / AWS A5.7: ERCuNiAl
Nickel aluminium bronze repair and components subject to corrosion or cavitation.

Part number	Size / pack
WO440812	0.8mm / 12.5kg
WO441212	1.2mm / 12.5kg



Handbook datasheet

SIFMIG C28 / 328

EN ISO 24373 Cu 6180A (CuAl8) / AWS A5.7 ERCuAl-A1
Aluminium-bronze surfacing and compatible copper-alloy work.

Part number	Size / pack
WO320840A	0.8mm / 4kg
WO320812A	0.8mm / 12.5kg
WO321040A	1.0mm / 4kg
WO321012A	1.0mm / 12.5kg
WO321240A	1.2mm / 4kg
WO321212A	1.2mm / 12.5kg
WO3210200A	328mm / 200kg



Handbook datasheet

SIFMIG C9 / 968

EN ISO 24373 Cu 6560 (CuSi3Mn1) / AWS A5.7 ERCuSi-A
MIG brazing of suitable thin coated steel and joining compatible copper alloys.

Part number	Size / pack
WO960807	0.8mm / 0.7kg
WO960840	0.8mm / 4kg
WO960812	0.8mm / 12.5kg
WO961007	1.0mm / 0.7kg
WO961040	1.0mm / 4kg
WO961012	1.0mm / 12.5kg
WO961240	1.2mm / 4kg
WO961212	1.2mm / 12.5kg



Handbook datasheet

SIFMIG C9

Part number	Size / pack
WO9610200	1.0mm / 200kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Copper alloy TIG

SIFTIG C1 / No. 7 HQ

EN ISO 24373 Cu 1897 (CuAg1)
Copper joining and compatible gas brazing or TIG applications.

Part number	Size / pack
RO071650HQ	1.6mm / 5kg
RO072450HQ	2.4mm / 5kg
RO073250HQ	3.2mm / 5kg



Handbook datasheet

SIFTIG C9 / 968

EN ISO 24373 Cu6560 (CuSi3Mn1)
Silicon bronze for TIG brazing and specified copper-alloy joints.

Part number	Size / pack
RO961201	1.2mm / 1kg
RO961225	1.2mm / 2.5kg
RO961250	1.2mm / 5kg
RO961601	1.6mm / 1kg
RO961625	1.6mm / 2.5kg
RO961650	1.6mm / 5kg
RO962401	2.4mm / 1kg
RO962425	2.4mm / 2.5kg
RO962450	2.4mm / 5kg
RO963201	3.2mm / 1kg
RO963225	3.2mm / 2.5kg
RO963250	3.2mm / 5kg



Handbook datasheet

SIFTIG C13 / No. 32

EN ISO 24373 : Cu 6180 (CuAl10Fe) / AWS A5.7: ERCuAl-A2
Aluminium-bronze components and repairs.

Part number	Size / pack
RO321601	1.6mm / 1kg
RO321625	1.6mm / 2.5kg
RO321650	1.6mm / 5kg
RO322401	2.4mm / 1kg
RO322425	2.4mm / 2.5kg
RO322450	2.4mm / 5kg
RO323201	3.2mm / 1kg
RO323225	3.2mm / 2.5kg
RO323250	3.2mm / 5kg
RO321610	1.6mm / 10kg
RO322410	2.4mm / 10kg
RO323210	3.2mm / 10kg



Handbook datasheet

SIFTIG C7 / 985

Deoxidised copper fusion welding.

Part number	Size / pack
RO981201	1.2mm / 1kg
RO981225	1.2mm / 2.5kg
RO981250	1.2mm / 5kg
RO981601	1.6mm / 1kg
RO981625	1.6mm / 2.5kg
RO981650	1.6mm / 5kg
RO982401	2.4mm / 1kg
RO982425	2.4mm / 2.5kg
RO982450	2.4mm / 5kg
RO983201	3.2mm / 1kg
RO983225	3.2mm / 2.5kg
RO983250	3.2mm / 5kg



Handbook datasheet

SIFTIG C11 / No. 8

EN ISO 24373 Cu 5180a (CuSn6P)
Phosphor bronze repair and compatible copper alloys.

Part number	Size / pack
RO081201	1.2mm / 1kg
RO081225	1.2mm / 2.5kg
RO081250	1.2mm / 5kg
RO081601	1.6mm / 1kg
RO081625	1.6mm / 2.5kg
RO081650	1.6mm / 5kg
RO082401	2.4mm / 1kg
RO082425	2.4mm / 2.5kg
RO082450	2.4mm / 5kg
RO083201	3.2mm / 1kg
RO083225	3.2mm / 2.5kg
RO083250	3.2mm / 5kg
RO081610	1.6mm / 10kg
RO081650HQ	1.6mm / 5kg
RO082410	2.4mm / 10kg
RO082450HQ	2.4mm / 5kg
RO083210	3.2mm / 10kg
RO083250HQ	3.2mm / 5kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Copper alloy TIG

SIFTIG C20/26 / No. 44

EN ISO 24373 : Cu 6328 (CuAl9Ni5Fe3Mn2) / AWS A5.7: ERCuNiAl
Nickel aluminium bronze in compatible marine and wear applications.

Part number	Size / pack
RO442401	2.4mm / 1kg
RO442425	2.4mm / 2.5kg
RO442450	2.4mm / 5kg



Handbook datasheet

SIFTIG CuNi10 90/10 / No. 79

EN ISO 24373 : Cu 7061 (CuNi10)
Compatible 90/10 copper-nickel and specified marine components.

Part number	Size / pack
RT791650	1.6mm / 5kg
RT792450	2.4mm / 5kg
RT793250	3.2mm / 5kg



Handbook datasheet

SIFTIG C9

Part number	Size / pack
RO961210	1.2mm / 10kg
RO961610	1.6mm / 10kg
RO962410	2.4mm / 10kg
RO963210	3.2mm / 10kg



Supplier product information

SIFTIG C27 / No. 82

EN ISO 24373: Cu 5410 (CuSn12P) / AWS A5.7: ERCuSn-C
Tin bronze applications where the C27 filler is specified.

Part number	Size / pack
RO821601	1.6mm / 1kg
RO821625	1.6mm / 2.5kg
RO821650	1.6mm / 5kg
RO822401	2.4mm / 1kg
RO822425	2.4mm / 2.5kg
RO822450	2.4mm / 5kg
RO823250	3.2mm / 5kg



Handbook datasheet

SIFTIG CuNi 70/30

EN ISO 24373: Cu 7158 (CuNi30Mn1Fe) / AWS A5.7: ERCuNi
Compatible copper-nickel fabrication and specified marine service.

Part number	Size / pack
RT731650	1.6mm / 5kg
RT732450	2.4mm / 5kg
RT733250	3.2mm / 5kg



Handbook datasheet

SIFTIG C7

Part number	Size / pack
RO981210	1.2mm / 10kg
RO981610	1.6mm / 10kg
RO982410	2.4mm / 10kg
RO983210	3.2mm / 10kg



Supplier product information

Match the copper alloy

Choose C7 for specified deoxidised copper welding. C9 is a silicon-bronze option for compatible copper alloys and specified TIG brazing. Quote the grade as well as the rod diameter.

© R H Davey Welding Supplies Ltd · Design and editorial content

Stainless MIG

SIFMIG 308LSi

EN ISO 14343-A: G 19 9 LSi / AWS A5.9 ER 308LSi
304/304L stainless. Added silicon promotes wetting.

Part number	Size / pack
WO330810	0.8mm / 1kg
WO330850	0.8mm / 5kg
WO330815	0.8mm / 15kg
WO331050	1.0mm / 5kg
WO331015	1.0mm / 15kg
WO331250	1.2mm / 5kg
WO331215	1.2mm / 15kg
WO331615	1.6mm / 15kg



Handbook datasheet

SIFMIG 316LSi

EN ISO 14343-A: G 19 12 3 LSi / AWS A5.9 ER 316LSi
316/316L stainless, with a silicon-enhanced MIG filler for wetting.

Part number	Size / pack
WO210610	0.6mm / 1kg
WO210650	0.6mm / 5kg
WO210612	0.6mm / 12.5kg
WO210810	0.8mm / 1kg
WO210850	0.8mm / 5kg
WO210815	0.8mm / 12.5kg
WO211010	1.0mm / 1kg
WO211050	1.0mm / 5kg
WO211015	1.0mm / 12.5kg
WO211210	1.2mm / 1kg
WO211250	1.2mm / 5kg
WO211215	1.2mm / 12.5kg
WO211615	1.6mm / 15kg



Handbook datasheet

SIFMIG 307Si

Specified dissimilar and difficult-to-weld steels.

Part number	Size / pack
WO301015	1.0mm / 15kg



Supplier product information

SIFMIG 309LSi

EN ISO 14343 23 12 LSi / AWS A5.9 ER 309LSi
Dissimilar stainless-to-carbon steel and specified cladding.

Part number	Size / pack
WO340850	0.8mm / 5kg
WO340815	0.8mm / 15kg
WO341050	1.0mm / 5kg
WO341015	1.0mm / 15kg
WO341250	1.2mm / 5kg
WO341215	1.2mm / 15kg



Handbook datasheet

SIFMIG 312

EN ISO 14343-A: G 29 9 / AWS A5.9: ER312
Difficult-to-weld steels and selected maintenance joints.

Part number	Size / pack
WO350815	0.8mm / 15kg
WO351015	1.0mm / 15kg
WO351215	312mm / 15kg



Handbook datasheet

SIFMIG Duplex 2209

EN ISO 14343-A: G 22 9 3 N L / AWS A5.9 ER2209
2205 and other compatible 22% chromium duplex grades.

Part number	Size / pack
WO220815	0.8mm / 15kg
WO221015	1.0mm / 15kg
WO221215	1.2mm / 15kg



Handbook datasheet

SIFMIG 347

Stabilised stainless fabrication.

Part number	Size / pack
WO200815	347mm / 15kg
WO201015	347mm / 15kg
WO201215	347mm / 15kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Stainless MIG

SIFMIG 310

Matching heat-resistant 310 stainless steel.

Part number	Size / pack
WO361015	1.0mm / 15kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Stainless TIG

SIFTIG 308H

EN ISO 14343-A: W 19 9 H / AWS A5.9: ER308H
High-temperature stainless work where 308H chemistry is specified.

Part number	Size / pack
RO331625H	1.6mm / 2.5kg
RO332425H	2.4mm / 2.5kg
RO333225H	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 309LSi

EN ISO 14343 23 12 LSi / AWS A5.9 ER 309LSi
Dissimilar stainless-to-carbon steel joints and clad steels.

Part number	Size / pack
RO341650	1.6mm / 5kg
RO342450	2.4mm / 5kg
RO343250	3.2mm / 5kg
RO341625	1.6mm / 2.5kg
RO342425	2.4mm / 2.5kg
RO391601	1.6mm / 1kg
RO391650	1.6mm / 5kg
RO392401	2.4mm / 1kg
RO392450	2.4mm / 5kg
RO393201	3.2mm / 1kg
RO393250	3.2mm / 5kg



Handbook datasheet

SIFTIG 310

AWS A5.9: ER310 / EN ISO 14343-A: S 25 20
Matching heat-resistant 310 stainless.

Part number	Size / pack
RT701625	1.6mm / 2.5kg
RT702425	2.4mm / 2.5kg
RT703225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 308L

EN ISO 14343-A: W 19 9 L / AWS A5.9: ER308L
304/304L stainless fabrication.

Part number	Size / pack
RO331650	1.6mm / 5kg
RO332450	2.4mm / 5kg
RO333250	3.2mm / 5kg
RO331050	1.0mm / 5kg
RO331601	1.6mm / 1kg
RO331625	1.6mm / 2.5kg
RO332425	2.4mm / 2.5kg
RO333225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 309L

AWS A5.9: ER309L / EN ISO 14343-A: S 23 12 L
Dissimilar stainless-to-carbon steel welds and specified cladding.

Part number	Size / pack
RO391625	1.6mm / 2.5kg
RO392425	2.4mm / 2.5kg
RO393225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 309LMo

EN ISO 14343-A: W 23 12 2 L / AWS A5.9: ER309LMo
Dissimilar welding requiring a molybdenum-bearing 309 deposit.

Part number	Size / pack
RO341625LMO	1.6mm / 2.5kg
RO342425LMO	2.4mm / 2.5kg
RO343225LMO	3.2mm / 2.5kg



Handbook datasheet

Choose by grade and service

308L suits compatible 304/304L. 309L suits specified dissimilar joints. For hot service, match the filler to the specified stainless grade and procedure.

© R H Davey Welding Supplies Ltd · Design and editorial content

Stainless TIG

SIFTIG 312

EN ISO 14343-A: W 29 9 / AWS A5.9: ER312
Specified repairs and difficult or dissimilar steel joints.

Part number	Size / pack
RO351050	1.0mm / 5kg
RO351250	1.2mm / 5kg
RO351625	1.6mm / 2.5kg
RO351650	1.6mm / 5kg
RO352425	2.4mm / 2.5kg
RO352450	2.4mm / 5kg
RO353225	3.2mm / 2.5kg
RO351025	312mm / 2.5kg
RO351225	312mm / 2.5kg



Handbook datasheet

SIFTIG 317L

EN ISO 14343-A: W 18 15 3 L / AWS A5.9: ER317L
317L stainless and specified corrosion-resistant fabrication.

Part number	Size / pack
RO241625	1.6mm / 2.5kg
RO242425	2.4mm / 2.5kg
RO243225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 410

EN ISO 14343-A: W 13
Matching 410 martensitic stainless.

Part number	Size / pack
RO4101625	1.6mm / 2.5kg
RO4102425	2.4mm / 2.5kg
RO4103225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 410NiMo

EN ISO 14343-A: W 13 4 / AWS A5.9: ER410NiMo
Compatible 410NiMo grades, including specified repair work.

Part number	Size / pack
RT4101625NM	1.6mm / 2.5kg
RT4102425NM	2.4mm / 2.5kg
RT4103225NM	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 316L

EN ISO 14343-A: W 19 12 3 L / AWS A5.9: ER316L
316/316L stainless fabrication.

Part number	Size / pack
RO210850	0.8mm / 5kg
RO211050	1.0mm / 5kg
RO211250	1.2mm / 5kg
RO211650	1.6mm / 5kg
RO212450	2.4mm / 5kg
RO213250	3.2mm / 5kg
RO210825	0.8mm / 2.5kg
RO211025	1.0mm / 2.5kg
RO211225	1.2mm / 2.5kg
RO211601	1.6mm / 1kg
RO211625	1.6mm / 2.5kg
RO212401	2.4mm / 1kg
RO212425	2.4mm / 2.5kg
RO213225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 347

EN ISO 14343-A: W 19 9 Nb / AWS A5.9: ER347
Stabilised stainless grades where niobium-stabilised filler is required.

Part number	Size / pack
RO201001	1.0mm / 1kg
RO201025	1.0mm / 2.5kg
RO201050	1.0mm / 5kg
RO201201	1.2mm / 1kg
RO201225	1.2mm / 2.5kg
RO201250	1.2mm / 5kg
RO201601	1.6mm / 1kg
RO201625	1.6mm / 2.5kg
RO201650	1.6mm / 5kg
RO202401	2.4mm / 1kg
RO202425	2.4mm / 2.5kg
RO202450	2.4mm / 5kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Stainless TIG

SIFTIG 420

AWS A5.9: ER420 / EN ISO 14343-A: W 13 C
Matching 420 martensitic stainless and specified repair work.

Part number	Size / pack
RO4201625	1.6mm / 2.5kg
RO4202425	2.4mm / 2.5kg
RO4203225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 2209

AWS A5.9: ER2209 / EN ISO 14343-A: W 22 9 3 N L
22% chromium duplex stainless work where this 2209 rod is specified.

Part number	Size / pack
RT741625	1.6mm / 2.5kg
RT742425	2.4mm / 2.5kg
RT743225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 316H

High-temperature 316-family stainless work where 316H is specified.

Part number	Size / pack
RO211650H	1.6mm / 5kg
RO212450H	2.4mm / 5kg



Supplier product information

SIFTIG 307Si

Specified dissimilar and difficult-to-weld steels.

Part number	Size / pack
RO301625	1.6mm / 2.5kg
RO302425	2.4mm / 2.5kg



Supplier product information

SIFTIG 825

Compatible nickel alloy 825 and specified dissimilar joints.

Part number	Size / pack
RO8251625	825mm / 2.5kg
RO8252425	825mm / 2.5kg



Supplier product information

SIFTIG 430

AWS A5.9: ER430 / EN ISO 14343-A: W 17
Matching 430 ferritic stainless.

Part number	Size / pack
RO4301625	1.6mm / 2.5kg
RO4302425	2.4mm / 2.5kg
RO4303225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG DUPLEX 2209

EN ISO 14343-A : W 22 9 3 N L / AWS A5.9: ER2209
22% chromium duplex stainless, including compatible 2205.

Part number	Size / pack
RT741650	1.6mm / 5kg
RT742450	2.4mm / 5kg
RT743250	3.2mm / 5kg



Handbook datasheet

SIFTIG 2594

EN ISO 14343-A: W 25 9 4 N L / AWS A5.9: ER2594
Compatible 25% chromium superduplex stainless.

Part number	Size / pack
RT781625	1.6mm / 2.5kg
RT782425	2.4mm / 2.5kg
RT783225	3.2mm / 2.5kg



Handbook datasheet

SIFTIG 317H

High-temperature 317-family stainless work where 317H is specified.

Part number	Size / pack
RO241625H	1.6mm / 2.5kg
RO242425H	2.4mm / 2.5kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Steel MIG & Cored

SIFMIG SG2/A18

EN ISO 14341-A: G 42 4 C1/M21 G3Si1 / AWS A5.18 ER70S-6
General mild and C-Mn steel fabrication.

Part number	Size / pack
WA180607	0.6mm / 0.7kg
WA180650	0.6mm / 5kg
WA180615	0.6mm / 15kg
WA180807	0.8mm / 0.7kg
WA180850	0.8mm / 5kg
WA180815	0.8mm / 15kg
WA1808250	0.8mm / 250kg
WA181050	1.0mm / 5kg
WA181015	1.0mm / 15kg
WA1810250	1.0mm / 250kg
WA181215	1.2mm / 15kg
WA1812250	1.2mm / 250kg



Handbook datasheet

SIFMIG ZERO SG3/G4Si1

EN ISO 14341-A: G 42 4 M21 4Si1 / AWS A5.18: ER70S-6
Copper-free G4Si1 wire for compatible semi-automatic and automated fabrication.

Part number	Size / pack
WA190818	0.8mm / 18kg
WA191018	1.0mm / 18kg
WA1910250	1.0mm / 250kg
WA191218	1.2mm / 18kg
WA1912250	1.2mm / 250kg



Handbook datasheet

SIFMIG A32 / ER80S-B2

EN ISO 21952-A: G CrMo1Si / AWS A5.28 : ER80S-B2
Compatible Cr-Mo steels where ER80S-B2 is specified.

Part number	Size / pack
WA320815	0.8mm / 15kg
WA321015	1.0mm / 15kg
WA321215	1.2mm / 15kg



Handbook datasheet

SIFMIG ZERO SG2/A18

EN ISO 14341-A-G 42 4 C1 / AWS A5.18 ER70S-6
Copper-free mild-steel MIG wire for clean feeding, including robotic work.

Part number	Size / pack
WA201018	1.0mm / 18kg
WA2010250	1.0mm / 250kg
WA201218	1.2mm / 18kg
WA2012250	1.2mm / 250kg



Handbook datasheet

SIFMIG SG3/G4Si1

EN ISO 14341-A: G 42 4 M21 4Si1 / AWS A5.18: ER70S-6
Higher Mn/Si wire for compatible steel fabrication.

Part number	Size / pack
WG030815	0.8mm / 15kg
WG0308250	0.8mm / 250kg
WG031015	1.0mm / 15kg
WG0310250	1.0mm / 250kg
WG031215	1.2mm / 15kg
WG0312250	1.2mm / 250kg



Handbook datasheet

SIFMIG A31 / ER80S-D2

EN ISO 14341-A-G4Mo / AWS A5.18 ER80S-D2
Higher-strength and manganese-molybdenum steels where ER80S-D2 is specified.

Part number	Size / pack
WA311015	1.0mm / 15kg
WA311215	1.2mm / 15kg



Handbook datasheet

SIFMIG 80S-Ni2

EN ISO 14341-A: G 50 6 M G2Ni2 / AWS A5.28 ER80S-Ni2
Nickel-bearing steel fabrication and repairs where the procedure specifies ER80S-Ni2.

Part number	Size / pack
WG721015	1.0mm / 15kg
WG721215	1.2mm / 15kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Steel MIG & Cored

SIFMIG E71T-GS

AWS A5.20 E71T-GS
All-position self-shielded wire for compatible mild steel. No external shielding gas.

Part number	Size / pack
WG180805	0.8mm / 0.45kg
WG180809	0.8mm / 0.9kg
WG180845	0.8mm / 4.55kg



Handbook datasheet

SIFCORED E71T-1M

EN ISO 17632-A: T 42 2 P M21 1 H5 / AWS A5.20: E71T-1M
All-position, low-hydrogen flux-cored wire with argon/CO2 shielding. Easy slag removal on vertical beads.

Part number	Size / pack
WO711215M	1.2mm / 15kg



Handbook datasheet

SIFCORED E110C-G

EN ISO 18276-A T 69 6 Mn2.5Ni M M 3 H5 / AWS A5.28: E110C-G H4
High-strength metal-cored wire for flat and horizontal welding with argon/CO2 shielding.

Part number	Size / pack
WO111212	1.2mm / 12.5kg

Handbook datasheet

SIFMIG HF600

EN ISO 14700 T Fe8
Wear-resistant overlays on suitable components.

Part number	Size / pack
WF601015	1.0mm / 15kg
WF601215	1.2mm / 15kg



Handbook datasheet

SIFCORED E70C-6M

EN ISO 17632-A-T 46 4 M M 1 H5 / AWS A5.18 E70C-6M
All-position metal-cored wire for carbon steel. Suitable for fast vertical-down welding with electrode-negative polarity.

Part number	Size / pack
WO701250	1.2mm / 5kg
WO701216	1.2mm / 16kg



Handbook datasheet

SIFCORED E71T-1

EN ISO 17632-A: T 42 2 P M21 1 H5 / AWS A5.20: E71T-1M
All-position rutile flux-cored wire for thin sheet and structural steel. Use argon/CO2 shielding.

Part number	Size / pack
WO711015	1.0mm / 15kg



Handbook datasheet

SIFCORED E71T-C

EN ISO 17632-A: T 42 4 C1 1 H5 / AWS A5.20: E71T-1C
All-position carbon-steel flux-cored wire for 100% CO2 shielding. Good penetration and easy slag removal.

Part number	Size / pack
WO711615	1.6mm / 15kg
WO711215	1.2mm / 15kg



Handbook datasheet

SIFMIG ER120S-G

High-strength steel fabrication where the welding procedure calls for ER120S-G.

Part number	Size / pack
WG121015	1.0mm / 15kg
WG121215	1.2mm / 15kg



Supplier product information

Match the wire to the feed system

SIFMIG ZERO SG2 is a copper-free option for compatible mild-steel work, including automated welding. Specify the wire diameter and spool or drum size the feeder accepts.

© R H Davey Welding Supplies Ltd · Design and editorial content

Steel MIG & Cored

SIFMIG A15

Triple-deoxidised wire for compatible carbon-steel fabrication.

Part number	Size / pack
WA150815	0.8mm / 15kg
WA151215	1.2mm / 15kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Steel TIG

SIFTIG A15 / 70S-2

EN ISO 636-A: W 46 2 2 / EN 1668 W2Ti
Deoxidised mild-steel TIG filler for compatible carbon steel pipe and fabrication.

Part number	Size / pack
RA151050	1.0mm / 5kg
RA151250	1.2mm / 5kg
RA151650	1.6mm / 5kg
RA152450	2.4mm / 5kg
RA153250	3.2mm / 5kg



Handbook datasheet

SIFTIG A32 / 80S-B2

EN ISO 21952-A: W CrMo1Si
Specified Cr-Mo steel welding.

Part number	Size / pack
RA321050	1.0mm / 5kg
RA321250	1.2mm / 5kg
RA321650	1.6mm / 5kg
RA322450	2.4mm / 5kg



Handbook datasheet

SIFTIG 80S-Ni2

EN ISO 636A W2Ni2 / AWS A5.28 ER80S-Ni2
Specified nickel-bearing low-alloy steel fabrication and repair.

Part number	Size / pack
RT722450	2.4mm / 5kg
RT723250	3.2mm / 5kg



Handbook datasheet

SIFTIG A32

Part number	Size / pack
RA323050	3.0mm / 5kg



Supplier product information

SIFTIG A18 / 70S-6

EN ISO 636-A W 46 4 Z W3Si1 / AWS A5.18 ER70S-6
Mild and C-Mn steel TIG fabrication.

Part number	Size / pack
RA181050	1.0mm / 5kg
RA181250	1.2mm / 5kg
RA181650	1.6mm / 5kg
RA182450	2.4mm / 5kg
RA183250	3.2mm / 5kg



Handbook datasheet

SIFTIG A31 / 80S-D2

EN ISO 636-B: W 57 A 3
Compatible higher-strength and Mn-Mo steels.

Part number	Size / pack
RA311650	1.6mm / 5kg
RA312450	2.4mm / 5kg



Handbook datasheet

SIFTIG A33 / 80S-Ni2

EN ISO 21952-A: W CrMo2Si
Nickel-bearing filler for compatible low-alloy steels.

Part number	Size / pack
RA331650	1.6mm / 5kg
RA332450	2.4mm / 5kg



Handbook datasheet

SIFTIG A15

Triple-deoxidised wire for compatible carbon-steel fabrication.

Part number	Size / pack
RA151025	1.0mm / 2.5kg
RA151225	1.2mm / 2.5kg
RA151625	1.6mm / 2.5kg
RA152425	2.4mm / 2.5kg
RA153225	3.2mm / 2.5kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Specialist TIG

SIFTIG AZ61A / No. 23

AWS A5.19 ERAZ61A
Compatible magnesium alloys and castings.

Part number	Size / pack
RO233212	3.0mm / 12Rod
RO233201	3.0mm / 1kg



Handbook datasheet

SIFTIG HF6

EN ISO 14700 SFe4 / AWS A5.21 ERFe6
Wear-resistant TIG overlays on suitable components.

Part number	Size / pack
ROHF61612	1.6mm / 12rod
ROHF61601	1.6mm / 1kg
ROHF62412	2.4mm / 12rod
ROHF62401	2.4mm / 1kg



Handbook datasheet

SIFTIG Ti5 6-4 / No. 75

AWS A5.16 ERTi-5
Titanium alloy fabrication where Grade 5 filler is specified.

Part number	Size / pack
RT751025	1.0mm / 2.5kg
RT751225	1.2mm / 2.5kg
RT751625	1.6mm / 2.5kg
RT752425	2.4mm / 2.5kg
RT751201	1.2mm / 1kg
RT751601	1.6mm / 1kg



Handbook datasheet

SIFTIG TI2

Commercially pure titanium Grade 2 components.

Part number	Size / pack
RT921625	1.6mm / 2.5kg
RT922025	2.0mm / 2.5kg



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

MMA Electrodes

SIFTRODE 6013

EN ISO 2560-A E 42 0 RC 11 / AWS A5.1 E 6013
Rutile electrode for mild-steel fabrication and maintenance. All positions except vertical-down.

Part number	Size / pack
RE802050	2.0mm / 5kg
RE802550	2.5mm / 5kg
RE803250	3.2mm / 5kg
RE804050	4.0mm / 5kg



Handbook datasheet

SIFTRODE 7018

EN ISO 2560-A E 42 4 B 31 H5 / AWS A5.1: E7018
Low-hydrogen iron-powder electrode for carbon steel fabrication. All positions except vertical-down.

Part number	Size / pack
RE762501	2.5mm / 1.5kg vacuum pack
RE762550	2.5mm / 5kg standard pack
RE763250	3.2mm / 5kg standard pack
RE763201	3.2mm / 1.5kg vacuum pack
RE764001	4.0mm / 1.5kg vacuum pack
RE764050	4.0mm / 5kg standard pack



Handbook datasheet

SIFTRODE HF-600

Hardfacing electrode for wear-resistant overlays on suitable steel components.

Part number	Size / pack
RE6003250	3.2mm / 5kg
RE6004050	4.0mm / 5kg
RE6005050	5.0mm / 5kg



Supplier product information

SIFTRODE 7016

EN ISO 2560-A: E 42 3 B 32 H10 / AWS A5.1 E 7016
Low-hydrogen electrode for root passes and compatible carbon steel. All positions except vertical-down.

Part number	Size / pack
RE712550V	2.5mm / 5kg vacuum pack
RE712550	2.5mm / 5kg standard pack
RE713250V	3.2mm / 5kg vacuum pack
RE713250	3.2mm / 5kg standard pack
RE714050V	4.0mm / 5kg vacuum pack
RE714050	4.0mm / 5kg standard pack



Handbook datasheet

SIFTRODE Ni

Nickel core electrode for repair of compatible grey and malleable cast irons.

Part number	Size / pack
RE5002501	2.5mm / 1kg
RE5003201	3.2mm / 1kg
RE5004001	4.0mm / 1kg



Supplier product information

SIFTRODE NiFe

Nickel-iron electrode for specified cast-iron repairs and cast iron-to-steel joints.

Part number	Size / pack
RE4002501	2.5mm
RE4003201	3.2mm



Supplier product information

SIFTRODE E307

Specified difficult-to-weld and dissimilar steels.

Part number	Size / pack
RC3072540	2.5mm / 4kg vacuum pack



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

MMA Electrodes

SIFTRODE E308L

304/304L stainless fabrication and maintenance.

Part number	Size / pack
RC3082540	2.5mm / 4kg vacuum pack
RC3083240	3.2mm / 4kg vacuum pack
RC3084040	4.0mm / 4kg vacuum pack



Supplier product information

SIFTRODE E316L

316/316L stainless fabrication.

Part number	Size / pack
RC3162040	2.0mm / 4kg vacuum pack
RC3162540	2.5mm / 4kg vacuum pack
RC3163240	3.2mm / 4kg vacuum pack
RC3164040	4.0mm / 4kg vacuum pack



Supplier product information

SIFTRODE E309L

Specified dissimilar joints and stainless-to-steel fabrication.

Part number	Size / pack
RC3092540	2.5mm / 4kg vacuum pack
RC3093240	3.2mm / 4kg vacuum pack



Supplier product information

SIFTRODE E312

Selected difficult-to-weld steels and maintenance joints.

Part number	Size / pack
RC3122540	2.5mm / 4kg vacuum pack
RC3123240	3.2mm / 4kg vacuum pack
RC3124040	4.0mm / 4kg vacuum pack



Supplier product information

© R H Davey Welding Supplies Ltd · Design and editorial content

Gas Welding & Brazing

SIFSILCOPPER No. 7 C1

EN ISO 24373: Cu 1897 (CuAg1)
Copper fabrication and repair, including compatible deoxidised copper sheet and fittings.

Part number	Size / pack
RO071601	1.6mm / 1kg
RO071625	1.6mm / 2.5kg
RO071650	1.6mm / 5kg
RO072401	2.4mm / 1kg
RO072425	2.4mm / 2.5kg
RO072450	2.4mm / 5kg
RO073201	3.2mm / 1kg
RO073225	3.2mm / 2.5kg
RO073250	3.2mm / 5kg



Handbook datasheet

SIFSTEEL No. 22

Oxy-fuel filler rod. Specify the grade and size for the repair.

Part number	Size / pack
RO221650	1.6mm / 5kg



Supplier product information

SUPERSILICON No. 9

EN 12536
Gas fusion welding of cast iron. The silicon-rich rod is intended for casting repairs.

Part number	Size / pack
RO096050	6mm / 5kg



Handbook datasheet

SIFSTEEL No. 11 / A1

EN 12536
Low-carbon steel gas welding for fabrication and repair.

Part number	Size / pack
RO111601	1.6mm / 1kg
RO111625	1.6mm / 2.5kg
RO111650	1.6mm / 5kg
RO112401	2.4mm / 1kg
RO112425	2.4mm / 2.5kg
RO112450	2.4mm / 5kg
RO113201	3.2mm / 1kg
RO113225	3.2mm / 2.5kg
RO113250	3.2mm / 5kg
RO114850	4.8mm / 5kg
RO221650	1.6mm / 5kg
RO222550	2.5mm / 5kg
RO223050	3.0mm / 5kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Brazing & Soldering

SIFREDICOTE C2 / No. 1

EN ISO 17672 CU 302
Flux-coated bronze for workshop repairs, mild steel and specified dissimilar joints.

Part number	Size / pack
RR011601	1.6mm / 1kg
RR011625	1.6mm / 2.5kg
RR012401	2.4mm / 1kg
RR012425	2.4mm / 2.5kg
RR012450	2.4mm / 5kg
RR013201	3.2mm / 1kg
RR013225	3.2mm / 2.5kg
RR013250	3.2mm / 5kg

Handbook datasheet

SIFBRONZE No. 101

Bronze brazing, including compatible joints using the SIF liquid flux system.

Part number	Size / pack
RO101501	1.5mm / 1kg
RO101525	1.5mm / 2.5kg
RO101550	1.5mm / 5kg
RO102001	2.0mm / 1kg
RO102025	2.0mm / 2.5kg
RO102050	2.0mm / 5kg
RO102501	2.5mm / 1kg
RO102525	2.5mm / 2.5kg
RO102550	2.5mm / 5kg
RO103001	3.0mm / 1kg
RO103025	3.0mm / 2.5kg
RO103050	3.0mm / 5kg
RO101510	101mm / 10kg
RO102010	101mm / 10kg
RO102510	101mm / 10kg



Handbook datasheet

SIFBRONZE C2 / No. 1

EN ISO 17672 CU302
Bare bronze for workshop fabrication and repair. Match with the correct separate flux.

Part number	Size / pack
RO011601	1.6mm / 1kg
RO011625	1.6mm / 2.5kg
RO011650	1.6mm / 5kg
RO012401	2.4mm / 1kg
RO012425	2.4mm / 2.5kg
RO012450	2.4mm / 5kg
RO013201	3.2mm / 1kg
RO013225	3.2mm / 2.5kg
RO013250	3.2mm / 5kg
RO014850	4.8mm / 5kg



Handbook datasheet

SIFCUPRON CP1 / 15Ag

EN ISO 17672 CuP 284 / EN ISO 17672 CP102
15% silver copper-phosphorus rod for specified copper pipework and fittings.

Part number	Size / pack
RO181506	1.5mm / 6Rod



Handbook datasheet

SIFCUPRON CP2 / 2Ag

EN ISO 17672 CuP 182 / EN ISO 17672 CP105
2% silver copper-phosphorus rod for specified copper joints.

Part number	Size / pack
BS1845	1.6mm
RO181601	1.6mm / 1kg
RO181625	1.6mm / 2.5kg
RO181650	1.6mm / 5kg
RO182401	2.4mm / 1kg
RO182425	2.4mm / 2.5kg
RO182450	2.4mm / 5kg
RO183201	3.2mm / 1kg
RO183225	3.2mm / 2.5kg
RO183250	3.2mm / 5kg
RO181510	1.5mm / 1kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Brazing & Soldering

SIFCUPRON CP3

EN ISO 17672 CuP 180 / EN ISO 17672 CP201
Copper-phosphorus filler for compatible copper-to-copper joints.

Part number	Size / pack
RO171501	1.5mm / 1kg
RO171525	1.5mm / 2.5kg
RO171550	1.5mm / 5kg
RO172401	2.4mm / 1kg
RO172425	2.4mm / 2.5kg
RO172450	2.4mm / 5kg
RO173201	3.2mm / 1kg
RO173225	3.2mm / 2.5kg
RO173250	3.2mm / 5kg



Handbook datasheet

SIF Silver Solder 40%

EN ISO 17672 Ag 140
40% silver alloy for close-fitting compatible joints.

Part number	Size / pack
RX401500	1.5mm / 1kg
RX402000	2.0mm / 1kg



Handbook datasheet

SIF Silvercote 55%

EN ISO 17672 AG 155 / EN 1044 AG 103
Flux-coated 55% silver alloy for compatible capillary joints.

Part number	Size / pack
RR431506	1.5mm / 6Rod
RR431501	1.5mm / 1kg



Handbook datasheet

SIF C2

Part number	Size / pack
RO011610	1.6mm / 10kg



Supplier product information

SIFCUPRON CP4 / 5Ag

EN ISO 17672 CuP 282 / EN ISO 17672 CP104
5% silver copper-phosphorus rod for compatible copper tubing.

Part number	Size / pack
RO1815015AG	1.5mm / 1kg
RO1815255AG	1.5mm / 2.5kg
RO1815505AG	1.5mm / 5kg
RO1825015AG	2.5mm / 1kg
RO1825255AG	2.5mm / 2.5kg
RO1825505AG	2.5mm / 5kg



Handbook datasheet

SIF Silver Solder 38%

EN ISO 17672 Ag 138
38% silver brazing alloy for compatible capillary joints.

Part number	Size / pack
RO391506	1.5mm / 6Rod
RX391500	1.5mm / 1kg



Handbook datasheet

SIF Silver Solder 55%

EN ISO 17672 Ag 155
55% silver brazing alloy for close-fitting joints and suitable dissimilar combinations.

Part number	Size / pack
RO431506	1.5mm / 6Rod
RX431500	1.5mm / 1kg



Handbook datasheet

SIF 555 Aluminium Solder

Low-temperature aluminium solder for compatible aluminium repairs.

Part number	Size / pack
RO553212	3.00mm / 12Rod
RO553201	3.00mm / 1kg
RO553225	3.00mm / 2.5kg



Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Brazing & Soldering

SIF C2

Part number	Size / pack
RO012410	2.4mm / 10kg



Supplier product information

SIF C2

Part number	Size / pack
RO013210	3.2mm / 10kg



Supplier product information

SIF C2

Part number	Size / pack
RO014810	4.8mm / 10kg



Supplier product information

Choose a filler for the joint fit

For compatible close-fitting joints, a free-flowing silver alloy helps filler move through the joint. Silvercote 55% has an integral flux coating for procedures that specify a coated rod.

© R H Davey Welding Supplies Ltd · Design and editorial content

Tungsten Electrodes

2% Thoriated • Red

DC TIG where a thoriated electrode is specified. Follow the handling and grinding instructions.

Part number	Size / pack
HP16110	1.0mm
HP16112	1.2mm
HP16116	1.6mm
HP16124	2.4mm
HP16132	3.2mm

Handbook datasheet

Superstrike • Blue

Use where the procedure calls for the Superstrike type.

Part number	Size / pack
HP16716	1.6mm
HP16724	2.4mm
HP16732	3.2mm

Handbook datasheet

Zirconiated • White

AC TIG on compatible aluminium alloys.

Part number	Size / pack
HP16216	1.6mm
HP16224	2.4mm
HP16232	3.2mm

Handbook datasheet

Ceriated • Grey

Low-current TIG where a ceriated tungsten is specified.

Part number	Size / pack
HP16310	1.0mm
HP16312	1.2mm
HP16316	1.6mm
HP16324	2.4mm
HP16332	3.2mm

Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content

Fluxes

SIF Aluminium Flux

Choose No. 12 for lower-melting aluminium fillers, No. 14 for intermediate and No. 36 for higher-melting grades.

Part number	Size / pack
FO120050	No. 12 / 500g
FO140050	No. 14 / 500g
FO360050	No. 36 / 500g

Handbook datasheet

SIFSILCOPPER Flux

For compatible copper and copper-alloy welding and brazing.

Part number	Size / pack
FO070050	500g jar

Handbook datasheet

SIFTIG Purging Flux

Root-side flux for suitable stainless steel and nickel alloy TIG work. Follow the applicable welding procedure.

Part number	Size / pack
FO210050	500g jar



Supplier product information

SIF Bronze Flux

Match the powder to SIFBRONZE No. 1 or No. 101.

Part number	Size / pack
FO010050	No. 1 / 500g
FO100050	No. 101 / 500g

Handbook datasheet

SIF Gasflux Liquid

Flux delivered through a compatible gas-flux system. Check transport and collection terms when ordering.

Part number	Size / pack
FXGF3LS	3L container

Handbook datasheet

SIF Silver Solder Flux

Match to compatible silver brazing alloys and base metals.

Part number	Size / pack
FO380050	500g jar
FO380022	225g jar

Handbook datasheet

© R H Davey Welding Supplies Ltd · Design and editorial content