

MIG WELD

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Aluminium and Copper filler metals

ML1070 AL99,7	3
ML1450 AL99,5Ti	4
ML2319 AlCu6MnZrTi	5
ML3103 AlMn1	6
ML4008 AlSi7Mg	7
ML4043 AlSi5	8
ML4047 AlSi12	9
ML4145 AlSi10Cu4	10
ML5087 AlMg4,5MnZr	11
ML5183 AlMg4,5Mn0,7	12
ML5356 AlMg5Cr	13
ML5554 AlMg2,7Mn	14
ML5556 AlMg5Mn1Ti	15
ML5556A AlMg5Mn1	16
ML5754 AlMg3	17
ML AlMg6Zr	18
Spools and Packaging	19
Bulk Packages	20
MW CuAl8	22
MW CuAl9Fe	23
MW CuSi3	24
MW CuSi28L	25
MW CuSn	26
MW CuSn6	27
MW CuMn13Al7	28
MW CuAl8Ni2	29
MW CuAl8Ni6	30
Spools and Packaging	31
Bulk Packages	32
Accessories for bulk packs	33

ML1070 AL99,7

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 1070 (Al99,7)
	DIN EN 1706	-
	AWS A 5-10	ER 1070
	Material No.	3.0259

Typical composition in %

Si < 0,20	Fe < 0,25	Cu < 0,04	Mn < 0,03	Mg < 0,03	Cr -	Zn < 0,04
V < 0,05	Ti < 0,03	Zr -	Be < 0,0003	Al > 99,7	Others total -	Other each < 0,03

Approvals	On request
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Description

Aluminium wires and rods for welding alloys with mostly pure aluminium basis (maximum 0,5% of alloyed elements). The alloy has a high resistance against corrosion.

Application Fields

Applications in chemistry, electronics, construction and food industries. Materials to be welded are for instance: Al99,0, Al99,5, Al99,7, E-Al

Mechanical Characteristics

Tensile Strength R_m	$\geq 65 \text{ N/mm}^2$
Elongation A5 ($L_0=5d_0$)	35 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position

PA, PB, PC, PF

Polarity

MIG =+ | WIG ~

Shielding gas

DIN EN ISO 14175-I1-I2-I3

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S300 - 6 kg | B300 - 7kg | BS300 - 7 kg | B400 -18kg | B400 40 kg

Pack size rods

TIG carton box of 5 kg or 10kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

ML1450 AL99,5Ti

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 1450 (Al99,5Ti)
	DIN EN 1706	-
	AWS A 5-10	ER 1450
	Material No.	3.0805

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,05	Mn < 0,05	Mg < 0,05	Cr -	Zn < 0,07
V -	Ti 0,10 - 0,20	Zr -	Be < 0,0003	Al > 99,5	Others total -	Other each < 0,03

Approvals	On request
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Description	Aluminium wires and rods for welding of alloys with mostly pure aluminium basis (maximum 0,5% of alloyed elements). Titanium acts as-grain refiner offering the material special characteristics as, for example, a higher corrosion resistance.
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Application Fields	Applications in the chemistry, construction and food industries. Materials to be welded are for instance: Al99,0, Al99,5, Al99,7, E-Al
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Mechanical Characteristics	Tensile Strength R_m	$\geq 65 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	35 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML2319 AlCu6MnZrTi

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 2319 (AlCu6MnZrTi)
	DIN EN 1706	-
	AWS A 5-10	ER 2319
	Material No.	-

Typical composition in %

Si < 0,20	Fe < 0,30	Cu 5,80 - 6,80	Mn 0,20 - 0,40	Mg < 0,02	Cr -	Zn < 0,10
V 0,05 - 0,15	Ti 0,10 - 0,20	Zr 0,10 - 0,25	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On request
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Description

The alloy AlCu6MnZrTi/ER 2319 is hardenable and produces higher strength and ductility than the 4xxx series filler alloys when welds in 2014, 2036, 2219 and Al-Cu casting alloys are post welds heat-treated. Depending in the after treatment like heat treating and aging the mechanical properties can be much higher than shown below.

Application Fields	This alloy is mainly used in the air- and spacecraft industry.
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Mechanical Characteristics

Tensile Strength R_m $\geq 240 \text{ N/mm}^2$

Elongation A5 ($L_0=5d_0$) 3 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML3103 AlMn1

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	-
	DIN EN 1706	-
	AWS A 5-10	ER3101
	Material No.	3.0516

Typical composition in %

Si < 0,50	Fe < 0,70	Cu < 0,10	Mn 0,90 - 1,50	Mg <0,30	Cr < 0,10	Zn < 0,20
V -	Ti Ti+Zr < 0,10	Zr -	Be -	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On request
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Description	The alloy has a good chemical resistance, which provides the possibility to be used in chemical industries especially for heat exchangers. The weld metal solidifies eutectically, therefore the weld metal is not susceptible to hot cracks. (by usage of similar parent materials)
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Application Fields	Typical applications are pressure vessels, civil construction, pipes and heat exchanger
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Mechanical Characteristics	Tensile Strength R_m	$\geq 105 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	29 %
Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.		

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML4008 AlSi7Mg

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	-
	DIN EN 1706	EN AC-42000
	AWS A 5-10	ER 4008
	Material No.	-

Typical composition in %

Si 6,50 - 7,50	Fe < 0,09	Cu < 0,05	Mn < 0,05	Mg 0,30 - 0,45	Cr -	Zn < 0,05
V -	Ti 0,04 - 0,15	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On request
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Description

This alloy is produced with controlled lower levels of impurities than those present in alloys 4010 and 356.0, A356.0 and A357.0. It is a product that meets chemistry requirements of AMS4181. The alloys 356.0, A356.0 and A357.0 are typically used to manufacture sand and permanent mould castings. Alloy 4008 is an excellent choice to join or repair these castings and, if needed, it can be heat treated in order to increase its mechanical properties.

Application Fields	Repair and join casting. Air- and Spacecraft industries
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Mechanical Characteristics

Tensile Strength R_m $\geq 140 \text{ N/mm}^2$

Elongation A5 ($L_0=5d_0$) 6 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML4043 AlSi5

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 4043 (AlSi5 (A))
	DIN EN 1706	-
	AWS A 5-10	ER 4043
	Material No.	3.2245

Typical composition in %

Si 4,50 - 6,00	Fe < 0,60	Cu < 0,30	Mn < 0,05	Mg < 0,05	Cr -	Zn < 0,10
V -	Ti < 0,20	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: DB TÜV TIG: DB TÜV
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Description	This alloy is particularly used to prevent solidification cracks in connection with high dilution and clamp conditions. Anodizing gives dark grey colours and is not recommended. The weld pool is very fluid. Our chemical analysis meets the specification of 4043 and 4043A
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Application Fields	Automotive, constructions, heat exchangers, AlSi alloys up to 7% Si, AlMgSi0,5, AlMgSi0,8, AlMgSi1, AlZnMg, AlCuMg
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Mechanical Characteristics	Tensile Strength R_m	$\geq 130 \text{ N/mm}^2$
	Elongation A5 (L0=5d0)	5 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML4047 AlSi12

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 4047 (AlSi12 (A))
	DIN EN 1706	-
	AWS A 5-10	ER 4047
	Material No.	3.2585

Typical composition in %

Si 11,00 - 13,00	Fe < 0,80	Cu < 0,30	Mn < 0,15	Mg < 0,1	Cr -	Zn < 0,20
V -	Ti -	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: DB
	TIG: DB

Description	Aluminium wires and rods for welding and brazing. Good mechanical characteristics: its excellent corrosion resistance and low melting point ensure a very low number of deformations in the parent metal. This material is generally used for brazing aluminium sheets, for extrusions and castings. (After anodizing the welding will be of a different colour). Our chemical analysis meets the specification of 4047 and 4047A
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Application Fields	Automotive, constructions, heat exchangers, G-AlSi10Mg, G-AlSi11, G-AlSi12(Cu), G-AlSi7Mg, G-AlSi6Cu4, AlMgSi0,8, AlMgSi1
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Mechanical Characteristics	Tensile Strength R_m	$\geq 130 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	5 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML4145 AlSi10Cu4

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 4145
	DIN EN 1706	-
	AWS A 5-10	ER 4145
	Material No.	-

Typical composition in %

Si 9,30 - 10,70	Fe < 0,80	Cu 3,30 - 4,70	Mn < 0,15	Mg < 0,15	Cr < 0,15	Zn < 0,20
V -	Ti -	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals

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Description

Originally developed as a brazing alloy due to its low melting point and high fluidity. This alloy is scarcely susceptible to cracking when used to weld alloys of series 2XXX or aluminium-copper-silicium alloys. It can be used for applications where high temperatures are required. This alloy is usually preferred to the 2319 alloy as it flows better in the weld puddle. The weld bead has a brighter and a more "smut free" appearance with respect to other alloys. It has an ultimate tensile strength lower than alloy 2319. It is not recommended to use this alloy for welding aluminium alloys with a high magnesium content

Application Fields

Brazing applications, Heat exchangers, AlSiCu

Mechanical Characteristics

Tensile Strength R_m $\geq 130 \text{ N/mm}^2$

Elongation A5 ($L_0=5d_0$) 5 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position

PA, PB, PC, PF

Polarity

MIG =+ | WIG ~

Shielding gas

DIN EN ISO 14175-I1-I2-I3

Available sizes Ø

MIG-wires [mm] 0,8 | 1,0 | 1,2 | 1,6 | 2,0 | 2,4

TIG-Rods [mm] 1,6 | 2,0 | 2,4 | 3,2 | 4,0

Pack size spools

S300 - 6 kg | B300 - 7kg | BS300 - 7 kg | B400 -18kg | B400 40 kg

Pack size rods

TIG carton box of 5 kg or 10kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

ML5087 AlMg4,5MnZr

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5087 (AlMg4,5MnZr)
	DIN EN 1706	-
	AWS A 5-10	ER 5087
	Material No.	3.3546

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,05	Mn 0,70 1,10	Mg 4,50 - 5,20	Cr 0,05 - 0,25	Zn < 0,25
V -	Ti 0,15	Zr 0,10 - 0,20	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: DNV-GL ABS DB TÜV Bureau Veritas TIG: DB TÜV
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Description	Aluminium wires and rods for welding aluminium-magnesium basis alloys with maximum 5% Mg. Zirconium acts as grain-refiner to improve both the bending and the corrosion resistance. The weld is not susceptible to hot cracking. Particularly advantageous for complicated weldments involving clamp conditions.
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Application Fields	Applications in the construction of ships, off-shore, storage tanks, railways and automotive industry. Metals to be welded: AlMg4,5Mn, AlZnMgCu1,5, AlMg5Mn, AlMg3, AlMg5, AlMgMn, AlZn,Mg1, G-AlMg3Si, G-AlMg10, AlMgSi0,7
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Mechanical Characteristics	Tensile Strength R_m	$\geq 275 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	17 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML5183 AlMg4,5Mn0,7

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5183 (AlMg4,5Mn0,7)
	DIN EN 1706	-
	AWS A 5-10	ER 5183
	Material No.	3.3548

Typical composition in %

Si < 0,40	Fe < 0,40	Cu < 0,10	Mn 0,50 - 1,00	Mg 4,30 - 5,20	Cr 0,05 - 0,25	Zn < 0,25
V -	Ti < 0,15	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: DNV-GL ABS LR DB TÜV Bureau Veritas KR BWB TIG: DB TÜV
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Description	Welding wires and rods to be used when very high seawater corrosion resistance is needed.
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Application Fields	Applications in the construction of ships, offshore, cryogenic plants, railway and in the automotive industry. Materials to be welded: AlMg4,5Mn, AlMg5, AlMg2Mn0,8, AlZnMg1, AlZnMgCu0,5, AlMgSi0,5, AlMgSi1, G-AlMg10, G-AlMg5, ,G-AlMg3Si, G-AlMg5Si
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Mechanical Characteristics	Tensile Strength R_m	$\geq 275 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	17 %
	Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.	

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML5356 AlMg5Cr

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5356 (AlMg5MnCr)
	DIN EN 1706	-
	AWS A 5-10	ER 5356
	Material No.	3.3556

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,10	Mn 0,05 - 0,20	Mg 4,50 - 5,50	Cr 0,05 - 0,20	Zn < 0,10
V -	Ti 0,06 - 0,20	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: DNV-GL ABS DB TÜV Bureau Veritas
	TIG: DB TÜV

Description

The weld metal is sea water resistant. Suitable for anodizing when matching colours are required.

Application Fields

Applications in the construction of ships, offshore, railway and in the automotive industry. Materials to be welded: AlMg5, AlMg3, AlZnMg1, AlZnMgCu0,5, AlMgSi0,7, AlMg1SiCu, G-AlMg10, G-AlMg3Si, G-AlMg5Si

Mechanical Characteristics

Tensile Strength R_m ≥ 240 N/mm²

Elongation A5 (L0=5d0) 17 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position

PA, PB, PC, PE, PF

Polarity

MIG =+ | WIG ~

Shielding gas

DIN EN ISO 14175-I1-I2-I3

Available sizes Ø

MIG-wires [mm] 0,8 | 1,0 | 1,2 | 1,6 | 2,0 | 2,4

TIG-Rods [mm] 1,6 | 2,0 | 2,4 | 3,2 | 4,0

Pack size spools

S300 - 6 kg | B300 - 7kg | BS300 - 7 kg | B400 -18kg | B400 40 kg

Pack size rods

TIG carton box of 5 kg or 10kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

ML5554 AlMg2,7Mn

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5554 (AlMg2,7Mn)
	DIN EN 1706	-
	AWS A 5-10	ER 5554
	Material No.	3.3538

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,10	Mn 0,50 - 1,00	Mg 2,40 - 3,00	Cr 0,05 - 0,20	Zn < 0,25
V -	Ti 0,05 - 0,20	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On request
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Description	This alloy was developed for applications at high temperatures and for resistance against intergranular corrosion. The weld metal is sea water resistant.
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Application Fields	Joining of the base metal 5454 with alloys of the 6000 range is possible. Materials to be welded: AlMg3, AlZnMg1, AlZnMgCu0,5, AlMgSi0,7, AlMg1SiCu, G-AlMg3Si
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Mechanical Characteristics	Tensile Strength R_m	$\geq 215 \text{ N/mm}^2$
	Elongation A5 ($L_0=5d_0$)	17 %
	Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.	

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML5556 AlMg5Mn1Ti

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5556 (AlMg5Mn1Ti (A))
	DIN EN 1706	-
	AWS A 5-10	ER 5556
	Material No.	-

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,10	Mn 0,50 - 1,00	Mg 4,70 - 5,50	Cr 0,05 - 0,20	Zn < 0,25
V -	Ti 0,05 - 0,20	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: TÜV
	TIG: TÜV

Description

Aluminium wire and rods used to weld aluminium magnesium base metal alloys with a maximum of 5,3% Mg. All elements of this alloy are closely controlled for optimum weld strength.

Application Fields

Applications in military industry, general constructions and structural industry. Materials to be welded: AlMg4,5Mn, AlMg5Mn, AlMg5, AlZn4,5Mg1, AlMg2,7Mn, AlMgSi1

Mechanical Characteristics

Tensile Strength R_m $\geq 275 \text{ N/mm}^2$

Elongation A5 ($L_0=5d_0$) 17 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PE, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML5556A AlMg5Mn1

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5556 (AlMg5Mn1 (A))
	DIN EN 1706	-
	AWS A 5-10	ER 5556A
	Material No.	-

Typical composition in %

Si < 0,25	Fe < 0,40	Cu < 0,10	Mn 0,60 - 1,00	Mg 5,0 - 5,5	Cr 0,05 - 0,20	Zn < 0,25
V -	Ti 0,05 - 0,20	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	MIG: TÜV
	TIG: TÜV

Description	Aluminium wire and rods used to weld aluminium magnesium base metal alloys with a maximum of 5,3% Mg. All elements of this alloy are closely controlled for optimum weld strength. Al S 5556A owns a higher minium content of Mg and Mn compared to S Al 5556
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Application Fields	Applications in military industry, general constructions and structural industry. Materials to be welded: AlMg4,5Mn, AlMg5Mn, AlMg5, AlZn4,5Mg1, AlMg2,7Mn, AlMgSi1
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Mechanical Characteristics	Tensile Strength R _m	≥275 N/mm ²
	Elongation A5 (L0=5d0)	17 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PE, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML5754 AlMg3

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	S Al 5754 (AlMg53)
	DIN EN 1706	-
	AWS A 5-10	ER 5754
	Material No.	3.3536

Typical composition in %

Si < 0,40	Fe < 0,40	Cu < 0,10	Mn < 0,50	Mg 2,60 - 3,60	Cr 0,3	Zn < 0,20
V -	Ti < 0,15	Zr -	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On request
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Description

Wires and rods for welding aluminium basis alloys with maximum 3% Mg. These alloys are suitable for a big range of applications in the construction sector, in general, and in the structural industry. They are corrosion-resistance and show an excellent colour-uniformity after anodizing

Application Fields

Civil Construction, structural Industrial. Materials to be welded: AlMgMn, AlMg1, AlMg2,7Mn, AlMg3, AlMg3,5, AlMgSi0,5, AlMgSi0,8, G-AlMg3Si

Mechanical Characteristics

Tensile Strength R_m $\geq 190 \text{ N/mm}^2$

Elongation A5 ($L_0=5d_0$) 20 %

Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
-----------------	----------------

Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

ML AlMg6Zr

Rod / Wire electrode for Aluminium

Classification	EN ISO 18273	-
	DIN EN 1706	-
	AWS A 5-10	-
	Material No.	-

Typical composition in %

Si < 0,40	Fe < 0,20	Cu < 0,05	Mn 0,80 - 0,90	Mg 5,50 - 6,10	Cr < 0,003	Zn < 0,20
V -	Ti 0,02 - 0,20	Zr 0,08 - 0,12	Be < 0,0003	Al Remainder	Others total < 0,15	Other each < 0,05

Approvals	On Request
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Description	Welded Aluminium applications are found in all structural fields, but especially in those that take full advantage of the metals light weight, combined with high corrosion resistance and mechanical properties. Best mechanical to be values achieved Alloys 5083 and 5059.
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Application Fields	MIG WELD AlMg6Zr welding wire the most appropriate filler material when the optimum combination of strength, ductility and corrosion resistance are to be achieved. Best mechanical to be values achieved Alloys 5083 and 5059. Shipbuilding and LNG-Tanks
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Mechanical Characteristics	Tensile Strength R_m	280 - 365 N/mm ²
	Elongation A5 (L0=5d0)	20 - 30 %
	Mechanical properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.	

Welding Position	PA, PB, PC, PF
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Polarity	MIG =+ WIG ~
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Shielding gas	DIN EN ISO 14175-I1-I2-I3
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Available sizes Ø	MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
	TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools	S300 - 6 kg B300 - 7kg BS300 - 7 kg B400 -18kg B400 40 kg
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Pack size rods	TIG carton box of 5 kg or 10kg (x 1000 mm length)
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MORE DIAMETERS AND PACKING UPON REQUEST

Spools and Packaging

TIG RodsPackung

S100 0,5KG



S200 2KG

S300 6KG



B300 7KG

BS300 7KG



B400 18KG

B400 40KG



Bulk Packages

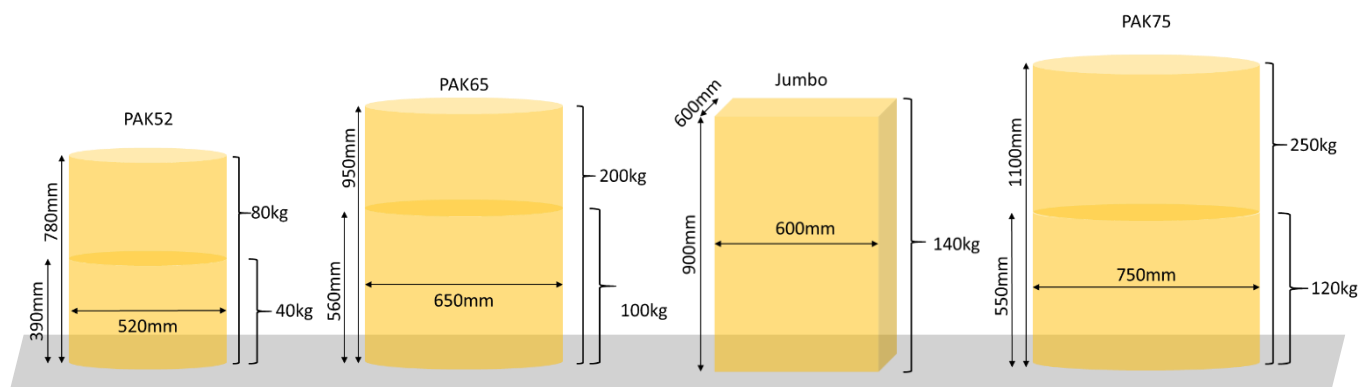
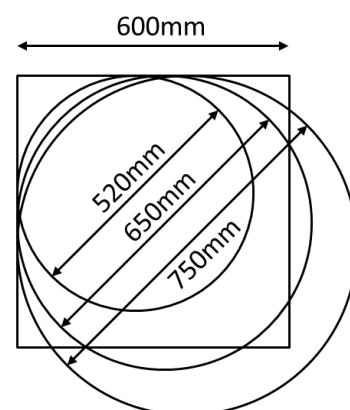
Round drum size



Jumbo Pack



	Diameter / width of drums [mm]	Hight [mm]	Weight [kg]
PAK52	520	390	40
PAK52	520	780	80
Jumbo	600	900	140
PAK65S	650	560	100
PAK65M	650	950	200
PAK75L	750	550	120
PAK75XL	750	1100	250





MW CuAl8

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu-Al-A1
	DIN 1733	MW CuAl8
	BS 2901 Pt3	C28
	En ISO 24373	S Cu 6100-CuAl7
	Material No.	2.0921

Typical composition in %

Al 6,00 - 8,50	Si < 0,20	Mn -	Ni -	Zn < 0,20	Sn -
Pb < 0,02	Fe -	P -	As -	Cu Remainder	Others total < 0,40

Description

The alloy MW CuAl8 has been developed for welding copper alloys and for coatings on steel, steel castings, nickel alloys and for fixing works in artistic foundries. Excellent for metal spraying. This material offers a very high resistance to seawater-corrosion and to the most commonly used acids in any concentration and at any temperature they may be needed. High erosion resistance. Often used for brazing galvanised steel sheets.

Application Fields

Shipbuilding: propellers, pumps, shafts and valves, bearings, main shafts. Chemical industry: gate valves, sleeves, pipes, heat exchangers, gear housings. Automotive industry: maintenance of car-parts and tools, bearings in general and galvanized sheets. Construction industry: welding and coating of aluminium-bronze with steel basis. Recommended for coating wearing metal.

Techological characteristics

Tensile Strength Rm	390 - 450 N/mm ²
Elongation A5 (L0=5d0)	≥ 45 %
Hardness	80 - 110 HB
Hardness after work hardening	140 HB
Conductivity	8 m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Shielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuAl9Fe

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu-Al-A2
	DIN 1733	MW CuAl9Fe
	BS 2901 Pt3	C13
	En ISO 24373	S Cu 6180 - CuAl10Fe
	Material No.	2.0937

Typical composition in %

Al 8,50 - 11,00	Si < 0,10	Mn -	Ni -	Zn < 0,02	Sn -
Pb < 0,02	Fe < 1,50	P -	As -	Cu Remainder	Others total < 0,50

Description

This weld metal is a Copper-Aluminium alloy one that is generally used for joining CuAl-Alloys or similar compositions for CuMn-, CuSi-, CuSn- and some CuNi-Alloys.

Application Fields

The MIG WELD alloy MW CuAl9Fe is suitable for welding parts which can undergo seawater corrosion. It is also used for joining dissimilar alloys, as for example copper and steel, cast iron, CuSn-Alloys and for a wide range of coating applications. Excellent for metal spraying.

Techological characteristics

Tensile Strength Rm	390 - 500 N/mm ²
Elongation A5 (L0=5d0)	≥ 45 %
Hardness	90 - 120 HB
Hardness after work hardening	140 - 160 HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Schielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuSi3

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu Si-A
	DIN 1733	MW CuSi3
	BS 2901 Pt3	C9
	En ISO 24373	S Cu 6560-CuSi3Mn1
	Material No.	2.1461

Typical composition in %

Al < 0,02	Si 2,80 - 4,00	Mn 0,50 - 1,50	Ni -	Zn < 0,40	Sn < 0,20
Pb < 0,02	Fe < 0,50	P < 0,05	As -	Cu Remainder	Others total < 0,50

Description

This alloy is used for inert gas arc welding of metals with copper basis, as, for example, CuSi, CuZn and galvanized sheets, also connected to steel.

Application Fields

This material is frequently used for fixing in artistic foundries, for welding galvanized sheets and even as coating of steel using the MIG and TIG methods. It is also suitable for surfaces subject to corrosion.

Technological characteristics

Tensile Strength Rm	330 - 370 N/mm ²
Elongation A5 (L0=5d0)	≥ 40 %
Hardness	80 - 90 HB
Hardness after work hardening	- HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Shielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuSi28L

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu Si-A
	DIN 1733	MW CuSi28L
	BS 2901 Pt3	C9
	En ISO 24373	S Cu 6560-CuSi3Mn1
	Material No.	2.1461

Typical composition in %

Al < 0,01	Si 2,80 - 2,95	Mn 0,75 - 1,50	Ni -	Zn < 0,20	Sn < 0,20
Pb < 0,02	Fe < 0,30	P < 0,02	As -	Cu Remainder	Others total < 0,40

Description

Best choice for Laser brazing of zinc-coated steel plates. Used for inert metal gas welding of Cu, CuSi and CuZn base metals to themselves.

Frequently used for fixing in artistic foundries, for welding galvanized sheets and even as a coating of steel using the MIG and TIG methods.

Suitable for surfaces subject to corrosion.

Application Fields

Automotive, Artistic foundries

Technological characteristics

Tensile Strength Rm	330 - 370 N/mm ²
Elongation A5 (L0=5d0)	≥ 40 %
Hardness	80 - 90 HB
Hardness after work hardening	- HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Shielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuSn

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu
	DIN 1733	MW CuSn
	BS 2901 Pt3	C7
	En ISO 24373	S Cu 1898A-CuSn1MnSi
	Material No.	2.1006

Typical composition in %

Al < 0,01	Si 0,10 - 0,40	Mn 0,10 - 0,40	Ni < 0,10	Zn -	Sn 0,50 - 1,00
Pb < 0,01	Fe < 0,03	P < 0,015	As -	Cu Remainder	Others total < 0,20

Description

Copper wire for high quality welding. It can be used with both TIG and MIG methods. Its excellent flowability makes it ideal for copper welding. Thanks to the deoxidizer in the weld material the welding is solid and porous-free.

Application Fields

Welding Copper, Electrical applications

Techological characteristics

Tensile Strength Rm	210 - 245 N/mm ²
Elongation A5 (L0=5d0)	- %
Hardness	60 - 80 HB
Harness after work hardening	- HB
Conductivity	15 - 20 m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Schielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuSn6

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu Sn-A
	DIN 1733	MW CuSn6
	BS 2901 Pt3	C11
	En ISO 24373	S Cu 5180A-CuSn6P
	Material No.	2.1022

Typical composition in %

Al < 0,01	Si -	Mn -	Ni -	Zn < 0,10	Sn 4,00 - 7,00
Pb < 0,02	Fe < 0,10	P < 0,01 - 0,40	As -	Cu Remainder	Others total < 0,20

Description

This wire has a high percentage of Sn. It is suitable for both TIG and MIG methods and it is excellent for fixing in artistic foundries. Ideal for surfaces, this material improves the hardness and can also be used for fixing worn surfaces with similar basis metals.

Application Fields

Repair of surfaces

Techological characteristics

Tensile Strength Rm	320 - 360 N/mm ²
Elongation A5 (L0=5d0)	≥ 25 %
Hardness	80 - 90 HB
Hardness after work hardening	130 HB
Conductivity	9 m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Shielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	0,8 1,0 1,2 1,6 2,0 2,4
TIG-Rods [mm]	1,6 2,0 2,4 3,2 4,0

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

TIG carton box of 10kg or 25kg (x 1000 mm length)

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuMn13Al7

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu MnNiAl
	DIN 1733	MW CuMn13Al7
	BS 2901 Pt3	C22
	En ISO 24373	S Cu 6338 – CuMn13Al8Fe3Ni2
	Material No.	2.1367

Typical composition in %

Al 7,0 - 8,5	Si < 0,10	Mn 11,00 - 14,00	Ni 1,50 - 3,00	Zn < 0,15	Sn -
Pb < 0,02	Fe 2,00 - 4,00	P -	As -	Cu Remainder	Others total < 0,50

Description

The alloy MIG WELD MW CuMn13Al7 is a welding wire containing Mn, Ni and Al. This is suitable for joining or fixing cast metals and for welding basis metals with similar compositions. Cladding of unalloyed and low alloyed steels such as C-Mn steels and cast iron, which require bronze diffusion bonding. Coatings with this alloy allow a very high corrosion, erosion and cavitation resistance.

Application Fields

Excellent in marine, power and chemical plants for the production of propellers, pumps and seawater devices.

Techological characteristics

Tensile Strength Rm	800 - 900 N/mm ²
Elongation A5 (L0=5d0)	≥ 10 %
Hardness	180 - 220 HB
Hardness after work hardening	200 - 240 HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Shielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	1,2 1,6
TIG-Rods [mm]	-

Pack size spools

S 300 - 12,5 kg | B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

-

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuAl8Ni2

Rod / Wire electrode from Copper

Standards	AWS A5.7	-
	DIN 1733	MW CuAl8Ni2
	BS 2901 Pt3	C29
	En ISO 24373	S Cu 6327 – Cu Al8Ni2Fe2Mn2
	Material No.	2.0922

Typical composition in %

Al 7,00 - 9,50	Si < 0,20	Mn 0,50 - 2,50	Ni 0,50 - 3,00	Zn < 0,20	Sn -
Pb < 0,02	Fe 0,50 - 2,50	P -	As -	Cu Remainder	Others total < 0,40

Description

An aluminium bronze alloy containing Nickel, Manganese and Iron. Applications include overlaying of steel. It has a good resistance to wear and good corrosion properties against sea-water and chlorides. The high mechanical strenght makes it suitable for welding on Cast Iron. Pre-heating is recommended for large work pieces.

Application Fields

-

Techological characteristics

Tensile Strength Rm	430 - 540 N/mm ²
Elongation A5 (L0=5d0)	30 %
Hardness	130 - 150 HB
Harness after work hardening	- HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Schielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	1,0 1,2 1,6
TIG-Rods [mm]	-

Pack size spools

B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

-

MORE DIAMETERS AND PACKING UPON REQUEST

MW CuAl8Ni6

Rod / Wire electrode from Copper

Standards	AWS A5.7	ER Cu NiAl
	DIN 1733	MW CuAl8Ni6
	BS 2901 Pt3	C26
	En ISO 24373	S Cu 6328 CuAl9Ni5Fe3Mn2
	Material No.	2.0923

Typical composition in %

Al 8,50 - 9,50	Si < 0,10	Mn 0,60 - 3,50	Ni 4,00 - 5,50	Zn < 0,10	Sn -
Pb < 0,02	Fe 3,00 - 5,00	P -	As -	Cu Remainder	Others total < 0,50

Description

A CuAlNi wire for use in welding of Nickel aluminium bronze (Cu Ni Al) components and fittings of similar composition. This weld metal alloy has excellent corrosion and wear resistance characteristics, which promote applications in marine, power and chemical plant components e.g. ships propellers, pumps and sea-water fittings. Surfacing with this alloy on steel or other Copper alloys allow a very high corrosion, erosion and cavitation resistance

Application Fields

Shipbuilding: propellers, pumps, chemical plant components

Techological characteristics

Tensile Strength Rm	450 - 560 N/mm ²
Elongation A5 (L0=5d0)	10 %
Hardness	150 - 170 HB
Harness after work hardening	- HB
Conductivity	- m/Ωmm ²

Technological properties quoted above are approximate values, intended for guidance only. Test temperature 20°C.

Schielding Gas

DIN EN ISO 14175-II | Gas flow rate 14-18 l/min

Available sizes Ø

MIG-wires [mm]	1,0 1,2 1,6
TIG-Rods [mm]	-

Pack size spools

B 300 - 15kg | BS 300 - 15 kg

Pack size Rods

-

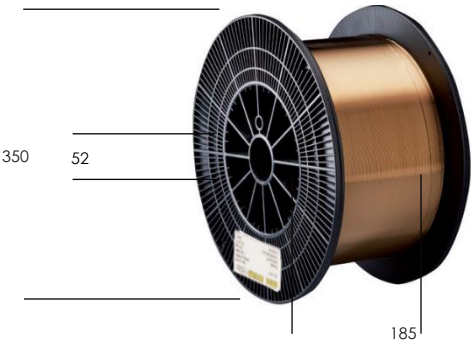
MORE DIAMETERS AND PACKING UPON REQUEST

Spools and Packaging

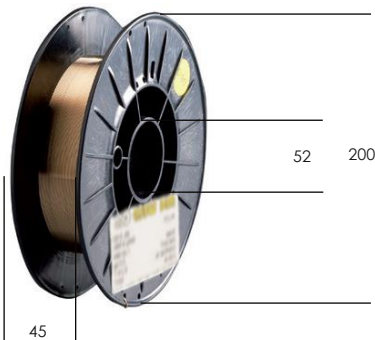
TIG Rods



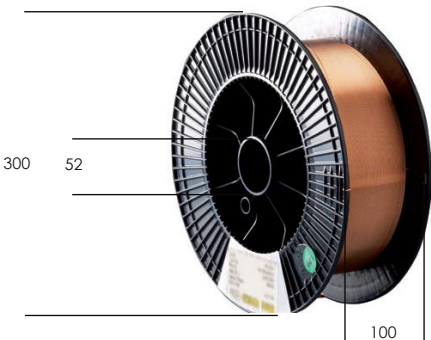
D350 40KG



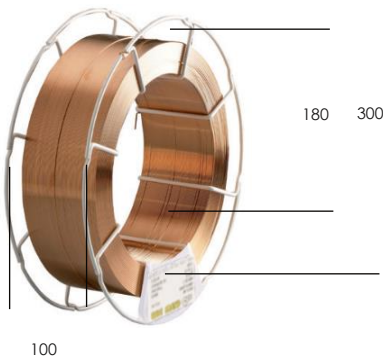
S200 2KG – 5kg



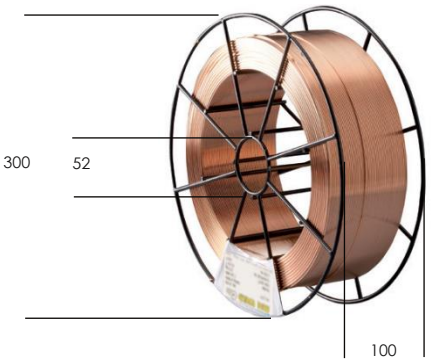
S300 12,5KG – 15KG



B300 12,5KG – 15KG



BS300 12.5KG – 15KG



Bulk Packages

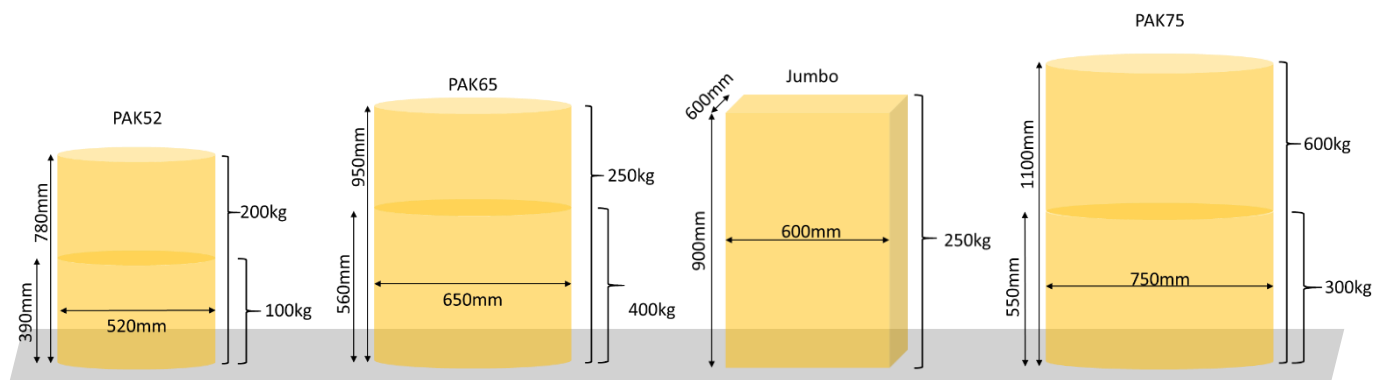
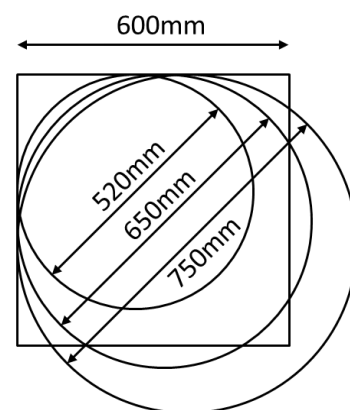
Round drum size



Jumbo Pack



	Diameter / width of drums [mm]	Hight [mm]	Weight [kg]
PAK52	520	390	100
PAK52	520	780	200
Jumbo	600	900	200 – 250
PAK65S	650	560	200 – 250
PAK65M	650	950	400
PAK75L	750	550	300
PAK75XL	750	1100	600



Accessories for bulk packs

Art. No.	Description		Price
9910 0000 03	Plastic hood for MIG WELD "PAK52" Prevents dirt getting into the welding wire and give possibility to connect wire conduit.		On Request
9910 0000 05	Plastic hood for MIG WELD "PAK65" Prevents dirt getting into the welding wire and give possibility to connect wire conduit.		On Request
9910 0000 04	Plastic hood for MIG WELD Jumbo Drum Prevents dirt getting into the welding wire and give possibility to connect wire conduit.		On Request
9910 0000 27	Plastic hood for MIG WELD "PAK75" Prevents dirt getting into the welding wire and give possibility to connect wire conduit.		On Request
9910 0000 01	Lifting device For drums PAK52 to PAK75 up to 500kg.		On Request
9910 0000 61	Wire conduit Greenliner will be delivered per meter including 2 connectors. The big inner diameter allows a low friction feeding of the wire. The used material HDPE owns a low roughness and coefficient of friction and a high abrasion resistance. Minimum order quantity 5m		On Request
9910 0000 60	Wire conduit EC6 The conduit is needed as telescopic piece between drum and wire feeder.		On Request

Accessories to pay of 4XXX Aluminium

Art. No.	Description		Price
9910 0000 08 9910 0000 07 9910 0000 36	Double cone for MIG WELD Jumbo Drum Double cone for das MIG WELD PAK65 Drum Double cone for MIG WELD PAK75 Drum With using the double cone there is no need to use anymore the wooden balls. The dimensions are fitting perfectly to the diameter of the spooled wire. The tie straps are hindering the wire to jump up. The upper side is guiding the wire like normally the inner cone is doing.		On Request
9910 0000 06	Wooden balls diameter 40mm To prevent the wire of coming and forming knots. To be used with the inner cone left inside the drum. 70 balls included in each pack.		On Request
BILLESBOIS55	Wooden balls diameter 55mm To prevent the wire of coming and forming knots. To be used with the inner cone left inside the drum. 70 balls included in each pack.		On Request
9910 0000 24	Wooden balls diameter 40mm <i>(fumigated)</i> To prevent the wire of coming and forming knots. To be used with the inner cone left inside the drum. 70 balls included in each pack.		On Request
BILLESBOIS55TRAITE	Wooden balls diameter 55mm <i>(fumigated)</i> To prevent the wire of coming and forming knots. To be used with the inner cone left inside the drum. 70 balls included in each pack.		On Request

Accessories to pay of 5XXX Aluminium

Art. No.	Description	Price
9910 0000 10	Pay Off System for „PAK52“, Pay Off System for Jumbo-Drum Pay Off System for „PAK65“ Pay Off System for „PAK75“ to decoil 5XXX Aluminium and Copper alloys. It allows a better guidance of the wire and prevents tangling wire	 On Request
9910 0000 15		
9910 0000 14		
9910 0000 26		

Accessories to grant trouble free feeding

Art. No.	Description	Price
9910 0000 17	Wire straightener 2 plans each 7 rollers This item is used, if the installation on site does not allow trouble free feeding. The straighter is usually used for 4XXX, 5XXX and copper alloys. Adapter 9910 0000 54 to be ordered extra Patent Pending E0108768	 On Request
9910 0000 49	Rollers with bearing for wire straightener Ready for application in wire Straightener for Ø1,20mm Aluminium and Copper alloys. Set consisting of 14 rollers	 On Request
9910 0000 28	Mounting plate for straightener For the straighteners with 5 and 7 rollers. Fitting to the hoods mentioned above. <u>Without accessories</u>	 On Request
9910 0000 18	Pay off device <i>For drum MIG WELD PAK52</i> To be mounted inside the hood for drum. This is used to prevent the wire building knots.	 On Request

9910 0000 02

Nylon Einlaufstück

Für Montageplatte 9910 0000 28



Auf Nachfrage

9910 0000 19

Pay off device

For Drum MIG WELD „PAK65“ & Jumbo-Drum

To be mounted inside the hood for drum. This is used to prevent the wire building knots.



On Request

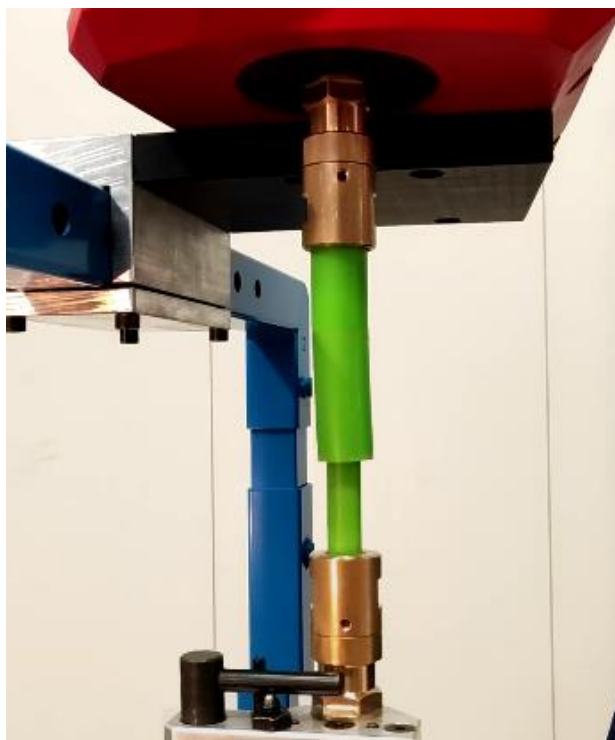
9910 0000 69

Dust cover Wire straightener

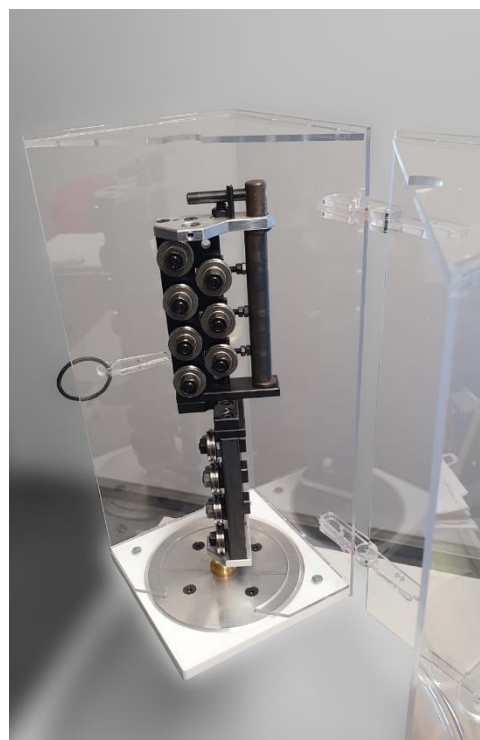
Dust cover for MIG WELD wire straightener



On Request



Example setup for connection between Straightener and wire feeder



Open dust protection for wire Straightener.

Universal connections

Art. No.	Description		Price
9910 0000 55	Connection M20 to EC6 Connector M20 x 2,5 male thread for Fronius feeding device and female self cutting tread for HDPE wire conduit with an OD of 19 mm (9910000060)		On Request
9910 0000 63	Connection M20 to EC4 Connector M20 x 2,5 male thread for Fronius feeding device and female self-cutting tread for HDPE wire conduit with an OD of 12 mm (9910000061)		On Request
9910 0000 56	Connection M14 to EC4 Connector male M14 for wire straightener with M14 female thread at the end plates and female self-cutting thread for OD 12 mm HDPE wire conduit (9910000061)		On Request
9910 0000 64	Connection M14 auf EC6 Connector male M14 for wire straightener and female self-cutting thread for OD 19 mm HDPE wire conduit (9910000060)		On Request
9910 0000 57	Connection M18 to EC4 Connector for mounting plate (9910000028) and female self-cutting thread for OD 12 mm HDPE wire conduit (9910000061)		On Request

Adaptor M14 female to 1/4" male

9910 0000 53

Adapter for female M14 thread and male 1/4" thread to connect Safra wire straightener with female 1/4" thread in the end plates of wire straightener.

You need this adapter to connect them to the adapter with the item no 9910000054 in order to use the old MIG WELD wire straightener type with 1/4" female thread.



On Request

Adaptor M18 male to M14 male

9910 0000 54

Adapter for M14 male thread and male M18 thread to connect mounting plate (9910 0000 28) to Safra wire straightener (9910 0000 17) with M14 thread end plates



On Request

Adaptor 1/4" female to M14 male

9910 0000 65

Adapter for male M14 thread and female 1/4" thread - from that point you can go ahead by the old system by usage of the quick connector item no.: 9910 0000 48, 9910 0000 52, 9910 0000 66

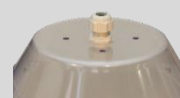


On Request

Connection PG

9910 0000 62

PG Connector ID 9-13 mm for HDPE wire conduit OD 12 mm



On Request



Adapter 9910 0000 54 for new Straightener with M14 thread



Adapten 9910 0000 54 and 9910 0000 53 for old straighteners with 1/4" thread.

Connections for existing installations

Art. No.	Description		Price
9910 0000 50	Connector DN7 Quick connector (Male) DN 7 with female thread 1/4		On Request
9910 0000 51	Merger EC4 Quick connector to join HDPE wire conduits with to ends - only for Ø 12 mm HDPE wire conduits		On Request
9910 0000 52	Quick Coupling DN7 Quick connector (female) DN7 and male thread 1/4"		On Request
9910 0000 66	EC4 Quick connect Quick connector for HDPE Liner with an OD Ø 12 and male thread 1/4"		On Request



Connection to hood for existing installations.



Connection with 9910 0000 51

Tools and spare parts

Art. No.	Description		Price
Insert EC4			
9910 0000 67	Bronze insert for PTFE liner side 12 mm HDPE (as spare part only) for item No.: 9910 0000 56, 9910 0000 57, 9910 0000 63		On Request
Insert EC6			
9910 0000 68	Bronze insert for PTFE liner side 19 mm HDPE (as spare part only) for item No.: 9910 0000 55, 9910 0000 64		On Request
Conduit insert for connectors			
9910 0000 59	PTFE liner for spare wire guide for connectors to be sold as MOQ - 1 mt length OD 5 mm – ID 2 mm (for Item No.: 9910 0000 55, 9910 0000 56, 9910 0000 57, 9910 0000 63, 9910 0000 64)		On Request
Spare swivel arm for Pay Off Systems			
9910 0000 70	Orbital arm as spare part for all MIG WELD wire pay off systems for 5XXX series Aluminium wires by the item no.: 9910 0000 10, 9910 0000 15, 9910 0000 14, 9910 0000 26		On Request
Tools HDPE installations			
9910 0000 58	Deburring and cutting tool kit for HDPE conduit OD 12 und 19 mm		On Request
Spare swivel arm for PAK52			
9910 0000 11	Ersatzdreharm für die Artikelnummer 9910 0000 18		

Connections (old version) for Fronius TPSi

Art. No.	Description		Price
9910 0000 09	Quick connector with ceramic inlet nozzle		On Request
9910 0000 48	Quick Connector A4S G1/4" With G1/4" thread		On Request
9910 0000 42	Quick Connector Fronius A5FRO For Fronius wire feeder		On Request
9910 0000 47	Connector A16F With self cutting thread		On Request
9910 0000 43	Connector A16F6 With self cutting thread for conduit EC6.		On Request
9910 0000 44	Polymer liner insert A4LH For metal free connector transit		On Request

To connect a drum with or without wire straightener. The wire is protected against dust and dirt. Through telescoping the wire drum can be exchanged easily.

A5FRO quick connector Fronius

A16F6 EC-6 Connector

A4LH polymer liner insert

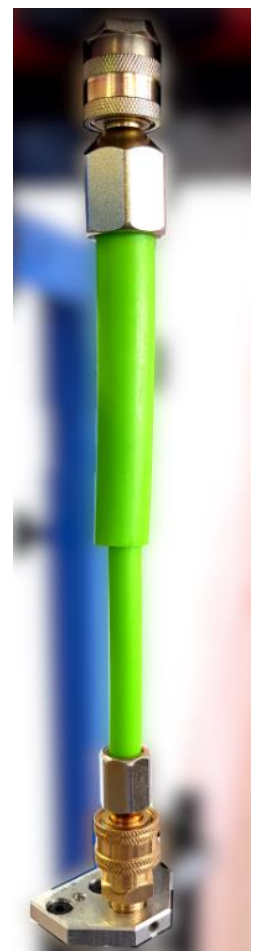
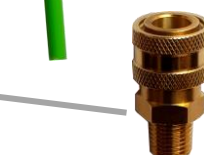
Liner_EC6 conduit

Greenliner conduit EC4

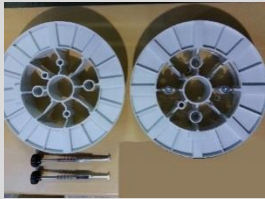
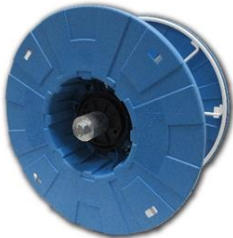
A16F4 EC-4 connector

A4LH polymer liner insert

A4S quick connector



Accessories for big spools

Art. No.	Description		Price
9910 0000 20	Wire feeding device DF40 The wire feeding device DF40 is made to decoil B400-18kg and B400-40kg spools. The internal regulation allows to use the device to be used without synchronizing with the wire feeder of the welding equipment. Through rollers mounted on a balanced beam it is granted that the force to feed the wire is very small, also at higher feeding speeds. The device is heated.		On Request
ADAPTATEUR	Adapter for B400 18kg Spools. Contains 2 half shell, 2 connectors.		On Request
ADAPTATEURB400	Adapter for B400 40kg Spools Contains 2 half shell, 2 prolonged connectors.		On Request
ADAPTPLEXI	Adapter for B400 40kg Spools with Plexiglas cover Contains 2 half shell, 2 prolonged connectors, Plexiglas cover.		On Request
ADAPTCOMPLET	Complete Adapter for B400 40kg Spools Like ADAPTERPLEXI but with shaft for DF40 device.		On Request
9910 0000 37	Spool adapter B400-40kg for B400 Spools (without arbor and brake)		On Request

9910 0000 38

Arbor for spool adapter B400-40kg
With Brakes



On Request

9910 0000 39

Stand to pay off B400 Spools
For simple automation solutions



On Request

Stand and trolley for drums

Art. No.	Description	Price
9910 0000 32	Stand for PAK75 Stand for drums till PAK75	On Request
9910 0000 21	Stand for Jumbo and PAK65 Stand for drums till PAK65	On Request
9910 0000 29	Trolley for Drums till PAK65 Trolley	On Request
9910 0000 33	Trolley for Drums till PAK75 Trolley	On Request
9910 0000 30	Mounting plate for wire feeder Mounting plate for I Fronius WF25 R2 or R4 for 9910 0000 32 und 9910 0000 21	On Request
9910 0000 31	Stand complete for PAK75 Consists of 9910 0000 32 and 9910 0000 33	On Request
9910 0000 34	Stand complete for Jumbo and PAK65 Consists of 9910 0000 21 and 9910 0000 29	On Request

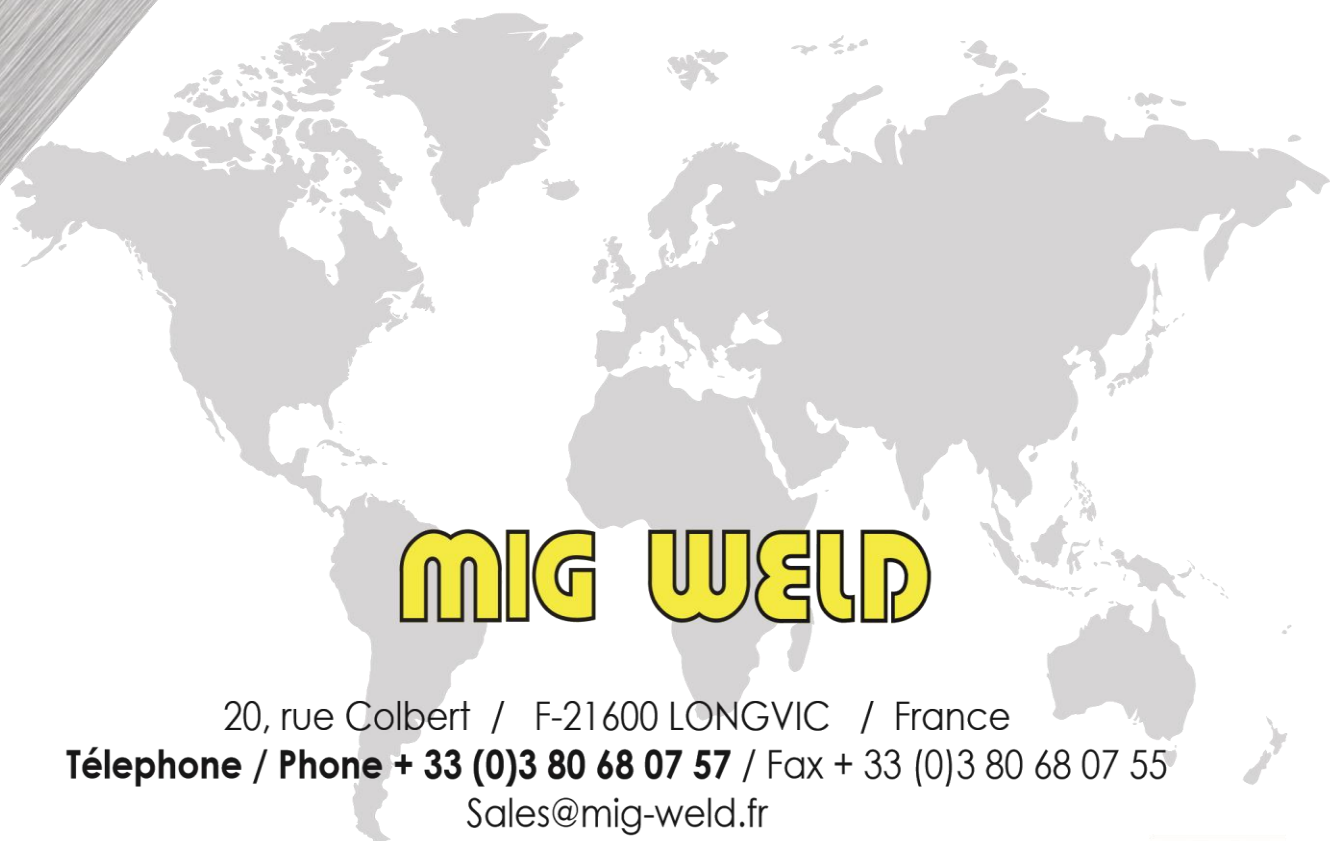
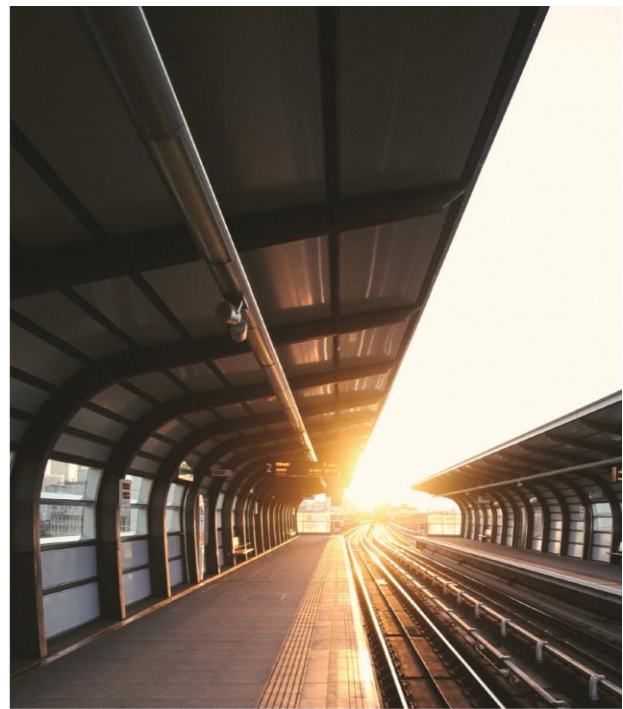
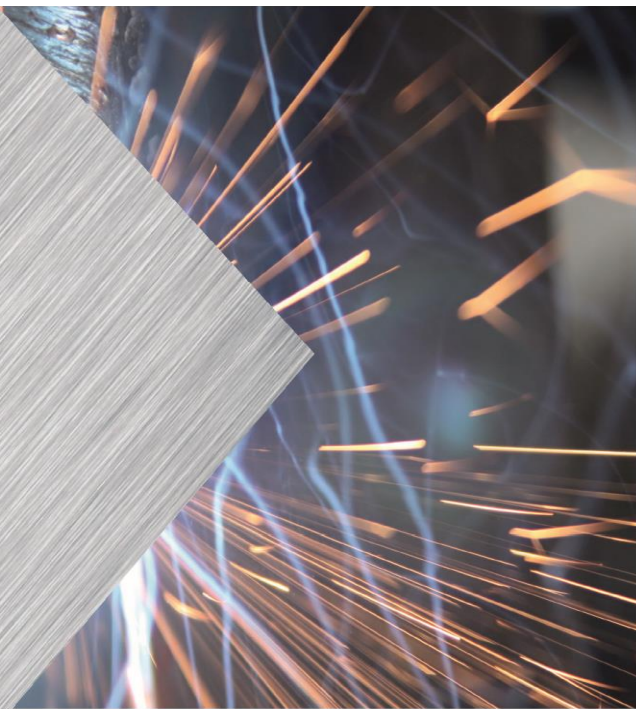
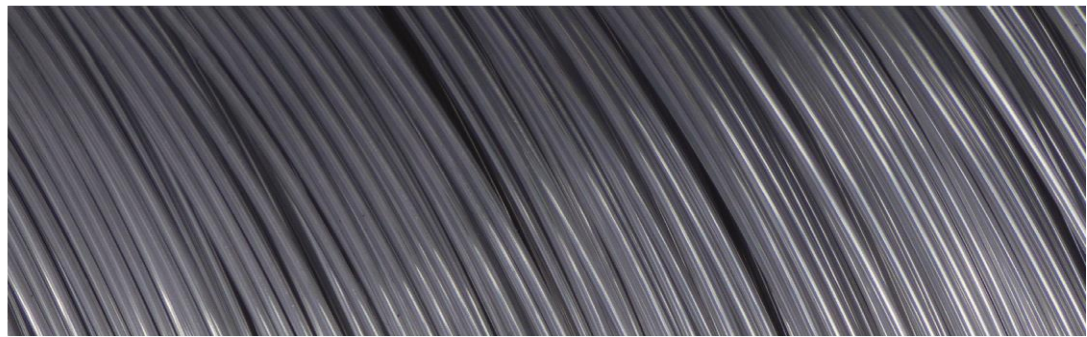


Accessories for feeding 5XXX alloys Ø1,2mm		
Torch	Item No.	Description EN
	9910000063	Connection M20 to EC4
	9910000061	HDPE Wire Conduit EC-4
	9910000063	Connection M20 to EC4
Wire Feeder		
	9910000055	Connection M20 to EC6
	9910000060	HDPE Wire Conduit EC-6
	9910000061	HDPE Wire Conduit EC-4
	9910000056	Connection M14 to EC4
Drum		
	9910000017	Wire Straightener two plan (seven roller each for 5XXX series wire)
	9910000054	Adaptor M18 male to M14 male
	9910000049	One set of rollers with bearing for Aluminium wire Ø 1,20 mm by usage of Safra wire straighteners (14 pcs)
	9910000028	Mounting plate for wire straightener
	9910000002	Inlet mounting plate
	9910000005	Plastic Hood Ø 650 mm (Round)
	9910000014	5XXX Alloys Wire Pay Off System (Ø 650 mm) - Single Cone with Orbital Arm
Stand and Accessories		
	9910000031	Complete drum rack for the drum diameter Ø 520 - 650 mm with trolley
	9910000001	Lifting Yoke up to 500 kg for drum Ø 520 mm - Ø 750 mm

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