Проволока и прутки из нержавеющей стали для дуговой сварки в среде защитного газа ELOX SG

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Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 307

Standards

TS EN ISO 14343-A	: G 18 8 Mn
EN ISO 14343-A	: G 18 8 Mn
TS EN ISO 14343-A	: W 18 8 Mn
EN ISO 14343-A	: W 18 8 Mn
AWS A5.9	: ~ER 307

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.08	0.9	7.0	19.2	9.0

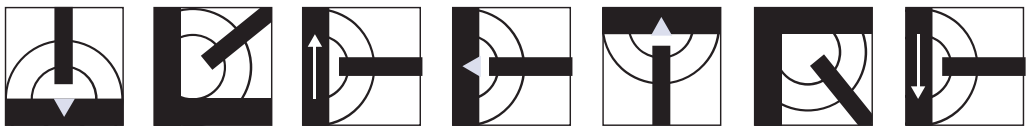
Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%))
min. 370	580 - 750	min. 63 J	min. 30

Features and Applications

- Filler welding of high-strength low-alloyed and alloyed heat-treatable steels, armor steels, steels including 14 % Mn, ferritic chromium steels, heat-resistant steels, non-magnetic steels etc.
- Joint welding of different types of steels with each other
- Filler welding of abrasion-resistant steels for valves and turbines
- As shielding gas, Argon is used at TIG welding, where as Ar+ % 2.5 O_2 or Ar+ % 2.5 CO_2 mixed gas is used at MIG welding

Welding Positions



Current Type

MIG DC(+) / TIG DC(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100313	0,8	0.030”	12.5	BS 300
6011100381	1	0.040”	15	BS 300
6011100314	1,2	0.047”	15	BS 300
6011100312	1,6	0.062”	15	BS 300
6011100315	2,00 x 1000	5/64 x 39”	5	Plastic Box
6011100316	2,40 x 1000	3/32 x 39”	5	Plastic Box
6011100317	3,20 x 1000	1/8 x 39”	5	Plastic Box

Approvals: SEPRO, DB

Stainless Steel Gas Shielded Welding Rod

ELOX SG 308-H

Standards

TS EN ISO 14343-A	: W 19 9 H
EN ISO 14343-A	: W 19 9 H
AWS A5.9	: ER 308 H

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.06	0.5	1.7	20.1	9.8

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/0°C)	**Elongation** (($L_o=5d_o$) (%)
min. 350	min. 550	min. 63 J	min. 25

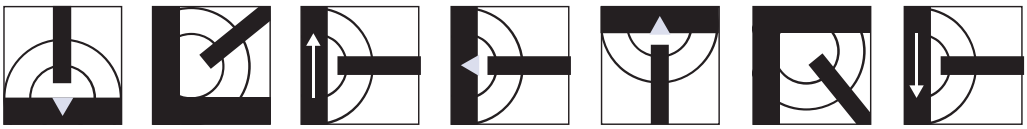
Typical Base Material Grades

- X2 CrNi 19 11, X5 CrNi 19 11, X 5 CrNi 18 8, X 12 CrNi 17 7, X 12 CrNi 18 8, G-X 10 CrNi 18 8, G-X 12 CrNi 18 8
- AISI: 304 L, 301,302,304,308

Features and Applications

- Applicability in welding tempered high-strength steels as well as stainless steels, carbon steels, and 18/8, Cr-Ni -alloy steels
- Requirement of use of Ar as “shielding gas for TIG welding”

Welding Positions



Current Type

TIG D.C.(-), MIG D.C.(+)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100318	2.0 x 1000	5/64 x 39”	5	Plastic Box
6011100319	2.4 x 1000	3/32 x 39”	5	Plastic Box
6011100320	3.2 x 1000	1/8 x 39”	5	Plastic Box

Approvals: SEPRO, CE

Stainless Steel Gas Shielded Welding Rod

ELOX SG 308 L

Standards

TS EN ISO 14343-A	: W 19 9 L
EN ISO 14343-A	: W 19 9 L
AWS A5.9	: ER 308 L

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.02	0.5	1.7	20.1	9.8

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%)
min. 390	540 - 660	min. 63 J	min. 35

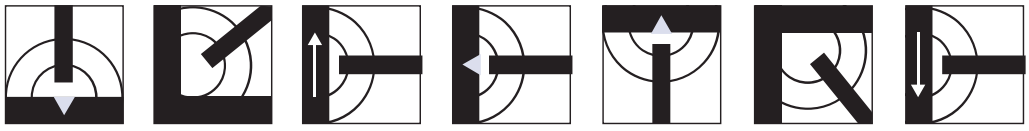
Typical Base Material Grades

- X2CrNi 19 11, X5CrNi 18 10, X6CrNiTi 18 10, X6CrNiNb 18 10, X2CrNiN 18 10, X10CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 347, 321, A320Gr.B8C, A320Gr.B8D

Features and Applications

- TIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304, or stabilized steels of type 347, or steels of similar qualities, all of which used in drug, cellulose, paper and food (production) industries
- The shielding gas is Argon (Ar).
- Maintenance of ductile behavior at temperature values down to -196°C
- Maintenance of resistance against intergranular corrosion at temperatures up to 400°C

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100424	1.00 x 1000	0.040” x 39”	5	Plastic Box
6011100321	1.20 x 1000	0.047” x 39”	5	Plastic Box
6011100326	1.6 x 1000	1/16 x 39”	5	Plastic Box
6011100327	2.0 x 1000	5/64 x 39”	5	Plastic Box
6011100328	2.4 x 1000	3/32 x 39”	5	Plastic Box
6011100329	3.2 x 1000	1/8 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire

ELOX SG 308 L Si

Standards

TS EN ISO 14343-A	: G 19 9 L Si
EN ISO 14343-A	: G 19 9 L Si
AWS A5.9	: ER 308 LSi

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.02	0.8	1.7	20.4	10.2

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/+20°C)	**Elongation** (($L_o=5d_o$) (%)
min. 350	520 - 660	min. 63 J	min. 35

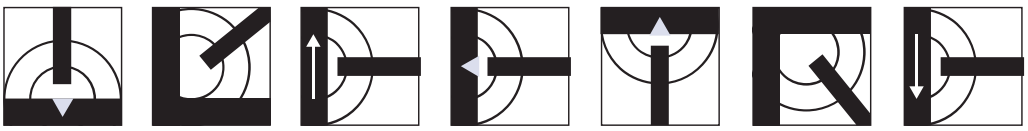
Typical Base Material Grades

- X2 CrNi 19 11, X5CrNi 18 10, X6 CrNiTi 18 10, X6 CrNiNb 18 10, X2 CrNiN 18 10, X10 CrNiNb 18 10
- AISI & ASTM: 304, 304L, 304LN, 321, 347, A320Gr.B8C, A320Gr.B8D

Features and Applications

- MIG welding of 13% Cr ferritic stainless steels, high-carbon steels of type 304 or stabilized steels of type 347, or steels of similar types, used in industries of drug, cellulose, paper, and food (production)
- Ar+%2.5O_2 or Ar+%2.5CO_2 mixed gas is used as shielding gas
- Maintenance of ductile behavoir at temperature valuesdown to -196°C.
- Maintenance of resistance to intergranular corrosion at temperatures up to 350°C

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	**Diameter** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100323	0.8	0.030”	12.5	BS 300
6011100324	1.0	0.040”	15	BS 300
6011100382	1.2	0.047”	15	BS 300
6011100322	1.6	0.062”	15	BS 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Rod

ELOX SG 309 L

Standards

TS EN ISO 14343-A	: W 23 12 L
EN ISO 14343-A	: W 23 12 L
AWS A5.9	: ER 309 L

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.03	0.45	1.80	23.5	13.0

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/+20°C)	**Elongation** (($L_o=5d_o$) (%)
min. 320	min. 520	min. 47 J	min. 30

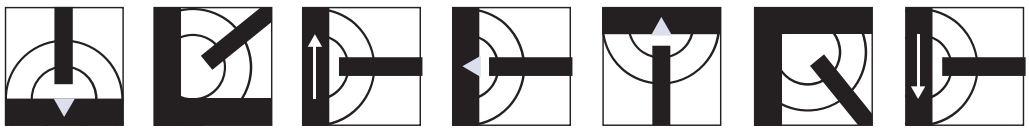
Typical Base Material Grades

- Ferritic Cr and austenitic CrNi steels, austenitic manganese steels, unalloyed high strength steels, high temperature steels

Features and Applications

- Applicability on ferritic Cr or austenitic CrNi steels, austenitic manganese steels, unalloyed high-strength steels, heat-treated steels
- Usability in welding austenitic stainless steels, in joint-welding of different kinds of metals, in buffer layers, in joint-welding of corrosion-resistant stainless steels to each other or to low-alloyed steels, and in welding coated steels
- Requirement of use of Ar as shielding gas

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100333	1.6 x 1000	1/16 x 39”	5	Plastic Box
6011100334	2.0 x 1000	5/64 x 39”	5	Plastic Box
6011100335	2.4 x 1000	3/32 x 39”	5	Plastic Box
6011100396	3.2 x 1000	1/8 x 39”	5	Plastic Box

Approvals: CE, SEPRO, NK, RINA, DNV-GL, TL

Stainless Steel Gas Shielded Welding Wire

ELOX SG 309 L Si

Standards

TS EN ISO 14343-A	: G 23 12 L Si
EN ISO 14343-A	: G 23 12 L Si
AWS A5.9	: ER 309 L Si

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.03	0.80	1.80	23.5	13.0

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/+20 °C)	**Elongation** (($L_o=5d_o$) (%)
min. 320	min. 520	min. 47 J	min. 30

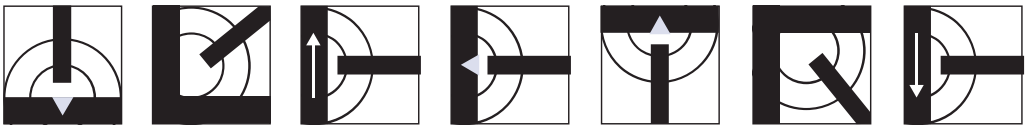
Typical Base Material Grades

- Ferritic Cr and austenitic CrNi steels, austenitic manganese steels, unalloyed high strength steels, high temperature steels.

Features and Applications

- Applicability on ferritic Cr or austenitic CrNi steels, austenitic manganese steels, unalloyed high-strength steels, heat-treated steels
- Usability in welding austenitic stainless steels, in joint- welding of different kinds of metals, in buffer layers, in joint-welding of corrosion-resistant stainless steels to each other or to low-alloyed steels, and in welding coated steels
- Ar+ %2.5 O_2 or (Ar+%2.5 CO_2) gas is used as shielding gas

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	**Diameter** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100383	0.8	0.030”	12.5	BS 300
6011100331	1.0	0.040”	15	BS 300
6011100332	1.2	0.047”	15	BS 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 310

Standards

TS EN ISO 14343-A	: G 25 20
EN ISO 14343-A	: G 25 20
TS EN ISO 14343-A	: W 25 20
EN ISO 14343-A	: W 25 20
AWS A5.9	: ER 310

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.12	0.5	1.6	25.0	20.5

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/+20°C)	**Elongation** (($L_o=5d_o$) (%)
min. 350	550 - 720	min. 63 J	min. 30

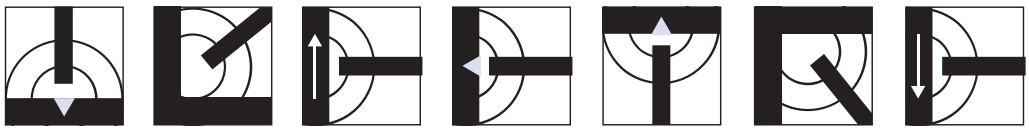
Typical Base Material Grades

- X15CrNiSi 25 20, X12CrNi 25 21, X15CrNi 20 12, G-X15CrNi 25 20, G-X40 CrNi 25 21, X10CrAl 7, X10CrAl 18, X10CrAl 24, 305, 310, 314, A297 HF, A297 HJ

Features and Applications

- Applicability in cement and ceramic industries, in manufacturing processes of industrial furnaces, oil refineries, in welding of steel and steel castings used in steam boiler manufacturing
- Suitability of weld metal for use at temperatures between -196°C and 1200°C
- Suitability for both TIG and MIG welding
- Requirement of use of Ar as shielding gas in TIG welding, and of Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gas as shielding in MIG welding

Welding Positions



Current Type

TIG D.C.(-) / MIG D.C.(+)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100402	0,8	0.030”	12.5	BS 300
6011100338	1	0.040”	15	BS 300
6011100374	1,2	0.047”	15	BS 300
6011100339	1,60 x 1000	1/16 x 39”	5	Plastic Box
6011100340	2,00 x 1000	5/64 x 39”	5	Plastic Box
6011100341	2,40 x 1000	3/32 x 39”	5	Plastic Box
6011100342	3,20 x 1000	1/8 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 312

Standards

TS EN ISO 14343-A	: G 29 9
EN ISO 14343-A	: G 29 9
TS EN ISO 14343-A	: W 29 9
EN ISO 14343-A	: W 29 9
AWS A5.9	: ER 312

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni
0.12	0.40	1.80	30.0	9.0

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%))
min. 450	min. 660	47 J	min. 20

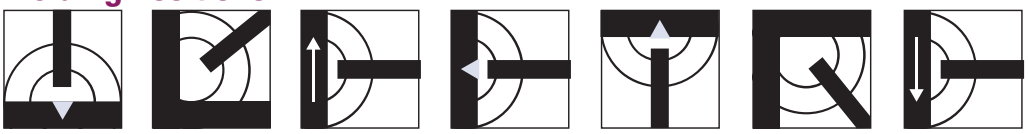
Typical Base Material Grades

DIN:	X7Cr13	G-X 7 Cr 13	AISI:	403
	X7CrAl13	G-X 20 Cr 14		405
	X10CrAl13	G-X 10 Cr Mo 13		410
	X 8 Cr17	G-X 8 Cr Ni 13		420
	X20Cr13			430
	X 15Cr 13			430 Ti
	X22CrNi17			431
	X15CrNi134			446
	X 8 Cr Ti 17			

Features and Applications

- Applicability in joint- welding of unalloyed and alloyed high-strength steels, Cr and Mn steels, tool steels, and of different metals
- Resistance to wearing, cracking and corrosion
- Requirement of use of Ar as shielding gas in TIG welding, and Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mix as shield gas in MIG welding

Welding Positions



Current Type

TIG D.C.(-) / MIG D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100153	0,8	0.030”	15	BS 300
6011100343	1	0.040”	15	BS 300
6011100156	1,2	0.047”	15	BS 300
6011100157	1,60 x 1000	1/16 x 39”	5	Plastic Box
6011100344	2,00 x 1000	5/64 x 39”	5	Plastic Box
6011100345	2,40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Rod

ELOX SG 316 L

Standards

TS EN ISO 14343-A	: W Z 19 12 3 L
EN ISO 14343-A	: W Z 19 12 3 L
AWS A5.9	: ER 316 L

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Mo	Cr	Ni
0.02	0.5	1.6	2.2	18.5	11.5

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%)
min. 420	570 - 700	min. 63 J	min. 30

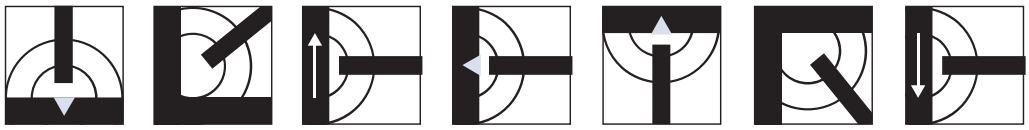
Typical Base Material Grades

- X2 CrNiMo 1814 3, XS CrNiMo 1713 3, X2 CrNiMo 1713 2, XS CrNiMoTi 1712 2, X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X2 CrNiMoN 1713 3, X2 CrNiMoN 1712 2
- AISI: 316, 316L, 316Cb, 316Ti

Features and Applications

- TIG welding of 13% Cr ferritic stainless steels, high-carbon or stabilized steels of type 316, low-carbon stainless steels of type 316 L, all of which are used in machinery and equipment parts at production plants for food, chemical, drug textile and similar kinds of industries
- As shielding gas, Argon (Ar) is used
- Maintenance of resistance to intergranular corrosion at temperature valves up to 400°C.
- Resistance to low temperatures varying at values down to -196°C

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100169	1,00 x 1000	0.040” x 39”	5	Plastic Box
6011100399	1,20 x 1000	0.047” x 39”	5	Plastic Box
6011100351	1,60 x 1000	1/16 x 39”	5	Plastic Box
6011100400	2,00 x 1000	5/64 x 39”	5	Plastic Box
6011100352	2,40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO, TL, DNV-GL, NK, RINA

Stainless Steel Gas Shielded Welding Wire

ELOX SG 316 L Si

Standards

TS EN ISO 14343-A	: G Z 19 12 3 L Si
EN ISO 14343-A	: G Z 19 12 3 L Si
AWS A5.9	: ER 316 LSi

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo
0.02	0.80	1.6	18.5	11.5	2.2

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation (($L_o=5d_o$) (%)
min. 400	550 - 700	min. 63 J	min. 30

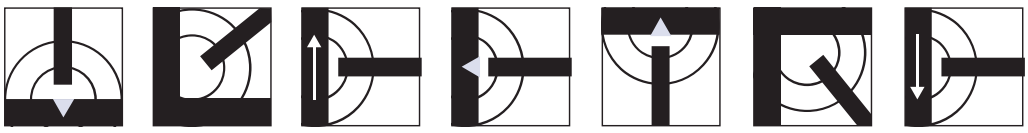
Typical Base Material Grades

- X2 CrNiMo 1814 3, X5 CrNiMo 17 13 3, X2 CrNiMo 1713 2,, X5 CrNiMo 1712 2, X6 CrNiMoTi 17 12 2, X6 CrNiMoNb 17 12 2, X2 CrNiMoN 1713 3, X2 CrNiMoN 1712 2
- AISI: 316, 316Cb, 316L, 316Ti

Features and Applications

- MIG welding of 13% ferritic stainless steels, high-carbon or stabilized stainless steels of type 316 and low carbon stainless steels of type 316 L, used in machinery and equipment parts of production plants for food, chemical, drug, textile and similar kinds of industries
- As shielding gas, Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gas is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400°C.
- Resistance to low temperatures varying at values down to -196°C

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
6011100348	0,8	0.030”	12.5	BS 300
6011100398	1	0.040”	15	BS 300
6011100349	1,2	0.047”	15	BS 300
6011100350	1,6	0.062”	15	BS 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Rod

ELOX SG 318

Standards

TS EN ISO 14343-A	: W 19 12 3 Nb
EN ISO 14343-A	: W 19 12 3 Nb
AWSA5.9	: ER 318

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo	Nb
0.035	0.50	1.7	19.6	11.4	2.7	+

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%))
min. 440	640 - 780	min. 63 J	min. 30

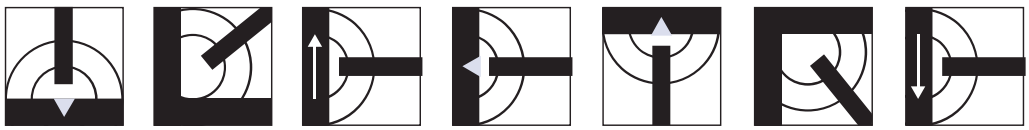
Typical Base Material Grades

- X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X5 CrNiMo 1712 2, G-X5 CrNiMoNb 18 10, X10 CrNiMoNb 18 12
- AISI: 316, 316Cb, 316L, 316Ti

Features and Applications

- TIG welding of 13% ferritic stainless steels as well as of stainless steels of similar chemical compositions as those of welding wires used in chemical, textile, paint, food and synthetic resin production
- As the shielding gas, argon(Ar) is used
- Maintenance of resistance to intergranular corrosion at temperature values up to 400 °C

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100401	1.6 x 1000	1/16 x 39”	5	Plastic Box
6011100356	2.0 x 1000	5/64 x 39”	5	Plastic Box
6011100180	2.4 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire

ELOX SG 318 Si

Standards

TS EN ISO 14343-A	: G 19 12 3 Nb Si
EN ISO 14343-A	: G 19 12 3 Nb Si
AWS A5.9	: ~ER 318

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo	Nb
0.035	0.8	1.4	19.9	11.5	2.8	+

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Impact Strength** (ISO-V/+20°C)	**Elongation** (($L_o=5d_o$) (%)
min. 390	600 - 780	min. 63 J	min. 30

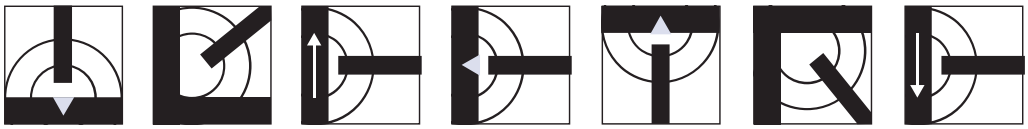
Typical Base Material Grades

- X6 CrNiMoTi 1712 2, X6 CrNiMoNb 1712 2, X5 CrNiMo 1712 2, G-X5 CrNiMoNb 1810, G-X10 CrNiMo 18 10, X10 CrNiNb 1810, X10 CrNiMoNb 1812
- AISI: 316, 316Cb, 316L, 316Ti

Features and Applications

- Used for the welding of 13% ferritic stainless steels or stainless steels which have the similar chemical analysis to welding wires that are used in the chemical, textile, paint and food industries
- Weld metal is resistant to corrosion up to +400°C and chlorine
- Suitable for MIG welding
- Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gases are the shielding gases.

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	**Diameter** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100357	1.0	0.040”	15	BS 300
6011100406	1.2	0.047”	15	BS 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Rod

ELOX SG 347

Standards

TS EN ISO 14343-A	: W 19 9 Nb
EN ISO 14343-A	: W 19 9 Nb
AWS A5.9	: ER 347

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Nb
0.035	0.5	1.4	19.4	9.5	+

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%)
min. 430	600 - 740	min. 63 J	min. 30

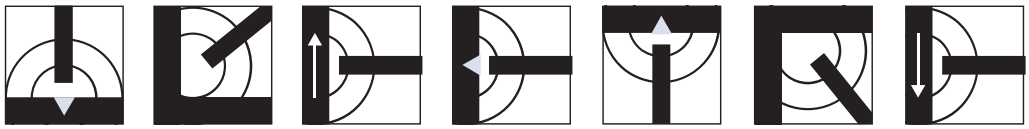
Typical Base Material Grades

- X6 CrNiNb 18 10, X6 CrNiTi 18 10, G-X5 CrNiNb 18 9, X-5 CrNi 18 10, G-X10 CrNi 18 8, X12 CrNiTi 18 9, X10 CrNiNb 1810
- AISI & ASTM: 304, 321, 347, A157Gr.C9, A296Gr.CF8C, A320Gr.B8C, A320Gr.B8D

Features and Applications

- Used for the welding of 13% Cr steels which are used in the textile, paper, paint and food industries
- Resistant to corrosion up to +400°C, suitable for TIG welding
- Argon is the shielding gas and it is also used for the welding of materials which have the similar chemical composition to welding wire

Welding Positions



Current Type

TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
6011100360	1.6 x 1000	1/16 x 39”	5	Plastic Box
6011100361	2.0 x 1000	5/64 x 39”	5	Plastic Box
6011100362	2.4 x 1000	3/32 x 39”	5	Plastic Box
6011100363	3.2 x 1000	1/8 x 39 “	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire

ELOX SG 347 Si

Standards

TS EN ISO 14343-A	: G 19 9 Nb Si
EN ISO 14343-A	: G 19 9 Nb Si
AWS A5.9	: ER 347 Si

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Nb
0.035	0.9	1.2	19.4	9.7	+

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($(L_o=5d_o)$ (%)
min. 400	570- 710	min. 63 J	min. 30

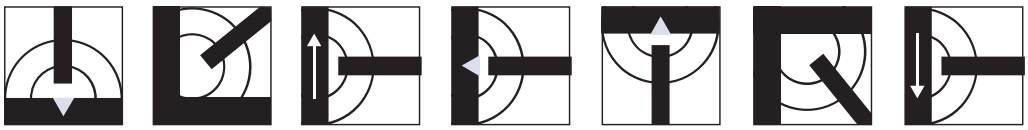
Typical Base Material Grades

- X6 CrNiNb 18 10, X6 CrNiTi 18 10, G-X5 CrNiNb 18 9, X5 CrNi 18 10, G-X 10 CrNi 18 8, X12 CrNiTi 18 9, X10 CrNiNb 18 10
- AISI & ASTM: 304, 321, 347, A157Gr.C9, A296Gr.CF8C, A320Gr.B8C, A320Gr.B8D

Features and Applications

- Used for the welding of 13% Cr steels which are used in the textile, paper, paint and food industries
- Resistant to corrosion up to +400°C, suitable for MIG welding
- Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gases are used for shielding, also used for the welding of materials which have the similar chemical composition to welding wire

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	Diamete (mm) / (inch)		Weight (Kg)	Package Type
6011100359	1.0	0.040”	15	BS 300
6011100231	1.2	0.047”	15	BS 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire

ELOX SG 409 CB

Standards

AWS A5.9	: ER 409 Nb

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo
0.07	1.0	0.8	12.0	0.6	0.5

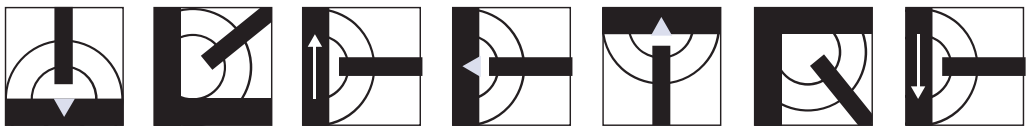
Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Elongation** (($L_o=5d_o$) (%)
min. 355	min. 450	min. 20

Features and Applications

- It used for the welding of ferritic stainless steel 409Gb and 409Ti which are commonly used for exhaust parts in automotive industry
- High resistant to thermal fatigue
- With help of Nb addition, Chromium carbide formation is prevented
- Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gases are used as shielding gas

Welding Positions



Current Type

MIG D.C.(+)

Operating Data

Product Code	**Diameter** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100364	1.20	0.047”	15	D 300

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 410

Standards

TS EN ISO 14343-A	: G/W 13
EN ISO 14343-A	: G/W 13
AWS A5.9	: ER 410

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr
0.10	0.35	0.50	13.0

Mechanical Properties (MIG)

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Elongation** ($(L_o=5d_o)$ (%))	**Heat Treatment**
min. 250	min. 520	min. 20	840 °C - 870 °C/2h

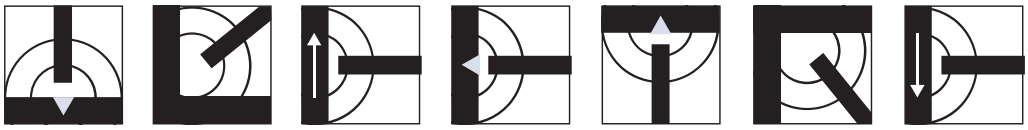
Typical Base Material Grades

- X 6 CrTi 17, X 20 CrNi 17 2, 431, 430 Ti
- AISI: 431, 430Ti

Features and Applications

- Preferred use in formation of surfaces resistant to corrosion, wear, and heat.
- Maintained hardness at temperatures of up to 500°C
- Resistance to formation of oxide layers at temperatures up to 900°C
- Reqiured use of Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mixed gas as shielding gas
- For TIG; Ar gas as shielding

Welding Positions



Current Type

MIG D.C. (+) / TIG D.C. (-)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100365	1.0	0.040”	15	BS 300
6011100375	1.2	0.047”	15	BS 300
6011100196	2.40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 430

Standards

TS EN ISO 14343-A	: G/W 17
EN ISO 14343-A	: G/W 17
AWS AS.9	: ER 430

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr
0.05	0.40	0.40	17.0

Mechanical Properties (MIG)

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Elongation** (($L_o=5d_o$) (%)	**Heat Treatment**
min. 300	min. 450	min. 20	760 - 790°C /2h

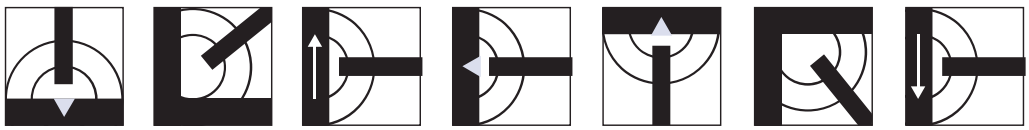
Typical Base Material Grades

- X 6 CrTi 17, X 20 CrNi 17 2
- AISI: 431, 430Ti

Features and Applications

- Applicability in surfacing to provide resistance to corrosion, wearing, and heat
- Requirement of use of for MIG: Ar+ %2.5 O_2 or Ar+ %2.5 CO_2 mix gas as shielding
- For TIG: Ar gas as shielding

Welding Positions



Current Type

MIG D.C.(+) / TIG D.C. (-)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100403	1.0	0.040”	15	BS 300
6011100366	1.2	0.047”	15	BS 300
6011100376	1.6	0.062”	15	BS 300
6011100367	2.40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO

Stainless Steel Gas Shielded Welding Wire & Rod

ELOX SG 2209

Standards

TS EN ISO 14343-A	: W 22 9 3 N L
EN ISO 14343-A	: W 22 9 3 N L
AWS A5.9	: ER 2209

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo	N
0.02	0.40	1.70	22.80	7.80	2.90	0.15

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Elongation** (($L_o=5d_o$) (%))	**Impact Strength** (ISO-V/-46°C)
550	700	28	100 J

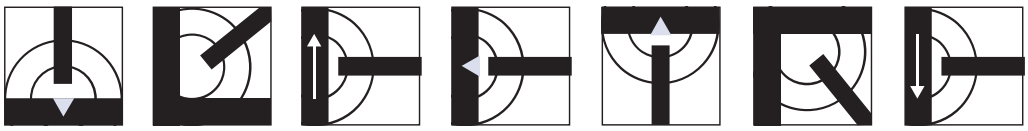
Typical Base Material Grades

- SAE 2209, SAE 2205, EN14462, X2CrNiMoN22-5-3, X2CrNiN23-4, X2CrNiMoN22-5-3 with X10CrNiMoNb18- 12 and X2CrNiMoN22-5-3 with P235GH/ P265GH, S255N, P295GH, S355N and 16Mo3 combinations, UNS S31803, S32205.

Features and Applications

- GeKa ELOX SG 2209 is duplex stainless steel TIG Welding rod contains low Carbon and approximate %22Cr, %9Ni and %3Mo
- Microstructure is Austenite + Ferritic
- The weld metal has an excellent resistance to stress corrosion, cracking and pitting
- The use of this welding rod, pipe and general manufacturing industries, offshore applications, oil, gas, chemical and petrochemical industry
- Shielding gas: TIG; pure Ar or Ar+%1-2N_2 mix gases can be used

Welding Positions



Current Type

MIG D.C. (+) / TIG D.C. (-)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100308	1,2	0.047”	15	BS 300
6011100309	2.00 x 1000	5/64 x 39”	5	Plastic Box
6011100310	2.40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO, NK, RINA

Stainless Steel Gas Shielded Welding Rod

ELOX SG 2594

Standards

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

Chemical Composition of Welding Wire % (Typical)

C	Si	Mn	Cr	Ni	Mo
0.02	0.35	0.70	25.0	9.00	3.80

Mechanical Properties

Yield Strength (N/mm^2)	**Tensile Strength** (N/mm^2)	**Elongation** (($L_o=5d_o$) (%)	**Impact Strength** (ISO-V/+20°C)
min. 550	min. 760	min. 18	min. 47 J

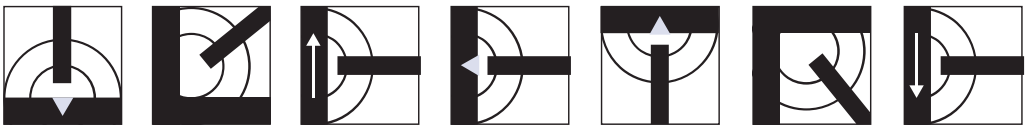
Typical Base Material Grades

- (1.4501)X2CrNiMoCuWN25-7-4, (1.4515)GX3CrNiMoCuN26-6-3, (1.4517)GX3CrNiMoCuN25-6-3-3, UNS S 32750, S 32760 ZERON 100, SAF 25/07, FALC100

Features and Applications

- GeKa ELOX SG 2594 is a super duplex welding wire.
- Used for the welding Austenitic-Ferritic stainless alloys of %25 Cr, %9 Ni, %3.5 Mo and low C types
- It has high resistance to intergranular corrosion and pitting
- GeKa ELOX SG 2594 is intended for welding super duplex alloys such as 2507, ASTM S32760, S32550 and A31260
- As the shielding gas, Argon (Ar) is used

Welding Positions



Current Type

TIG D.C. (-)

Operating Data

Product Code	**Diameter x Length** (mm) / (inch)		**Weight** (Kg)	**Package Type**
6011100225	1.60 x 1000	1/16 x 39”	5	Plastic Box
6011100226	2.00 x 1000	5/64 x 39”	5	Plastic Box
6011100227	2.40 x 1000	3/32 x 39”	5	Plastic Box

Approvals: CE, SEPRO

По вопросам продаж и поддержки обращайтесь:

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