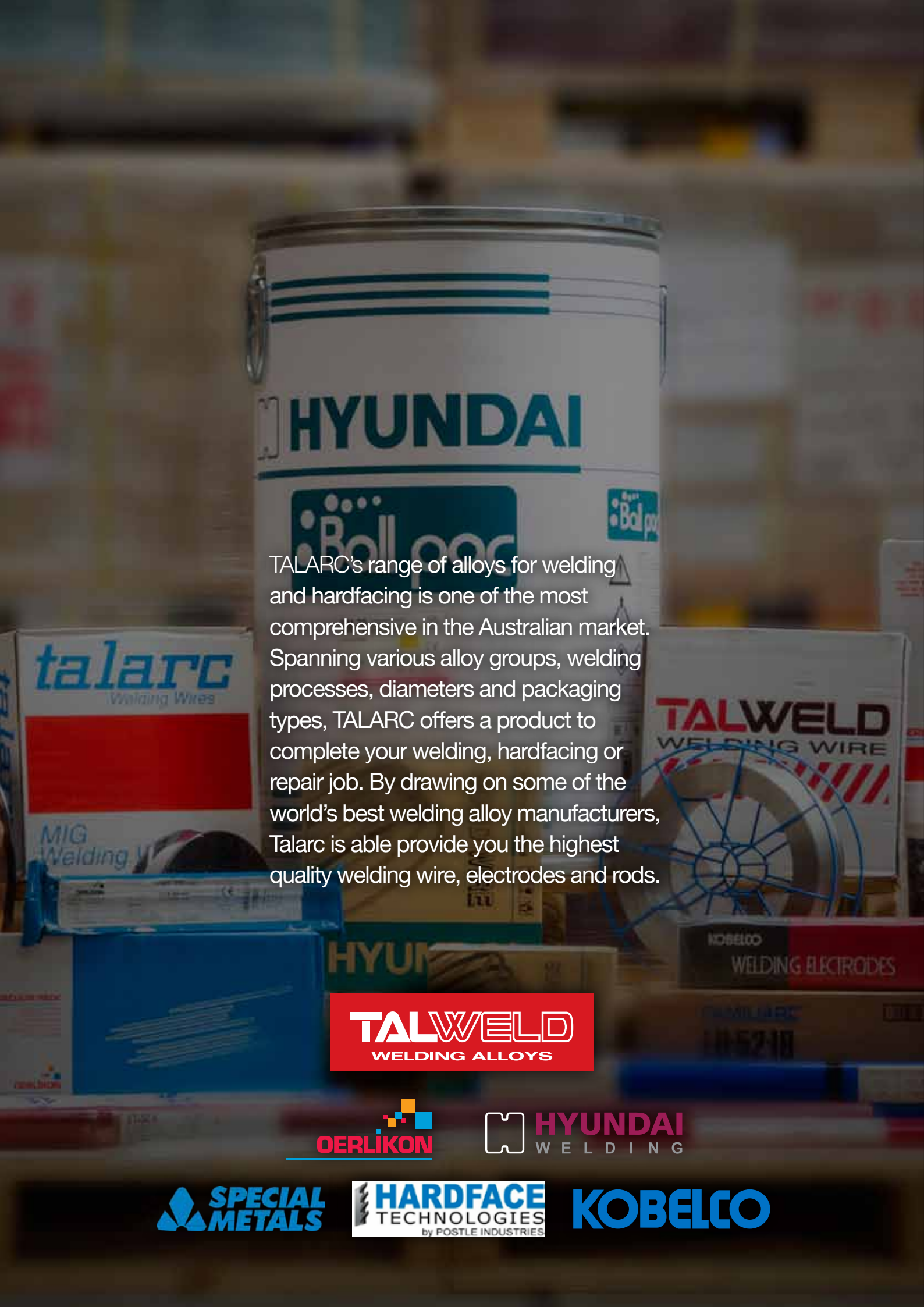




talarc

**Welding Filler Metals and
Hardfacing Alloys**



TALARC's range of alloys for welding and hardfacing is one of the most comprehensive in the Australian market. Spanning various alloy groups, welding processes, diameters and packaging types, TALARC offers a product to complete your welding, hardfacing or repair job. By drawing on some of the world's best welding alloy manufacturers, Talarc is able provide you the highest quality welding wire, electrodes and rods.

TALWELD
WELDING ALLOYS

OERLIKON

HYUNDAI
WELDING

SPECIAL METALS

HARDFACE
TECHNOLOGIES
by POSTLE INDUSTRIES

KOBELCO

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RB-26

Features:

- High rutile type covered electrode for mild steel
- Suitable for butt and fillet welding of thin plates
- Excellent usability in all positions including vertical down

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
450	510	25%

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.6	350	5kg/20kg	KOBE RB26-26
3.2	350	5kg/20kg	KOBE RB26-32
4.0	400	5kg/20kg	KOBE RB26-40

LB-52U

Features:

- Low hydrogen type covered electrode for mild steel 490MPa high tensile strength steel
- Suitable for one side welding of pipes
- Extremely good arc stability in one-sided welding with low current

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
480	560	25%	80J at -29°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.6	350	5kg/20kg	KOBE LB52-U-26
3.2	350	5kg/20kg	KOBE LB52-U-32
4.0	400	5kg/20kg	KOBE LB52-U-40

LB-52-18

Features:

- Iron powder low hydrogen type covered electrode for mild steel and 490MPa high tensile strength steel
- Suitable for butt and fillet welding of heavy structures
- Good performance using DC-EP current

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
500	560	31%	110J at -29°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.6	350	5kg/20kg	KOBE LB52-18-26
3.2	350	5kg/20kg	KOBE LB52-18-32
4.0	400	5kg/20kg	KOBE LB52-18-40

Classification:

ASME/AWS A 5.1 E6013
EN ISO 2560-A-E 35 0 R

Datasheet No.

ME08

Classification:

ASME/AWS A 5.1 E7016
EN ISO 2560-A-E 42 2 B

Datasheet No.

ME06

Classification:

ASME/AWS A 5.1 E7018
EN ISO 2560-A-E 42 3 B

Datasheet No.

ME07



OVERCORD-E

Features:

- Medium coated rutile type electrode for mild steel
- Suitable for butt and fillet welding of thin plates
- Excellent usability in all positions including vertical down

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
480	560	25%

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	4.5kg/13.5kg	OER OVERCORD25
3.2	350	4.5kg/13.5kg	OER OVERCORD32
4.0	450	4.5kg/13.5kg	PH48E40

SPEZIAL

Features:

- Low hydrogen double coated electrode for structural steelwork, workshop and maintenance welding
- Smooth clean welds that blend into the base metal without undercut
- The double coating of this electrode produces a stable and concentrated arc, thus being ideally suited for root pass and positional welding

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
480	560	25%	90J at -20°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	4.0kg/12.0kg	OER SPEZIAL25
3.2	350	3.9kg/11.7kg	OER SPEZIAL32
4.0	450	5.2kg/15.6kg	OER SPEZIAL40

TENAX 35S

Features:

- Low hydrogen electrode containing iron powder suitable for all position welding
- The excellent mechanical properties at low temperatures make this electrode suitable for critical welding
- Applications include off-shore work, nuclear industry and pressure vessels

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
480	565	28%	110J at -50°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	4.0kg/12.0kg	OER TENAX35S25
3.2	350	3.9kg/11.7kg	OER TENAX35S32
4.0	450	5.2kg/15.6kg	PH77VP40

Classification:

ASME/AWS A 5.1 E6013
ISO 2560 A E 38 0 R 12

Datasheet No.

ME01

Classification:

ASME/AWS A 5.1 E7016 H8
ISO 2560 A E 38 2 B 12 H10

Datasheet No.

ME02

Classification:

ASME/AWS A 5.1 E7018-1 H4
ISO 2560 A E 42 5 B 22 H5

Datasheet No.

ME03

TALARC 46 BLUE

Features:

- Rutile coated (blue colour) electrode for mild steel
- Easy arc starting, smooth arc and excellent bead appearance
- Excellent usability in all positions including vertical down

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
440	540	24%

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	5kg/15kg	INE4625
3.2	350	5kg/15kg	INE4632

TALARC 86TC

Features:

- Low hydrogen double coated electrode for structural steelwork, workshop and maintenance welding
- Designed for both A.C. and D.C. operation in all positions
- Excellent weld bead with very limited spattering and a rather brittle, easy to remove slag

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
470	540	28%	75J at -20°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	2kg VAC pack/12kg	INE8625
3.2	350	2kg VAC pack/12kg	INE8632
4.0	450	1.8kg VAC pack/10.8kg	INE8640

Classification:

ASME/AWS A 5.1 E6013
ISO 2560 A E 42 0 RC 11

Datasheet No.

ME04

Classification:

ASME/AWS A 5.1 E7016
ISO 2560 A E 42 2 B 32

Datasheet No.

ME05

SF71-LF

Features:

- Rutile type all positional flux cored wire for mild steel
- For use with CO₂ welding gas
- Low fume generation compared to other conventional flux cored wires

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
550	590	27%	90J at 0°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSF71LF12
1.6	15kg Spool	HKSF71LF16

SF70-MX

Features:

- High deposition rutile type flux cored wire
- For use in Downhand, H-V positions with CO₂ welding gas
- Designed for high speed welding of structural steels > 6mm thickness

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
560	590	28%	60J at 0°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSF70MX12
1.6	15kg Spool	HKSF70MX16

Supercored 71

Features:

- Rutile type all positional flux cored wire for mild steel
- For use with CO₂ welding gas
- Quiet, smooth arc with excellent slag detachability

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
545	572	26%	110J at 0°C 70J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSCORD7112
1.6	15kg Spool	HKSCORD7116

Classification:

ASME/AWS A 5.20 E71T-1C

Datasheet No.

MF01

Classification:

ASME/AWS A 5.20 E70T-1C
EN ISO 17632-A-T 42 0 R C 3

Datasheet No.

MF02

Classification:

ASME/AWS A 5.20 E71T-1C
EN ISO 17632-A-T 42 2 P C 1

Datasheet No.

MF04

SC-71LHM Cored

Features:

- Rutile type all positional flux cored wire for mild steel
- For use with mixed gas (Ar + 20-25% CO₂)
- Extra low hydrogen level (H5) wire with smooth arc and fast freezing slag

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
560	610	27%	80J at -30°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSC71LHM12
1.6	15kg Spool	HKSC71LHM16

SF71-MC

Features:

- Rutile type all positional flux cored wire for mild steel
- For use with 100% CO₂ or with mixed gas (Ar + 20-25% CO₂)
- Low spatter and easy slag removal shorten the clean-up time

Typical Mechanical Properties				
Shielding Gas	Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
CO ₂	510	550	28%	95J at -20°C
Ar+25%CO ₂	540	605	28%	110J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HK71MC12
1.6	15kg Spool	HK71MC16

Supercored 70NS

Features:

- High deposition metal-cored type flux cored wire
- Exceptionally smooth and stable arc with low spatter and minimal slag coverage
- Quiet, smooth arc with excellent slag detachability

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
480	550	27%	50J at -30°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HK70NS12
1.6	15kg Spool	HK70NS16

Classification:

ASME/AWS A5.20 E71T-1M/-9M
EN ISO 17632-A-T 46 3 P M 1 H5

Datasheet No.

MF05

Classification:

ASME/AWS A5.20 E71T-1C/-1M
ASME/AWS A5.20 -9C/-9M-12C/-12M
EN ISO 17632 A T 46 3 P M 1
EN ISO 17632 A T 46 2 P C 1

Datasheet No.

MF06

Classification:

ASME/AWS A 5.18 E70C-6M
EN ISO 17632 A T 42 3 M M 3 H5

Datasheet No.

MF03

DW-50

Features:

- Suitable for butt and fillet welding in all positions including vertical down
- Excellent usability with soft and stable arc, low fume and spatter levels, good bead appearance and easy slag removal
- For use with 100% CO₂ or with mixed gas (Ar + 20-25% CO₂)

Typical Mechanical Properties				
Shielding Gas	Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
CO ₂	510	580	31%	108 J at -18°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	KOBE DW5012
1.6	15kg Spool	KOBE DW5016

Mild Steel | Flux Cored Welding Wire – Seamless



FLUXOFIL 14HD

Features:

- Seamless copper coated rutile flux cored wire
- A high flux filling content results in a higher current carrying capacity and high deposition rate
- Usable in all positions and it is characterized by low spatter loss, good slag removal and finely rippled, pore-free welds without undercut
- For use with 100% CO₂ or with mixed gas (Ar + 20-25% CO₂)

Typical Mechanical Properties				
Shielding Gas	Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
Ar+25%CO ₂	510	590	30%	95J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	16kg Spool	OERFF14HD12

Classification:

ASME/AWS A5.20 E71T-1C/-1M
ASME/AWS A5.20 E71T-9C/-9M
EN 758 T 42 2 P C/M 1

Datasheet No.

MF07

Classification:

ASME/AWS A5.20 E71T-1 H4
ASME/AWS A5.20 E71T-1M H4
EN 758 T 46 2 P C/MH5

Datasheet No.

MF08

Supershield 71GS

- Features:**
- All position self-shielded flux cored wire for single-pass welding
 - For mild and medium tensile steels, with TS not exceeding 510MPa
 - Ideal for light structural work, short assembly welds, other general fabrication and galvanized steel fixtures, gates, etc

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
430	610	21%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	5kg Spool	HK71GS0905

Supershield 11

- Features:**
- For the self-shielded welding of mild, carbon and galvanized steels
 - All position wire designed for single and multi-pass welding applications
 - Ideal for the outdoor welding or repair of gates, steel frames and tanks

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
520	590	22%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HK1112
1.6	15kg Spool	HK1116

Mild Steel | Flux Cored Welding Wire – Gasless

TALARC GASLESS T11

- Features:**
- For the self-shielded welding of mild, carbon and galvanized steels
 - Can be used in limited multi pass welding applications
 - Ideal for the welding or repair of gates, fences, steel frames and galvanized steel tanks

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
415	610	22%

Dimensions and Packing Details			
Diameter, mm	0.9kg Spool	4.5kg Spool	11.34kg Spool
0.8	WC0809	WC0845	
0.9	WC0909	WC0945	WC091134
1.2		WC1245	WC121134

Classification:
ASME/AWS A5.20 E71T-GS

Datasheet No.
MG01

Classification:
ASME/AWS A5.20 E71T-11

Datasheet No.
MG02



Classification:
ASME/AWS A5.20 E71T-11

Datasheet No.
MG03

SM-70

- Features:**
- Premium S6 grade wire with superior bead appearance and low spatter
 - Electrolytically applied copper coating and precision layer winding ensure optimum feedability and current transfer at the contact tip
 - Available in a wide range of diameters and packaging types

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
460	560	29%	95J at -29°C

Dimensions and Packing Details			
Diameter, mm	5kg Spool	15kg Spool	Ball Pac Drum*
0.8	HCSM700805	HCSM700815	
0.9	HCSM700905	HCSM700915	HCSM7009250 250kg
1.0		HCSM701015	HCSM7010300 300kg
1.2		HCSM701215	HCSM7012300 300kg
1.6		HCSM701615	HCSM7016400 400kg

Classification:
ASME/AWS A5.18 ER70S-6
ISO 14341 A G 46 4 M 3Si1
ISO 14341 A G 42 2 C 3Si1

Datasheet No.
MM01

*See Datasheet **MM01A** for
Ball Pac Fittings – Drum Cap and
Wire Conduit Cable

Features:

- High quality precision layer wound S6 grade wire
- For use with 100% CO₂ or with mixed gas (Ar + 15-25% CO₂)
- Ideal for general fabrication and structural steel work

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
430	540	28%	70J at -29°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HCSM70-N0915
1.6	15kg Spool	HCSM70-N1215

Classification:
ASME/AWS A5.18 ER70S-6
ISO 14341 A G 42 3 M 3Si1
ISO 14341 A G 42 2 C 3Si1

Datasheet No.
MM02

Mild Steel | Solid GMA Welding Wire



TALWELD S6

- Features:**
- Premium S6 grade wire, available in small diameters and spool sizes
 - For use with 100% CO₂ or with mixed gas (Ar + 15-25% CO₂)
 - Ideal for thin gauge work, DIY projects, galvanised steel

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
415	610	22%

Dimensions and Packing Details			
Diameter, mm	0.9kg Spool	5kg Spool	15kg Spool
0.6	INMS60609	INMS60605	INMS60615
0.8	INMS60809		

Classification:
ASME/AWS A5.18 ER70S-6

Datasheet No.
MM03

S-777MX and H-14

Features:

- Single and multi-layer welding of thin to medium plate
- Insensitive to oil, rust, scale, dirt or primers on surface of plates
- Excellent slag detachability, even in narrow groove welds

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
560	620	27%	90J at 0°C

Dimensions and Packing Details		
Item	Pack	Part No.
777MX Flux	20kg Can	HKS-777
2.4mm H14	25kg Coil	HKH1424
3.2mm H14	25kg Coil	HKH1432

S-717 and M-12K

Features:

- For multi-layer welding of medium to thick plate
- Weldmetal has excellent impact values and high crack resistance
- Neutral type flux which is not affected by welding parameter

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
555	615	29%	60J at -50°C

Dimensions and Packing Details		
Item	Pack	Part No.
717 Flux	20kg Can	HKS-717
2.4mm M12K	25kg Coil	HKM12K24
3.2mm M12K	25kg Coil	HKM12K32

Classification:

ASME/AWS A5.17 F7AZ-EH14
ASME/AWS A5.17 F7PZ-EH14
EN ISO 14174 S A AR 1/S4

Datasheet No.

MS01

Classification:

ASME/AWS A5.17 F7A6-EM12K
ASME/AWS A5.17 F7P6-EM12K
EN ISO 14174 S A AB 1/S2Si

Datasheet No.

MS02

ST-50.6

Features:

- Premium S6 grade copper coated TIG Rod
- For butt and fillet welding of carbon steel pressure vessels, tubes, frames, etc
- Also suitable for oxy-fuel gas welding

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
450	520	28%	180J at -20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	HKST-50-16
2.4	5kg Tube	1000	HKST-50-24
3.2	5kg Tube	1000	HKST-50-32

ST-50.3

Features:

- Premium S3 grade copper coated TIG Rod
- For butt and fillet welding of carbon steel pressure vessels, tubes, frames, etc
- Also suitable for oxy-fuel gas welding

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
495	565	26%	170J at -20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	HKST-503-16
2.4	5kg Tube	1000	HKST-503-24

ST-72

Features:

- Premium S2 grade triple deoxidised copper coated TIG Rod
- For butt and fillet welding of carbon steel pressure vessels, tubes, frames, etc
- Also suitable for oxy-fuel gas welding

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
500	580	29%	180J at -30°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	HKST-72-16
2.4	5kg Tube	1000	HKST-72-24

Classification:

ASME/AWS A5.18 ER70S-6

Datasheet No.

MT01

Classification:

ASME/AWS A5.18 ER70S-3

Datasheet No.

MT02

Classification:

ASME/AWS A5.18 ER70S-2

Datasheet No.

MT03

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TUNGSTEN INERT GAS (TIG) ROD

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TALARC B3 TIG	LT06	23
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TALARC B9 TIG	LT08	SEE WEBSITE



TALARC Cr-Mo B2

- Features:**
- 1.25Cr-0.5Mo type used for welding creep resistant steel
 - Low alloy basic-coated electrode for use in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 550°C

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
520	630	24%	75J at -20°C

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	2kg VAC pack/12kg	INEB225
3.2	350	2kg VAC pack/12kg	INEB232
4.0	350	2kg VAC pack/12kg	INEB240

TALARC Cr-Mo B3

- Features:**
- 2.25Cr-1Mo type used for welding creep resistant steel
 - Low alloy basic-coated electrode for use in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 600°C

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
580	660	22%

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
2.5	350	2kg VAC pack/12kg	INEB325
3.2	350	2kg VAC pack/12kg	INEB332
4.0	350	2kg VAC pack/12kg	INEB340



TENAX 118M

- Features:**
- All-position low-hydrogen electrode for welding high strength steel
 - For 760-870MPa steels such as HY80, Bisalloy 80 or Weldox 700
 - Applications include mining/earthmoving equipment and components

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
450	520	25%

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
3.2	350	1.9kg/11.4kg	OER TENAX118M32

Classification:
ASME/AWS A 5.5 E8018-B2
ISO 3580-A: E CrMo1 B 4 2 H5

Datasheet No.
LE01

Classification:
ASME/AWS A 5.5 E8018-B3
ISO 3580-A: E CrMo2 B 4 2 H5

Datasheet No.
LE02

Classification:
ASME/AWS A 5.1 E11018-M H4
EN 757: E 69 5 ZB 32

Datasheet No.
LE06



Supercored 81MAG

- Features:**
- High toughness rutile type all positional flux cored wire
 - For use with mixed gas (Ar + 20-25% CO₂)
 - Applications include mining/earthmoving equipment, oil and gas construction, pipes and offshore structures

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
550	590	26%	60J at -60°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.6	15kg Spool	HKSCORD8116



FLUXOFIL 20HD

- Features:**
- Seamless copper coated rutile flux cored wire
 - Ensures optimum feedability and current transfer at the contact tip with very low hydrogen levels
 - For use with mixed gas (Ar + 20-25% CO₂)
 - Applications include mining/earthmoving equipment, oil and gas construction, pipes and offshore structures

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
540	620	30%	80J at -40°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	16kg Spool	OERFF20HD12
1.6	16kg Spool	OERFF20HD16

FLUXOFIL M42

- Features:**
- Seamless copper coated metal cored flux cored wire
 - Ensures optimum feedability and current transfer at the contact tip and very low hydrogen levels
 - High strength wire for use on Q&T plate such as Bisalloy 80 and Weldox 700.
 - For use with mixed gas (Ar + 20-25% CO₂)

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
720	810	18%	75J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	16kg Spool	OERFFM4212

Classification:
ASME/AWS A5.29 E81T1-Ni1M H4
EN ISO 17632-A-T 46 6 1 Ni P M 2 H5

Datasheet No.
LF01

Classification:
ASME/AWS A5.29 E81T1-Ni1M J H4
EN 758 T 46 4 1Ni P M 1 H5

Datasheet No.
LF02

Classification:
ASME/AWS A5.28 E110C-G H4
EN 12535 T 69 4 Mn2NiCrMo M M 1H5

Datasheet No.
LF03

TALARC 110

Features:

- Low-alloy copper-coated solid steel wire with Ni-Cr-Mo additions
- Applications include the mixed gas welding of HSLA (high-strength low-alloy) steels, for industrial machinery construction, mining equipment, cranes and other highly stressed structural components

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
805	880	18%	85J at -40°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	INM11009
1.2	15kg Spool	INM11012

TALARC D2

Features:

- Low-alloy copper-coated solid steel wire with 0.5%Mo addition
- Designed for welding low-alloy steels with high tensile strength and creep-resistant steels
- For use with mixed gas (Ar + CO₂)

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
560	650	22%	90J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	INMD209
1.2	15kg Spool	INMD212

TALARC B2

Features:

- Low-alloy copper-coated solid steel wire with 1.25%Cr, 0.5%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 550°C
- For use with mixed gas (Ar + O₂)

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
490	590	23%	150J at 20°C

Dimensions and Packing Details		
Diameter, mm	5kg Spool	15kg Spool
0.9	INMB20905	INMB20915
1.2		INMB21215

Classification:

ASME/AWS A5.28 ER110S-1
ISO 16834-A: G Mn3Ni2, 5CrMo

Datasheet No.

LM02

Classification:

ASME/AWS A5.28 ER80S-D2
ISO 14341-A: G 5005 M G4Mo

Datasheet No.

LM03

Classification:

ASME/AWS A5.28 ER80S-B2
ISO 21952- B: G 1CM

Datasheet No.

LM04

TALARC B3

Features:

- Low-alloy copper-coated solid steel wire with 2.25%Cr, 1%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 600°C
- For use with mixed gas (Ar + O₂)

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
570	670	20%	170J at 20°C

Dimensions and Packing Details		
Diameter, mm	5kg Spool	15kg Spool
0.9	INMB30905	INMB30915
1.2		INMB31215
1.6		INMB31615

TALARC B6

Features:

- Low-alloy copper-coated solid steel wire with 5%Cr, 0.5%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 550°C
- For use with mixed gas (Ar + O₂)

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
500	620	25%	70J at 20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	INMB61215
1.6	15kg Spool	INMB61615

TALARC Cu

Features:

- Low-alloy copper-coated solid steel wire with Ni-Cu-Cr additions
- Designed for welding weather-resistant steels such as Corten A or B, ASTM A242 or A588
- For use with mixed gas (Ar + CO₂)

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
560	650	22%	90J at -20°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	INMCU09
1.2	15kg Spool	INMCU12

Classification:

ASME/AWS A5.28 ER90S-B3
ISO 21952- B: G 2CM

Datasheet No.

LM05

Classification:

ASME/AWS A5.28 ER80S-B6
ISO 21952- A: W CrMo5Si

Datasheet No.

LM06

Classification:

ASME/AWS A5.28 ER80S-G
ISO 16834-A: G Mn3Ni1Cu

Datasheet No.

LM07

TALARC 80Ni-1 TIG

Features:

- Low-alloy copper-coated steel TIG rod with 1%Ni content
- Suitable for low temperature applications including the welding of offshore platforms, pressure vessels and pipelines

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
530	600	26%	80J at -40°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
2.4	5kg Tube	1000	INTNi-1 24

TALARC D2 TIG

Features:

- Low-alloy copper-coated steel TIG rod with 0.5%Mo addition
- Designed for welding low-alloy steels with high tensile strength and creep-resistant steels
- Also used for welding low-alloy steels with high tensile strength

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
570	660	22%	200J at 20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	INTD216
2.4	5kg Tube	1000	INTD224

TALARC 110 TIG

Features:

- Low-alloy copper-coated steel TIG rod with Ni-Cr-Mo additions
- Applications include the welding of HSLA (high-strength low alloy) steels, for industrial machinery, mining equipment, cranes and other highly stressed structural components

Typical Mechanical Properties			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
740	805	16%	120J at -40°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	INT11016
2.4	5kg Tube	1000	INT11024

Classification:

ASME/AWS A5.28 ER80S-Ni1
EN ISO 636-A: W3Ni1

Datasheet No.

LT01

Classification:

ASME/AWS A5.28 ER80S-D2
EN ISO 636-B: W4M31

Datasheet No.

LT03

Classification:

ASME/AWS A5.28 ER110S-1
EN ISO 16834-A W Mn4Ni2Mo

Datasheet No.

LT04

TALARC B2 TIG

Features:

- Low-alloy copper-coated steel TIG rod with 1.25%Cr, 0.5%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 550°C

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
490	590	23%	150J at 20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	INTB216
2.4	5kg Tube	1000	INTB224

TALARC B3 TIG

Features:

- Low-alloy copper-coated steel TIG rod with 2.25%Cr, 1%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 600°C

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
570	650	22%	230J at 20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	INTB316
2.4	5kg Tube	1000	INTB324

TALARC B6 TIG

Features:

- Low-alloy copper-coated steel TIG rod with 5%Cr, 0.5%Mo
- Designed for welding creep resistant steels in chemical and petro-chemical industries, for heat exchangers, boilers, piping and pressure vessels with service temperature up to about 550°C

Typical Mechanical Properties (after PWHT)			
Yield Strength, MPa	Tensile Strength, MPa	Elongation	CVN Impact
500	620	25%	200J at 20°C

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	INTB616
2.4	5kg Tube	1000	INTB624

Classification:

ASME/AWS A5.28 ER80S-B2
ISO 21952- B: W 1CM

Datasheet No.

LT05

Classification:

ASME/AWS A5.28 ER90S-B3
ISO 21952- B: W 2CM

Datasheet No.

LT06

Classification:

ASME/AWS A5.28 ER80S-B6
ISO 21952- W: CrMo5Si

Datasheet No.

LT07

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KS-308L

Features:

- Weld metal is austenite structure with 20%Cr-9%Ni
- Excellent weldability, easy slag removal and smooth beads
- Suitable for welding 18%Cr-8%Ni stainless steels (AISI 301, 302, 304, 304L and 308), and 19.5%Cr-10%Ni steel (AISI 347)

Classification:

AWS A5.4/A5.4ME308L-16
AS/NZS 4854 B ES308L-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.5	2.5kg Tube/30kg	KS30825
3.2	2.5kg Tube/30kg	KS30832

Datasheet No.

SE01

KS-308H

Features:

- Weld metal is austenite structure with 20%Cr-9%Ni and has higher carbon to improve tensile strength at high temperature
- Excellent weldability, easy slag removal and smooth beads
- Suitable for welding high carbon 18%Cr-8%Ni steel such as AISI 304H

Classification:

AWS A5.4/A5.4M E308H-16
AS/NZS 4854 B ES308H-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.5	2.5kg Tube/30kg	KS308H25
3.2	2.5kg Tube/30kg	KS308H32

Datasheet No.

SE02

KS-309L

Features:

- Weld metal is austenite structure with low carbon 24%Cr-13%Ni
- Superior crack and corrosion resistance due to moderate ferrite content
- Ideal for welding 309/309L stainless, heat resistant steel (13Cr, 18Cr) and dissimilar metals (carbon steel to stainless steel)

Classification:

AWS A5.4/A5.4M E309L-16
AS/NZS 4854 B ES309L-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.5	2.5kg Tube/30kg	KS30925
3.2	2.5kg Tube/30kg	KS30932
4.0	2.5kg Tube/30kg	KS30940

Datasheet No.

SE03

KS-310

Features:

- Weld metal is austenite structure with 25%Cr-20%Ni
- Recommended for high temperature applications, upto 1000°C
- Ideal for welding AISI 310 and 310S stainless steels

Classification:

AWS A5.94A5.4M E310-16
AS/NZS 4854 B ES310-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
3.2	2.5kg Tube/30kg	KS31032

Datasheet No.

SE04

KS-312

Features:

- Weld metal is austenite structure with 20%Cr-9%Ni
- Excellent weldability, easy slag removal and smooth beads
- Suitable for welding stainless steel sheet linings, dissimilar metals, alloy steels with high hardenability, and hard-to-weld steel

Classification:

AWS A5.4/A5.4M E312-16
AS/NZS 4854 B ES312-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.5	2.5kg Tube/30kg	KS31225
3.2	2.5kg Tube/30kg	KS31232

Datasheet No.

SE05

KS-316L

Features:

- Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo
- Extra low carbon and Mo content help prevent intergranular corrosion
- Excellent weldability, easy slag removal and smooth beads
- Suitable for welding plate and pipe for chemical vessels, such as AISI 316, 316L steel

Classification:

AWS A5.4/A5.4M E316L-16
AS/NZS 4854 B ES316L-16

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.5	2.5kg Tube/30kg	KS31625
3.2	2.5kg Tube/30kg	KS31632
4.0	2.5kg Tube/30kg	KS31640

Datasheet No.

SE06

SUPRANOX 316L

Features:

- Rutile coated MMA electrode having an extra low carbon for welding austenitic stainless steels
- Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking
- For operating temperatures of up to 400°C
- Suitable for welding plate and pipe for chemical vessels, such as AISI 316, 316L steel

Classification:

AWS A5.4/A5.4M E316L16
EN 1600: E 19 12 3 L R 12

Dimensions and Packing Details		
Diameter, mm	Pack/Carton	Part No.
2.0	3.6kg/10.8kg	PHRS31620
2.5	3.6kg/10.8kg	OER RS316L25
3.2	4.3kg/12.9kg	PHRS31632
4.0	2.1kg/12.6kg	PHRS31640

Datasheet No.

SE08

FLUXINOX 308L-PF

- Features:**
- Designed for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag removal
 - Suitable for welding 18%Cr-8%Ni stainless steels, such as AISI 301, 302, 304, 304L and 308 steel
 - It is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	OERFI308L-PF12

Classification:
AWS A5.22: E308LT1-4/E308LT1-1
EN 12073: T 19 9 L P M/C 1

Datasheet No.
SF01

FLUXINOX 309L-PF

- Features:**
- Designed for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag remova
 - Suitable for welding 309/309L stainless, heat resistant steels (13Cr, 18Cr), dissimilar metals (carbon steel to stainless steel) or for depositing austenitic cladding
 - It is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	OERFI309L-PF12

Classification:
AWS A5.22: E309LT1-4/E309LT1-1
EN12073:T2312LPM/C1

Datasheet No.
SF02

FLUXINOX 316L-PF

- Features:**
- Designed for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag removal
 - Suitable for welding plate and pipe for chemical vessels, such as AISI 316, 316L steel
 - It is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	OERFI316L-PF12

Classification:
AWS A5.22: E316LT1-4/E316LT1-1
EN 12073: T 19 12 3 L P M/C 1

Datasheet No.
SF03

SW-309L Cored

- Features:**
- All position wire for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag removal
 - Suitable for welding 309/309L stainless, heat resistant steels (13Cr, 18Cr), dissimilar metals (carbon steel to stainless steel) or for depositing austenitic cladding

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSW30912

Classification:
AWS A5.22: E309LT1-4/E309LT1-1
EN 12073: T 23 12 L P M/C 2

Datasheet No.
SF05

SW-316L Cored

- Features:**
- All position wire for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag removal
 - Suitable for welding plate and pipe for chemical vessels, such as AISI 316, 316L steel
 - Due to the ferrite content in the weld metal's austenitic structure, it has excellent crack resistance

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	HKSW31612

Classification:
AWS A5.22: E316LT1-4/E316LT1-1
EN 12073: T 19 12 3 L P M/C 2

Datasheet No.
SF06

Stainless Steel – Duplex | Flux Cored Welding Wire

FLUXINOX 22.9.3L-PF

- Features:**
- Designed for use with 100% CO₂ or mixed gas
 - Outstanding, almost spatter-free, welds with very easy slag removal
 - High strength welds and excellent resistance to pitting and stress corrosion cracking
 - It is suitable for welding duplex stainless steel with 22% Cr, such as UNS S31803 (Alloy 2205)
 - It is well-suited for welding in the horizontal (PD), overhead (PE) and vertical-up (PF) positions

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	OERF2293L-PF12

Classification:
AWS A5.22: E2209T1-4/E2209T1-1
EN 12073: T 22 9 3 N L P M/C 1

Datasheet No.
SF04

KM-308LSi

Features:

- Weld metal is austenite structure with 20%Cr-9%Ni
- Good crack and corrosion resistance due to moderate ferrite content
- Suitable for welding 18%Cr-8%Ni stainless steel with high travel speed, such as AISI 301, 302, 304, 304L and 308 steel

Classification:

AWS A5.9/A5.9M ER308LSi

AS/NZS ISO 14343 B SS308LSi

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.8	15kg Spool	KM3080815
0.9	15kg Spool	KM3080915
1.2	15kg Spool	KM3081215
1.6	15kg Spool	KM3081615

KM-309LSi

Features:

- Weld metal is austenite structure with low carbon 24% Cr-13%Ni
- Superior crack and corrosion resistance due to moderate ferrite content
- Ideal for welding dissimilar metals (carbon steel to stainless steel)

Classification:

AWS A5.9/A5.9M ER309LSi

AS/NZS ISO 14343 B SS309LSi

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	5kg Spool	KM3090905
0.9	15kg Spool	KM3090915
1.2	5kg Spool	KM3091205
1.2	15kg Spool	KM3091215
1.6	15kg Spool	KM3091615

KM-316LSi

Features:

- Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo-Si
- Superior corrosion resistance to acetic acid, phosphoric acid, acetate and phosphate due to additional Mo content
- Ideal for welding sheets and pipes of chemical vessels, such as AISI 316, 316L steel

Classification:

AWS A5.9/A5.9M ER316LSi

AS/NZS ISO 14343 B SS316LSi

Dimensions and Packing Details			
Diameter, mm	1kg Spool	5kg Spool	15kg Spool
0.6		KM3160605	
0.8	KM3160801	KM3160805	KM3160815
0.9		KM3160905	KM3160915
1.0		KM3161005	KM3161015
1.2		KM3161205	KM3161215
1.6			KM3161615

Datasheet No.

SM02

Datasheet No.

SM03

Datasheet No.

SM07

KM-307Si

Features:

- Weld metal is austenite structure with 20%Cr-9%Ni-6%Mn
- Good cracking resistance
- Ideal for welding heat resistant steels (13Cr, 18Cr), dissimilar metals (carbon steel to stainless steel), high manganese steel and armour steel

Classification:

AWS A5.9/A5.9M ER307 (near eq.)

AS/NZS ISO 14343 A G 18 8 Mn

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	KM3071215
1.6	15kg Spool	KM3071615

KM-310

Features:

- Weld metal is austenite structure with 25%Cr-20%Ni
- Recommended for high temperature applications, upto 1000°C
- Ideal for welding AISI 310 and 310S stainless steels

Classification:

AWS A5.9/A5.9M ER310

AS/NZS ISO 14343 B SS310

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	KM3100915
1.2	15kg Spool	KM3101215

KM-312

Features:

- Weld metal is austenite structure with 30%Cr-9%Ni
- Superior crack resistance and high strength due to high ferrite content
- Ideal for welding dissimilar metals, clad steel, alloy steel with high hardenability and may be used as buffer layer before hardfacing

Classification:

AWS A5.9/A5.9M ER312

AS/NZS ISO 14343 B SS312

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	KM3120915
1.2	15kg Spool	KM3121215

KM-347

Features:

- Weld metal is austenite structure with 20%Cr-10%Ni and Nb
- Superior intergranular corrosion resistance and strength at high temperature than 308LSi due to KM347's Nb content
- Ideal for welding AISI 308L, 321 and 347 stainless steel

Classification:

AWSA5.9/A5.9M ER347

AS/NZS ISO 14343 B SS347

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	KM3470915
1.2	15kg Spool	KM3471215

Datasheet No.

SM01

Datasheet No.

SM05

Datasheet No.

SM06

Datasheet No.

SM08

KM-253MA

- Features:
- Weld metal is austenitic with 0.2% nitrogen and 0.05% rare earth (Ce)
 - For welding matching composition high temperature plate, pipe and fittings
 - It has very good strength and oxidation resistance at high temperatures, upto 1100°C

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	5kg Spool	KM253MA0905
0.9	15kg Spool	KM253MA0915
1.2	15kg Spool	KM253MA1215

Classification:

UNS S30815
EN 1.4835

Datasheet No.

SM10

KM-2209

- Features:
- Weld metal is duplex stainless steel with 22.5%Cr-8.5%Ni-3%Mo-0.15%N
 - High strength welds and excellent resistance to pitting and stress corrosion cracking
 - It is suitable for welding duplex stainless steel with 22% Cr, such as UNS S31803 (Alloy 2205)

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	KM22090915
1.0	15kg Spool	KM22091015
1.2	15kg Spool	KM22091215

Classification:

AWS A5.9/A5.9M ER2209
AS/NZS ISO14343 BSS2209

Datasheet No.

SM15

KM-2594

- Features:
- Weld metal is super duplex stainless with 25%Cr-9%Ni-4%Mo-0.25%N
 - High strength welds and excellent resistance to pitting and stress corrosion cracking
 - It is suitable for welding super duplex stainless steel with such as Zeron 100 and 2507

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	15kg Spool	KM25940915
1.2	15kg Spool	KM25941215

Classification:

AWS A5.9/A5.9M ER2594
AS/NZS ISO 14343 B SS2594

Datasheet No.

SM16

KM-409Nb

- Features:
- Weld metal is ferrite structure with 12%Cr and Nb
 - Additional Nb content in weld metal promotes the formation of ferriteand improves the corrosion resistance and strength at high temperature
 - It is suitable for welding car exhaust and muffler systems, such as AISI 409 stainless steel

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	KM4090915

Classification:

AWS A5.9/A5.9M ER409Nb

Datasheet No.

SM11

KM-430

- Features:
- Weld metal is ferrite structure with 16%
 - Weld deposit has good heat and corrosion resistance
 - It is suitable for welding exhaust and muffler systems, such as AISI 409 and 430 steel

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	KM4301215
1.6	15kg Spool	KM4301615

Classification:

AWS A5.9/A5.9M ER430
AS/NZS ISO 14343 B SS430

Datasheet No.

SM14

KM-410NiMo

- Features:
- Weld metal is martensite structure with 12%Cr-4.5%Ni-0.5%Mo
 - It is suitable for welding turbines, valve bodies and high pressure piping in offshore and power generation industries

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	KM410NiM12

Classification:

AWS A5.9/A5.9M ER410NiMo

Datasheet No.

SM12

KM-420

- Features:
- Weld metal is martensite structure with 13%Cr
 - Weld deposit has higher hardness vs 410 grade due to KM420's higher carbon content
 - It is suitable for build-up of corrosion or temperature resistant components

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.6	15kg Spool	KM4201615

Classification:

AWS A5.9/A5.9M ER420

Datasheet No.

SM13

STAINLESS STEEL

KT-308L

- Features:
- Weld metal is austenite structure with 20%Cr-9%Ni
 - Good crack and corrosion resistance due to moderate ferrite content
 - Suitable for welding 18%Cr-8%Ni stainless steel with high travel speed, such as AISI 301, 302, 304, 304L and 308 steel
- Classification:
- AWS A5.9/A5.9M ER308L
AS/NZS ISO 14343 B SS308L

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT30816
2.4	5kg Tube	1000	KT30824

Datasheet No.
ST01

KT-309L

- Features:
- Weld metal is austenite structure with low carbon 24%Cr-13%Ni
 - Superior crack and corrosion resistance due to moderate ferrite content
 - Ideal for welding dissimilar metals (carbon steel to stainless steel)
- Classification:
- AWS A5.9/A5.9M ER309L
AS/NZS ISO 14343 B SS309L

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT30916
2.4	5kg Tube	1000	KT30924

Datasheet No.
ST03

KT-316L

- Features:
- Weld metal is austenite structure with 18%Cr-12%Ni-2%Mo-Si
 - Superior corrosion resistance to acetic acid, phosphoric acid, acetate and phosphate due to additional Mo content
 - Ideal for welding sheets and pipes of chemical vessels, such as AISI 316, 316L steel
- Classification:
- AWS A5.9/A5.9M ER316L
AS/NZS ISO 14343 B SS316L

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.0	5kg Tube	1000	KT31610
1.2	5kg Tube	1000	KT31612
1.6	5kg Tube	1000	KT31616
2.4	5kg Tube	1000	KT31624
3.2	5kg Tube	1000	KT31632

Datasheet No.
ST05

KT-310

- Features:
- Weld metal is austenite structure with 25%Cr-20%Ni
 - Recommended for high temperature applications, upto 1000°C
 - Ideal for welding AISI 310 and 310S stainless steels
- Classification:
- AWS A5.9/A5.9M ER310
AS/NZS ISO 14343 B SS310

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT31016
2.4	5kg Tube	1000	KT31024

Datasheet No.
ST06

KT-312

- Features:
- Weld metal is austenite structure with 30%Cr-9%Ni
 - Superior crack resistance and high strength due to high ferrite content
 - Ideal for welding dissimilar metals, clad steel, alloy steel with high hardenability and may be used as buffer layer before hardfacing
- Classification:
- AWS A5.9/A5.9M ER312
AS/NZS ISO 14343 B SS312

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT31216
2.4	5kg Tube	1000	KT31224

Datasheet No.
ST07

KT-347

- Features:
- Weld metal is austenite structure with 20%Cr-10%Ni and Nb
 - Superior intergranular corrosion resistance and strength at high temperature than 308LSi due to KM347's Nb content
 - Ideal for welding AISI 308L, 321 and 347 stainless steel
- Classification:
- AWS A5.9/A5.9M ER347
AS/NZS ISO 14343 B SS347

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT34716
2.4	5kg Tube	1000	KT34724

Datasheet No.
ST08

KT-253MA

- Features:
- Weld metal is austenitic with 0.2% nitrogen and 0.05% rare earth (Ce)
 - For welding matching composition high temperature plate, pipe and fittings
 - It has very good strength and oxidation resistance at high temperatures, upto 1100°C
- Classification:
- UNS S30815
EN 1.4835

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT253MA16
2.4	5kg Tube	1000	KT253MA24

Datasheet No.
ST09

Stainless Steel – Martensitic | Tungsten Inert Gas (TIG) Rod

TALWELD
WELDING ALLOYS

KT-410

- Features:
- Weld metal is martensite structure with 13%Cr
 - High oxidation and corrosion resistance upto 650°C
 - It is suitable for welding 410 or 420 type stainless, steels in chemical and petro-chemical industries
- Classification:
- AWS A5.9/A5.9M ER410

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT41016

Datasheet No.

ST11

Stainless Steel – Duplex/Super Duplex | Tungsten Inert Gas (TIG) Rod

TALWELD
WELDING ALLOYS

KT-2209

- Features:
- Weld metal is duplex stainless steel with 22.5%Cr-8.5%Ni-3%Mo-0.15%N
 - High strength welds and excellent resistance to pitting and stress corrosion cracking
 - It is suitable for welding duplex stainless steel with 22% Cr, such as UNS S31803 (Alloy 2205)
- Classification:
- AWS A5.9/A5.9M ER2209
AS/NZS ISO 14343 B SS2209

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT220916
2.4	5kg Tube	1000	KT220924

Datasheet No.

ST12

KT-2594

- Features:
- Weld metal is super duplex stainless with 25%Cr-9%Ni-4%Mo-0.25%N
 - High strength welds and excellent resistance to pitting and stress corrosion cracking
 - It is suitable for welding super duplex stainless steel with such as Zeron 100 and 2507
- Classification:
- AWS A5.9/A5.9M ER2594
AS/NZS ISO 14343 B SS2594

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	KT259416
2.4	5kg Tube	1000	KT259424

Datasheet No.

ST13

Nickel Based Alloys Index Page

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INCONEL® 112

Features:

INCONEL 112 electrodes are used for shielded-metal-arc welding of INCONEL alloy 625, INCOLOY alloy 825, INCOLOY alloy 25-6MO, and other molybdenum-containing stainless steels. Other uses include surfacing of steel and for welding 9% Ni steels.

Classification:

ASME/AWS A5.14 ENiCrMo-3

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
760	30%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SME11224
3.2	4.54kg Tube	SME11232
4.0	4.54kg Tube	SME11240

INCONEL® 117

Features:

INCONEL 117 electrodes are used for shielded-metal-arc welding of INCONEL alloy 617. The weld metal has high strength, good metallurgical stability and excellent resistance to corrosion and high temperature oxidation. INCONEL 117 also gives good results when welding many dissimilar materials, especially for high-temperature applications such as INCONEL alloys 600/601 and alloys 800HT/803.

Classification:

ASME/AWS A5.14 ENiCrCoMo-1

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
620	25%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
3.2	4.54kg Tube	SME11732

INCONEL® 182

Features:

INCONEL 182 electrodes are used for shielded-metal-arc welding INCONEL alloys 600 and 601. The weld metal has excellent high-temperature strength and oxidation resistance and can meet stringent radiographic requirements.

Classification:

ASME/AWS A5.14 ENiCrFe-3

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
760	30%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SME18224
3.2	4.54kg Tube	SME18232
4.0	4.54kg Tube	SME18240

Datasheet No.

NE02

Datasheet No.

NE03

Datasheet No.

NE04

INCONEL® Filler Metal 625

Features:

INCONEL Filler Metal 625 is used for gas-metal-arc and gas-tungsten-arc welding of INCONEL alloy 625, INCOLOY alloy 825, INCOLOY alloy 25-6MO, and a range of high alloy austenitic and super-austenitic stainless steels. It is also used for surfacing of steel and for welding 9% Ni steels.

Classification:

ASME/AWS A5.14 ERNiCrMo-3

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
760	30%

Dimensions and Packing Details – GMAW Wire		
Diameter, mm	Pack	Part No.
0.9	13.62kg Spool	SMM62509
1.2	13.62kg Spool	SMM62512
1.6	13.62kg Spool	SMM62516

Datasheet No.

NM01

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	4.54kg Tube	SMT62516
2.4	4.54kg Tube	SMT62524
3.2	4.54kg Tube	SMT62532

INCONEL® Filler Metal 82

Features:

INCONEL Filler Metal 82 is used for the gas-tungsten-arc and gas-metal-arc welding of INCONEL alloys 600, 601 and 690, INCOLOY alloys 800 and 800HT, and INCOLOY alloy 330. It is also used for surfacing of steel.

Classification:

ASME/AWS A5.14 ERNiCr-3

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
550	30%

Dimensions and Packing Details – GMAW Wire		
Diameter, mm	Pack	Part No.
0.9	13.62 kg Spool	SMM8209
1.2	13.62 kg Spool	SMM8212

Datasheet No.

NM02

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	4.54kg Tube	SMT8216
2.4	4.54kg Tube	SMT8224

MONEL® Filler Metal 67

Features:

MONEL Filler Metal 67 is used for oxyacetylene, gas-tungsten-arc and gas-metal-arc, and submerged-arc welding of MONEL alloy 450 (70/30 Copper-Nickel) and other copper nickel alloys. It is used for surfacing of steel if a barrier layer of Nickel Filler Metal 61 is first applied.

Classification:

ASME/AWS A 5.7 ERCuNi

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
345	30%

Dimensions and Packing Details – GMAW Wire		
Diameter, mm	Pack	Part No.
0.9	13.62kg Spool	SMM62509
1.2	13.62kg Spool	SMM62512

Datasheet No.

NM03

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	4.54kg Tube	SMT62516
2.4	4.54kg Tube	SMT62524

INCONEL® Filler Metal 617

Features:

INCONEL Filler Metal 617 is used for gas-tungsten-arc welding of INCONEL alloy 617. Due to the weld metal's high temperature strength, oxidation resistance, and metallurgical stability, the filler meta is also used for joining various dissimilar high-temperature alloys such as INCONEL alloys 600/601 and alloys 800HT/803.

Classification:

ASME/AWS A5.14 ERNiCrCoMo-1

Datasheet No.
NT01

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
620	25%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SMT61724

MONEL® Filler Metal 60

Features:

MONEL Filler Metal 60 is used for the gas-tungsten-arc welding of MONEL alloys 400, R404, and K-500. It has good strength and resists corrosion in many media, including sea water, salts and reducing acids.

Classification:

ASME/AWS A5.14 ERNiCu-7

Datasheet No.
NT02

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
485	30%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.6	4.54kg Tube	SMTMONEL6016
2.4	4.54kg Tube	SMTMONEL6024

NICKEL Filler Metal 61

Features:

NICKEL Filler Metal 61 is used for gas-tungsten-arc welding of Nickel 200 and 201. It is also used for surfacing of steel. Dissimilar welding applications for Nickel Filler Metal 61 include joining Nickel 200 and 201 to stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, copper-nickel alloys, and MONEL alloys.

Classification:

ASME/AWS A 5.7 ERNi-1

Datasheet No.
NT03

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
415	20%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SMTNICKEL6124

INCO-WELD® C276

Features:

INCO-WELD C276 Filler Metal is used for gas-tungsten-arc welding of INCONEL alloy C-276 and other nickel-chromium-molybdenum alloys. It is also used for surfacing of steel. The weld metal has excellent corrosion resistance in many aggressive media and is especially resistant to pitting and crevice corrosion.

Classification:

ASME/AWS A5.14 ERNiCrMo-4

Datasheet No.
NT04

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
690	30%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SMTC27624

INCO-WELD® 686CPT

Features:

INCO-WELD 686CPT Filler Metal is used for gas-tungsten-arc welding of duplex, super duplex and super-austenitic stainless steels, as well as nickel alloys such as UNS N06059/N06022. INCONEL alloy C-276 and INCONEL alloys 22, 625 and 686. It can also be used to deposit overlays with outstanding corrosion resistance onto a range of steels.

Classification:

ASME/AWS A5.14 ERNiCrCoMo-14

Datasheet No.
NT05

Typical Mechanical Properties	
Tensile Strength, MPa	Elongation
760	35%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
2.4	4.54kg Tube	SMT686CPT24
3.2	4.54kg Tube	SMT686CPT32

Hardfacing And Repair/Maintenance

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Hardfacing And Repair/Maintenance

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SOLID WELDING/SURFACING WIRE

NI-ROD® 44 FILLER METAL	RM01	51
NI-ROD® 99 FILLER METAL	RM02	51

S-350A.R

- Features:
- For rebuilding or worn steel parts and as a buffer layer prior to application of hardfacing
 - For AC or DC+ operation
 - Applications include: machine components, gear teeth, keyways
 - Carbon steel railroad track components and parts for earth-moving/mining equipment

Deposit Properties			
Hardness, HRc	Thickness	Flame Cut	Machining
34 – 39	Unlimited	Yes	Carbide Tools

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
3.2	350	5kg/20kg	HKS-350AR32
4.0	400	5kg/20kg	HKS-350AR40

S-13MN.B

- Features:
- Work-hardening austenitic manganese steel type electrode
 - Deposits are very tough, and work-harden rapidly in-service
 - Applications include: crusher jaws, hammer mills, impact breaker bars, and can also be used for joining manganese steel plates/components

Deposit Properties			
Hardness, HRc	Thickness	Flame Cut	Machining
16 - 20 A-W 45 - 54 W-H	Unlimited	Yes	Carbide Tools (As deposited)

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
3.2	350	5kg/20kg	HKS-13MNB32
4.0	400	5kg/20kg	HKS-13MNB40

S-700B.B

- Features:
- All-weld metal deposit is very hard martensite structure, containing small quantity of retained austenite
 - For AC or DC+ operation
 - Applications include: scrapper blades, auger flights, road ripperteeth, screw conveyors, bucket teeth, bucket sides and bottoms

Deposit Properties		
Hardness, HRc	Thickness	Machining
55 – 59	2 – 3 layers	No, Grinding only

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
3.2	350	5kg/20kg	HKS-700B32
4.0	400	5kg/20kg	HKS-700B40

Classification:

AS/NZS 2576: 1435-A4

Datasheet No.

HE01

Classification:

AS/NZS 2576: 1220-A4

Datasheet No.

HE02

Classification:

AS/NZS 2576: 1855-A4

Datasheet No.

HE03

S-711

- Features:
- S-711 Electrode deposits a chromium carbide/austenite structure
 - For AC or DC+ operation
 - Applications include: scrapper blades, auger flights, road ripperteeth, screw conveyors. bucket teeth, bucket sides and bottoms, cement plant components

Deposit Properties		
Hardness	Thickness	Machining
58 – 62 HRc	1 – 2 layers	No, Grinding only

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack/Carton	Part No.
3.2	350	5kg/20kg	HKS-71132
4.0	400	5kg/20kg	HKS-71140

Classification:

AS/NZS 2576: 2360-A4

Datasheet No.

HE04

Hardfacing | Manual Arc Surfacing Electrode

POSTALLOY® 216HD

- Features:
- Tubular hardfacing electrode with high chromium carbide content
 - Operates at much lower amperage than flux coated electrodes
 - Applications include: scrapper blades, auger flights, road ripper teeth, bucket teeth, sides and bottoms

Deposit Properties		
Hardness, HRc	Thickness	Machining
59 – 62	1 – 2 layers	No, Grinding only

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack	Part No.
6	455	4.54kg	PHF216HD

Classification:

AS/NZS 2576: 2360-A1

Datasheet No.

HE05

POSTALLOY® 219HD

- Features:
- Tubular hardfacing electrode with high tungsten carbide content
 - Operates at lower amperages and with high deposition rate
 - Applications include: auger points, debarking hammers, cutter teeth, anvil knives and flights

Deposit Properties		
Hardness, HRc	Thickness	Machining
64 – 68	1 – 2 layers	No, Grinding only

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack	Part No.
6	455	4.54kg	PHF219HD

Classification:

AS/NZS 2576: 3465-A1

Datasheet No.

HE06

POSTALLOY® 2892-SPL (350-G)

- Features:**
- Medium hardness build up wire with excellent compressive strength
 - Metal-cored, gas-shielded wire, for use with Ar-O₂ or Ar-CO₂ mixed gas
 - Applications include: machine components, gear teeth, keyways, carbon steel railroad track components and parts for earth-moving/mining equipment

Deposit Properties			
Hardness	Thickness	Flame Cut	Machining
33 – 38 HRc	Unlimited	Yes	Carbide Tools

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	11.4kg Spool	PHF350G12

POSTALLOY® 2892-FCO (350-O)

- Features:**
- Medium hardness build up wire with excellent compressive strength
 - Flux cored, open arc wire
 - Applications include: machine components, gear teeth, keyways, carbon steel railroad track components and parts for earth-moving/mining equipment

Deposit Properties			
Hardness, HRc	Thickness	Flame Cut	Machining
30 – 35	Unlimited	Yes	Carbide Tools

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	11.4kg Spool	PHF350-O12

POSTALLOY® 2850-FCO (MANG-O/G)

- Features:**
- Work-hardening austenitic manganese steel type flux-cored wire
 - For open arc (gasless) use – for vertical, 100% CO₂ is recommended
 - Designed for build-up, hardfacing and fabricating of manganese steel.
 - Deposits are very tough, and work-harden rapidly in-service
 - Applications include: crusher jaws, hammer mills, impact breaker bars, gyratory crusher mantels and for joining of manganese steel components

Deposit Properties			
Hardness, HRc	Thickness	Flame Cut	Machining
15 – 20 A-W 50 – 55 W-H	Unlimited	Yes	Carbide Tools (As deposited)

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.6	11.4kg Spool	PHFMANG-O16

Classification:
AS/NZS 2576: 1435-B5

Datasheet No.
HF01

Classification:
AS/NZS 2576: 1435-B7

Datasheet No.
HF02

Classification:
AS/NZS 2576: 1220-B5/B7

Datasheet No.
HF03

POSTALLOY® 289w8-SPL (650-G)

- Features:**
- General purpose self-hardening overlay with a good combination of resistance to abrasion and impact
 - Metal-cored, gas-shielded wire, for use with Ar-O₂ or Ar-CO₂ mixed gas
 - Applications include: hot shear blades, dozer blades, shearing and piercing dies, farm implements/augers

Deposit Properties		
Hardness, HRc	Thickness	Machining
55 – 58	2 – 3 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	4.54kg Spool	11.4 kg Spool
1.2	PHF650G1245	PHF650G12
1.6		PHF650G16

POSTALLOY® 2898-FCO (650-O)

- Features:**
- General purpose self-hardening overlay with a good combination of resistance to abrasion and impact
 - Flux-cored, open arc wire,
 - Applications include: Hot Shear Blades, Dozer Blades, Shearing and piercing dies, Farm Implements/Augers, Back hoes

Deposit Properties		
Hardness	Thickness	Machining
55 – 58 HRc	2 – 3 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	11.4kg Spool	PHF650-O12
1.6	11.4kg Spool	PHF650-O16

POSTALLOY® 2832-FCO (850-O/G)

- Features:**
- Premium chromium carbide alloy with a high volume fraction of carbides dispersed in a hard matrix
 - Metal-cored, open arc or gas shielded wire,
 - Applications include: scrapper blades, auger flights, road ripperteeth, screw conveyors, bucket teeth, bucket sides and bottoms

Deposit Properties		
Hardness, HRc	Thickness	Machining
58 – 62	1 – 2 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	11.4kg Spool	PHF850-O12
1.6	11.4kg Spool	PHF850-O16

Classification:
AS/NZS 2576: 1855-B5

Datasheet No.
HF04

Classification:
AS/NZS 2576: 1855-B7

Datasheet No.
HF05

Classification:
AS/NZS 2576: 2360-B5/B7

Datasheet No.
HF08



POSTALLOY® 2836-SPL

- Features:**
- High hardness multi-carbide hardfacing alloy
 - Metal-cored, open arc or gas shielded wire
 - Highly resistant to severe abrasion and maintains its hardness and wear resistance up to 760°C
 - Applications include: sinter plant parts, cement mill parts, coke pusher shoes, brick making equipment

Deposit Properties		
Hardness, HRc	Thickness	Machining
63 – 67	1 – 2 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	11.4kg Spool	PHF2836-12
1.6	11.4kg Spool	PHF2836-16

POSTALLOY® 299-SPL (Tungsten Carbide 299)

- Features:**
- For extreme earth abrasion resistance with little or no impact
 - Metal-cored, open-arc tungsten carbide in iron type hardfacing wire
 - Applications include: auger points, debarking hammers, cutter teeth, anvil knives and flights

Deposit Properties		
Hardness, HRc	Thickness	Machining
60 – 65	1 – 2 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.6	11.4kg Spool	PHF299-SPL16

POSTALLOY® PS-98 (Matrix PS-98) & WC Granules

- Features:**
- Matrix alloy wire for tungsten carbide (WC) embedding process
 - Metal-cored, gas shielded hardfacing wire
 - The microstructure of PS-98 is designed to encapsulate and protect the tungsten carbide particles from premature erosion

Deposit Properties		
Hardness, HRc	Thickness	Machining
60 – 65	1 – 2 layers	No, Grinding only

Dimensions and Packing Details		
Item	Pack	Part No.
1.2mm Wire	11.4kg Spool	PHF299-SPL16
#16-20 WC	25kg Container	DTC1620-1.18x.85
#14-20 WC	25kg Container	DTC1420-1.4x.85
#12-20 WC	25kg Container	DTC1220-1.7x0.85

Classification:
AS/NZS 2576: 2465-B5/B7

Datasheet No.
HF09

Classification:
AS/NZS 2576: 3465-B7

Datasheet No.
HF11

Classification (wire):
AS/NZS 2576: 1860-B5

Datasheet No.
HF12



TALARC HF350

- Features:**
- Medium hardness solid build up wire with high compressive strength
 - Can be used as a buffer layer prior to the application of higher hardness/abrasion resistant hardfacing
 - Applications include: machine components, gear teeth, keyways, carbon steel railroad track components and parts for earth-moving/mining equipment

Deposit Properties			
Hardness, HRc	Thickness	Flame Cut	Machining
32 – 37	Unlimited	Yes	Carbide Tools

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	INMHF3501215

TALARC HF600

- Features:**
- Solid wire depositing air-hardening martensitic type hardfacing alloy
 - Bronze coated wire for use with Ar+O₂ or Ar+CO₂ gas shield
 - Applications include: rolling mill rollers tracks, sliding rollers, screws, mill crushing jaws and excavation buckets and teeth

Deposit Properties		
Hardness, HRc	Thickness	Machining
55 – 58	2 – 3 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.0	15kg Spool	INMHF6001015
1.6	15kg Spool	INMHF6001615

TALARC EA600

- Features:**
- Solid wire depositing air-hardening martensitic type hardfacing alloy
 - Copper coated wire for use with Ar+O₂ or Ar+CO₂ gas shield
 - Applications include: rolling mill rollers tracks, sliding rollers, screws, mill crushing jaws and excavation buckets and teeth

Deposit Properties		
Hardness, HRc	Thickness	Machining
55 – 58	2 – 3 layers	No, Grinding only

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	15kg Spool	EA6001215

Classification:
AS/NZS 2576: 1435-B6

Datasheet No.
HM01

Classification:
AS/NZS 2576: 1855-B6

Datasheet No.
HM02

Classification:
AS/NZS 2576: 1855-B6

Datasheet No.
HM03



POSTALLOY® 50

Features:

- High nickel iron electrode with state-of-the-art coating technology
- For all grades of cast iron and cast iron to steel, and to stainless steel
- Use with AC or DC+ polarity

Deposit Properties		
Hardness, HV	Tensile Strength, MPa	Machinable
210	520	Yes

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack	Part No.
3.2	355	4.54kg Tube	PHF5032

Classification:

AWS/ASME A5.15 ENiFe-CI
(near equivalent)

Datasheet No.
RE01

POSTALLOY® 51

Features:

- High nickel electrode for cast irons with excellent weldability
- Deposits are dense, porosity-free and have outstanding machinability
- Use with AC or DC+ polarity.

Deposit Properties		
Hardness, HV	Tensile Strength, MPa	Machinable
180	380	Yes

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack	Part No.
2.5	255	2.27kg Tube	PHF5125
3.2	355	4.54kg Tube	PHF5132
4.0	355	4.54kg Tube	PHF5140

Classification:

AWS/ASME A5.15 ENi-CI
(near equivalent)

Datasheet No.
RE02

POSTALLOY® 505

Features:

- High nickel iron electrode for the repair of various types of cast iron
- Good for heavy sections and for joining cast iron to steel
- Use with AC or DC+ polarity

Deposit Properties		
Hardness, HV	Tensile Strength, MPa	Machinable
210	450	Yes

Dimensions and Packing Details			
Diameter, mm	Length, mm	Pack	Part No.
2.5	255	2.27kg Tube	PHF50525
3.2	355	4.54kg Tube	PHF50532

Classification:

AWS/ASME A5.15 ENiFe-CI

Datasheet No.
RE03



CAST IRON WELDING WIRE

Features:

- Composite metal cored wire for repair and joining of cast irons
- For all grades of cast iron and for joining cast iron to steel, use with Argon + 1-3% O₂ shielding gas

Deposit Properties		
Hardness, HV	Tensile Strength, MPa	Machinable
190 – 220	460	Yes

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	2.27kg Spool	WCNI5512

Classification:

AWS/ASME A5.15 ENiFe-CI
(for equivalent electrode)

Datasheet No.
RF01



NI-ROD® 44 Filler Metal

Features:

- Solid nickel-iron-manganese wire for the repair and welding of ductile, malleable and grey cast irons
- All-position weldability
- Excellent performance with good wetting and crack resistance

Deposit Properties		
Tensile Strength, MPa	Elongation	Machinable
690	35%	Yes

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	13.62kg Spool	SMMNIROD4412

Classification:

AWS/ASME A5.15 ENiFeMn-CI

Datasheet No.
RM01

NI-ROD® 99 Filler Metal

Features:

- Solid nickel wire for welding ductile, malleable and grey cast irons
- Pure nickel deposit with easy machinability
- Dissimilar-welding applications include gas-metal-arc welding of cast ironsto low-alloy and carbon steels

Deposit Properties		
Tensile Strength, MPa	Elongation	Machinable
490	12%	Yes

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	13.62kg Spool	SMMNIROD9909
1.2	13.62kg Spool	SMMNIROD9912

Classification:

AWS/ASME A5.15 ENi-CI

Datasheet No.
RM02

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TALWELD SilBro

Features:
TALWELD SILBRO filler metal is a copper-base alloys containing approx. 3% silicon. It is used for the gas metal arc welding of copper-silicon and copper-zinc alloys (brass) and for welding steel to itself or to these alloys.

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
165	350	30%

Dimensions and Packing Details		
Diameter, mm	5kg Spool	13.6kg Spool
0.8	CMCSILBRO0805	CMCSILBRO08
0.9	CMCSILBRO0905	CMCSILBRO09
1.2		CMCSILBRO12
1.6		CMCSILBRO16

Classification:
AWS A5.7 ERCuSi-A

Datasheet No.
CM01

BRONZE WELD A2

Features:
Bronze Weld-A2 filler metal is an intermediate-strength aluminium bronze alloy used for welding aluminium bronze plate fabrications and for joining dissimilar metals such as cast iron, carbon steels, copper, bronze and copper-nickel materials.

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
270	540	28%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
0.9	13.6kg Spool	CMWA209
1.2	13.6kg Spool	CMWA212
1.6	13.6 kg Spool	CMWA216

Classification:
AWS A5.7 ERCuAl-A2

Datasheet No.
CM02

NICKEL ALU BRONZE

Features:
Nickel Alu-Bronze is a nickel-aluminium bronze alloy used to weld cast and wrought nickel-aluminium bronze. It has excellent resistance to corrosion, erosion, and cavitation wear in salt or brackish water. Typical applications include the fabrication or repair of ship fittings and propellers, and other components exposed to salty and brackish water.

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
360	570	24%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	13.6kg Spool	CMWNiAlBro12

Classification:
AWS A5.7 ERCuNiAl

Datasheet No.
CM03

TALWELD Phos-C/Phos-C Weld

Features:
TALWELD PHOS-C (ex China) and **Phos-C Weld** (ex USA) wires contain 8% tin. They are harder and stronger than AWS 5.7 ER CuSn-A, and are preferred for welding phosphor bronzes, high strength bronzes and brasses. The alloys' colour matches phosphor bronze very well.

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
320	480	24%

Dimensions and Packing Details		
Diameter, mm	13.6kg Spool Talweld Phos-C	13.6kg Spool Phos-C Weld
1.2	CMCPHOS-C12	CMWPHOS-C12

Classification:
AWS A5.7 ERCuSn-C

Datasheet No.
CM04

TALWELD DE-OX

Features:
TALWELD DE-OX filler metal is deoxidized copper with small quantities of phosphorus, silicon, tin and manganese. The phosphorus and silicon are primarily deoxidizers, while silicon and other elements improve fluidity and ease of welding. This wire is normally used to weld deoxidized copper (C12000 and C12200) and electrolytic tough pitch copper (C11000).

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
60	210	29%

Dimensions and Packing Details		
Diameter, mm	Pack	Part No.
1.2	13.6kg Spool	CMCDEOX12
1.6	13.6kg Spool	CMCDEOX16

Classification:
AWS A5.7 ERCu

Datasheet No.
CM05

TALWELD SiIBro/Sil-Weld TIG

Features:

TALWELD SILBRO (ex China) and **Sil-Weld** (ex USA) filler metal are copper-base alloys containing approx. 3% silicon. They are used for the gas tungsten arc (GTAW/TIG) welding of copper-silicon and copper-zinc alloys (brass) and for welding steel to itself or to these alloys.

Classification:

AWS A5.7 ERCuSi-A

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
165	350	30%

Dimensions and Packing Details					
Diameter, mm	Pack	SiIBro, ex China		Sil-Weld, ex USA	
		Length, mm	Part No.	Length, mm	Part No.
1.6	5kg Tube	1000	CTCSILBRO16	915	CTWSILBRO16
2.4	5kg Tube	1000	CTCSILBRO24	915	CTWSILBRO24
3.2	5kg Tube	1000	CTCSILBRO32	915	CTWSILBRO32

BRONZE WELD A2 TIG

Features:

Bronze Weld-A2 filler metal is an intermediate-strength aluminium bronze alloy used for gas tungsten arc (GTAW/TIG) welding aluminium bronze plate fabrications and for joining dissimilar metals such as cast iron, carbon steels, copper, bronze and copper-nickel materials.

Classification:

AWS A5.7 ERCuAl-A2

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
270	540	28%

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	915	CTWA216
2.4	5kg Tube	915	CTWA224
3.2	5kg Tube	915	CTWA232

TALWELD DE-OX

Features:

TALWELD DE-OX filler metal is deoxidized copper with small quantities of phosphorus, silicon, tin and manganese. The phosphorus and silicon are primarily deoxidizers, while silicon and other elements improve fluidity and ease of welding.

Classification:

AWS A5.7 ERCu

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
60	210	29%

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
2.4	5kg Tube	1000	CTCDEOX24
3.2	5kg Tube	1000	CTCDEOX32

Datasheet No.

CT01

Datasheet No.

CT02

Datasheet No.

CT03

Manganese Bronze

Features:

TALWELD Manganese Bronze is a low-fuming copper-zinc alloy used on steels, copper alloys, nickel alloys, and stainless steel. It s available as a bare rod and in convenient-to-use flux-coated format. The deposits are readily machinable. It can be used with standard oxy-fuel torches – a brazing flux is recommended for use with bare rod.

Classification:

AWS A5.8 RB CuZn-C
AS 1167.1 R CuZn-C

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
175	455	32%

Dimensions and Packing Details				
Diameter, mm	Pack	Length, mm	Bare Rod	Flux Coated
1.6	5kg Tube	1000	CTCMANGBRO16	
2.4	5kg Tube	1000	CTCMANGBRO24	CTCMANGBROFX24
3.2	5kg Tube	1000	CTCMANGBRO32	CTCMANGBROFX32

Tobin Bronze

Features:

TALWELD Tobin Bronze is a bare rod copper-zinc alloy used for brazing or oxyfuel (oxyacetylene) gas welding of steel, cast iron, copper-bronze and nickel alloys. The deposits are readily machinable. It can be used with standard oxy-fuel torches – use of a brazing flux is recommended with this alloy.

Classification:

AWS A5.8 RB CuZn-A
AS 1167.1 R CuZn-A

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
120	365	38%

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	CTCTOBINBRO16
2.4	5kg Tube	1000	CTCTOBINBRO24

Nickel Bronze

Features:

TALWELD Nickel Bronze is a bare copper-zinc alloy containing 10%Ni. It used for high strength brazing or oxyfuel (oxyacetylene) gas welding of steel, cast iron, copper-bronze and nickel alloys, and also finds use in attaching carbide tungsten tips in cutting tools. The deposits are easily machinable. It can be used with standard oxy-fuel torches – use of a brazing flux is recommended with this alloy.

Classification:

AWS A5.8 RB CuZn-D
AS 1167.1 R CuZn-D

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
260	480	21%

Dimensions and Packing Details			
Diameter, mm	Pack	Length, mm	Part No.
1.6	5kg Tube	1000	CTCNICKELBRO16
2.4	5kg Tube	1000	CTCNICKELBRO24

Datasheet No.

CT04

Datasheet No.

CT05

Datasheet No.

CT06

TALWELD 5356 MIG and TIG

Features:
TALWELD 5356 is an aluminium alloy TIG rod containing 5% magnesium for welding wrought or cast aluminium alloys of similar composition. It is the most universally used aluminium filler metal. It has good corrosion resistance and high strength.

Classification:
AWS A5.10 ER5356
AS/NZS ISO 18273 S Al 5356

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
125	240	17%

Dimensions and Packing Details – GMA Wire		
Diameter, mm	Pack	Part No.
0.8	2kg Spool	AMC53560802
0.9	2kg Spool	AMC53560802
1.0	2kg Spool	AMC53561002

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	2.5kg Tube	ATC535616
2.4	2.5kg Tube	ATC535624
3.2	2.5kg Tube	ATC535632

SAFRA aluminium wire (6kg spools) and TIG rods (5kg packs) are also available

TALWELD 4043 TIG

Features:
TALWELD 4043 is an aluminium alloy TIG rod containing 5% silicon used for welding of cast and wrought aluminium alloys. Its silicon content gives lower strength and excellent crack resistance, particularly for the repair of castings.

Classification:
AWS A5.10 ER4043
AS/NZS ISO 18273 S Al 4043

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
125	240	17%

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	2.5kg Tube	ATC404316
2.4	2.5kg Tube	ATC404324
3.2	2.5kg Tube	ATC404332

Datasheet No.
AT01

TALWELD 4047 TIG

Features:
TALWELD 4047 is an aluminium alloy TIG rod containing 12% silicon and can used for welding castings, forgings and extruded shapes. It has a low melting point and good fluidity, resulting in low parent metal distortion.

Classification:
AWS A5.10 ER4047
AS/NZS ISO 18273 S Al 4047

Typical Mechanical Properties		
Yield Strength, MPa	Tensile Strength, MPa	Elongation
130	160	6%

Dimensions and Packing Details – TIG Rod		
Diameter, mm	Pack	Part No.
1.6	2.5kg Tube	ATC404716
2.4	2.5kg Tube	ATC404724
3.2	2.5kg Tube	ATC404732

Datasheet No.
AT02

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