

MILD STEEL LOW ALLOY TIG WIRE

ITALFIL ER100S-G TIG Welding Wire

AWS A5.28 ER100S-G, EN ISO 16834 Mn3NiCrMo

ITALFIL ER100S-G is for welding of NiCrMo fine grained steels for low temperature applications.

Chemical Analysis (WT%)

C	Si	Mn	Mo	Cu	Cr	S	P	Ni
0.08	0.75	1.4	0.25	0.25	0.55	0.015	0.015	0.6

Welding Process: TIG Gas: Argon

Part No. Diameter Weight

Part No.	Diameter	Weight
WER2542	1.2 mm	5 Kg
WER2543	1.6 mm	5 Kg
WER2544	2.4 mm	5 Kg
WER2545	3.2 mm	5 Kg



ITALFIL ER110S-G TIG Welding Wire

AWS A5.28 ER110S-G, EN ISO 16834-A-G 69 2 M21 Mn3Ni1CrMo

ITALFIL ER110S-G is a low alloy wire with NiCrMo suitable for single pass or multi-pass welding of low alloy steels.

Chemical Analysis (WT%)

C	Si	Mn	Mo	Cu	Cr	S	P	Ni	V
0.08	0.6	1.6	0.3	0.25	0.3	0.015	0.015	1.5	0.1

Welding Process: TIG Gas: Argon

Part No. Diameter Weight

Part No.	Diameter	Weight
WER2546	1.2 mm	5 Kg
WER2547	1.6 mm	5 Kg
WER2548	2.4 mm	5 Kg
WER2549	3.2 mm	5 Kg



ITALFIL ER120S-G TIG Welding Wire

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

ITALFIL ER120S-G is for the welding of fine grain steels, Austenpering steels giving high yield strength.

Chemical Analysis (WT%)

C	Si	Mn	Mo	Cu	Cr	S	P	Ni	V
0.11	0.7	1.9	0.5	0.25	0.5	0.015	0.015	2.5	0.03

Welding Process: TIG Gas: Argon

Part No. Diameter Weight

Part No.	Diameter	Weight
WER2550	1.2 mm	5 Kg
WER2551	1.6 mm	5 Kg
WER2552	2.4 mm	5 Kg
WER2553	3.2 mm	5 Kg



COPPER/BRONZE TIG WELDING WIRE

WELDTIG C7 Copper TIG Welding Wire

AWS A5.7 ERCu EN ISO 24373 Cu1898 CuSn1

WELDTIG C7 is for welding of copper, producing a deoxidised pure copper deposit.

Chemical Analysis (WT%)

Part No.	Diameter	Weight	Cu	Si	Mn
WER2450	1.6 mm	5 Kg	98	0.1	0.1
WER2451	2.4 mm	5 Kg	Welding Process: TIG		
WER2452	3.2 mm	5 Kg	Gas: Argon		



WELDTIG CuSi3 (C9) TIG Brazing Wire

BS 2901 1990 Pt3 C9 CuSi3

WELDTIG CuSi3 are copper rods containing 3% silicon and 1% Manganese used for welding of materials of similar composition e.g Copper alloys, brass and steel. It is commonly used within the motor industry for welding of Zinc coated steel.

Chemical Analysis (WT%)

Part No.	Diameter	Weight	Cu	Si	Mn
WER1645	1.2 mm	5 Kg	96	3.0	1.0
WER1646	1.6 mm	5 Kg	Welding Process: TIG		
WER1647	2.4 mm	5 Kg	Gas: Argon		
WER1648	3.2 mm	5 Kg			



WELDTIG C11 Phosphor Bronze TIG Welding Wire

AWS A5.7 ERCuSn6P EN ISO 24373 Cu5180

WELDTIG C11 is for welding of phosphor bronze, tin bronze, cast iron, Gunmetal & repairing of cast copper alloys.

Chemical Analysis (WT%)

Part No.	Diameter	Weight	Cu	Sn
WER2453	1.6 mm	5 Kg	93	7
WER2454	2.4 mm	5 Kg	Welding Process: TIG	
WER2455	3.2 mm	5 Kg	Gas: Argon	



WELDTIG C13 Aluminium Bronze TIG Welding Wire

AWS A5.7 ERCuAl-A2 EN ISO 24373 Cu6180 CuAl10Fe

WELDTIG C13 is for joining & repairing of Aluminium bronze castings, giving increased resistance to wear & brazing.

Chemical Analysis (WT%)

Part No.	Diameter	Weight	Cu	Al	Fe
WER2456	1.6 mm	5 Kg	89	10	1
WER2457	2.4 mm	5 Kg	Welding Process: TIG		
WER2458	3.2 mm	5 Kg	Gas: Argon		



WELDTIG 1070 (1050A) Aluminium TIG Welding Rods

AWS A5.10 92 ER1100 EN 18273-S 2004 AL1100



Chemical Analysis (WT%)

Si	Fe	Cu	Mn	Mg	Zn	Ti	Al
0.2	0.25	0.04	0.03	0.03	0.04	0.03	99.7

Parent Metals: Non-heat treatable aluminium in 1000 series. AlMn alloys 3003, 3103, 3105 where the best colour matching after anodising is required.

Welding Process: TIG

Gas: Argon

Anodising: Good

Corrosion Resistance: Good

Part No.	Diameter	Weight
WER1500	1.6 mm	2.5 Kg
WER1502	2.4 mm	2.5 Kg
WER1503	3.2 mm	2.5 Kg

WELDTIG 4043 AISi5 (NG21) Aluminium TIG Welding Rods

AWS A5.10 92 ER4043 EN 18273-S 2004 AL4043

Chemical Analysis (WT%)

Si	Fe	Cu	Zn	Ti	Al
4.5-6	0.8	0.3	0.1	0.2	Bal

Parent Metals: AlMgSi (6000 series) alloys e.g. 6063, 6082 cast alloys of aluminium silicon type

Welding Process: TIG

Gas: Argon

Anodising: Poor

Corrosion Resistance: Good (Depending on parent alloy)

Part No.	Diameter	Weight
WER1510	1.6 mm	2.5 Kg
WER1512	2.4 mm	2.5 Kg
WER1513	3.2 mm	2.5 Kg

WELDTIG 4047 AISi12 Aluminium TIG Rods

AWS A5.10 92 ER4047 EN 18273-S 2004 AL4047

Chemical Analysis (WT%)

Si	Fe	Cu	Mn	Mg	Zn	Al
11-13	0.8	0.3	0.15	0.1	0.2	Bal

Parent Metals: AlMgSi (6000 series) alloys e.g. 6063, 6082 cast alloys of aluminium-silicon type. Not recommended for welding of AlMg Alloys.

Welding Process: TIG

Gas: Argon

Anodising: Poor

Corrosion Resistance: Good (Depending on parent alloy)

Part No.	Diameter	Weight
WER1530	1.6 mm	2.5 Kg
WER1532	2.4 mm	2.5 Kg
WER1533	3.2 mm	2.5 Kg

WELDTIG 5183 AlMg4.5Mn0.7 Aluminium TIG Rods

AWS A5.10 92 ER5183 EN 18273-S 2004 AL5183

Chemical Analysis (WT%)

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al
0.4	0.4	0.1	0.5-1	4.3-5.2	0.05-0.2	0.25	0.15	Bal

Parent Metals: 5000 (AlMg) series alloys and 7000 (AlZn & AlZnMg) series.

Welding Process: TIG

Gas: Argon

Anodising: Fair

Corrosion Resistance: Fair

Part No.	Diameter	Weight
WER1540	1.6 mm	2.5 Kg
WER1542	2.4 mm	2.5 Kg
WER1543	3.2 mm	2.5 Kg

WELDTIG 5356 AlMg5 (NG6) Aluminium TIG Rods

AWS A5.10 92 ER5356 EN 18273-S 2004 AL5356



Chemical Analysis (WT%)

Si	Fe	Cu	Mg	Cr	Zn	Ti	Al
0.25	0.04	0.1	4.5-5.5	0.05-0.2	0.1	0.06-0.2	Bal

Parent Metals: 5000 series alloys (AlMg) with Mg < 4%, 6000 (AlMgSi) alloys when anodised. Cast alloys of AlSi-Mg type. In practice the most versatile & universally used filler metal.

Welding Process: TIG

Gas: Argon

Anodising: Excellent

Corrosion Resistance: Excellent (Very good in marine applications)

Part No.	Diameter	Weight
WER1520	1.6 mm	2.5 Kg
WER1522	2.4 mm	2.5 Kg
WER1523	3.2 mm	2.5 Kg

WELDTIG 5556 AlMg5Mn Aluminium TIG Rods

AWS A5.10 92 ER5556 EN 18273-S 2004 AL5556

Chemical Analysis (WT%)

Si	Fe	Cu	Mn	Mg	Zn	Ti	Al
0.25	0.4	0.1	0.8	5-5.5	0.2	0.05-0.2	Bal

Parent Metals: 5000 (AlMg) series alloy, with high Mg content.

Welding Process: TIG

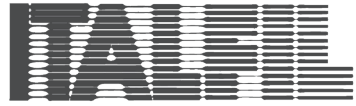
Gas: Argon

Anodising: Good

Corrosion Resistance: Fair

Part No.	Diameter	Weight
WER1550	1.6 mm	2.5 Kg
WER1552	2.4 mm	2.5 Kg
WER1553	3.2 mm	2.5 Kg





HARDFACING TIG RODS

WELDMIG HF350 TIG Rods

DIN 8555 MSG-2-GZ-350

ITALFIL HF350 is a solid copper coated TIG welding wire for the overlay of all Carbon/ Manganese steels. It is suitable for surfacing of parts that are subject to wear and impact. It is also possible to machine and will work harden. Hardness 325 - 375 HRC.



Chemical Analysis (WT%)

C	Si	Mn	Cr	Cu	Mo
0.068	0.55	0.90	6.0	0.25	0.90
Welding Process: TIG					
Gas:		Argon			

Part No.	Diameter	Weight
WER1673	1.6 mm	5 Kg
WER1674	2.4 mm	5 Kg
WER1675	3.2 mm	5 Kg

ITALFIL HF600 TIG Rods

DIN 8555 WSG6-GZ-60

ITALFIL HF600 is a solid copper coated MIG welding wire for the overlay of all Carbon/Manganese steels. It is suitable for surfacing of parts that are subject to wear and impact. It is possible to finish by grinding. Hardness 550 - 600 HRC.



Chemical Analysis (WT%)

C	Si	Mn	Cr
0.45	3.0	0.40	9.30
Welding Process: TIG			
Gas:		Argon	

Part No.	Diameter	Weight
WER1676	1.6 mm	5 Kg
WER1677	2.4 mm	5 Kg
WER1678	3.2 mm	5 Kg



STAINLESS STEEL FLUX CORED TIG RODS

WELDTIG 316L Flux cored Stainless Steel TIG Rods

AWS A5.22 R316L T1-5 EN ISO 6947 ASME IX 1F, 1G, 2F, 2G, 3F, 3G, 4F, 4G, 5Gup

WELDTIG 316L Flux cored stainless TIG rods is for root pass tig welding without the need for backing gas.

- Produces slag to protect the reverse side of the root pass from oxidation by the atmosphere.
- Saves the costs for back shielding gases.
- Eliminate gas purging down time.
- Perfectly suited for stainless steel pipe welding.

Chemical Analysis (WT%)

C	Si	Mn	Cr	Ni	Mo
0.03	0.50	0.90	18.5	12	2.8
Welding Process: TIG					

Thickness (mm)	Gap (mm)	Root Face (mm)	Current (A)
3-5	2	1	80-95
5-10	2.5	1	90-110
10	3	1	105-140

Part No.	Diameter	Weight
WER2318	2.2 mm	1 Kg

*Also available in grades 308L, 309L, 347 to special order



STAINLESS STEEL TIG RODS

Nevinox 307Si Stainless Steel TIG Rods

AWS A5.9 ER307Si BS EN 12072 2000 18.8 Mn

Nevinox 307Si is ideal for the joining of austenitic stainless steel to carbon steels as well as joining wear plates & providing a buffer layer prior to hardfacing. Approvals: CE, TUV



Chemical Analysis (WT%)

C	Si	Mn	Cr	Ni
0.15	0.95	6.5	19.5	9.0
Welding Process: TIG				
Gas:		Argon		

Part No.	Diameter	Weight
WER1600	0.8 mm	5 Kg
WER1601	1.0 mm	5 Kg
WER1602	1.2 mm	5 Kg
WER1603	1.6 mm	5 Kg
WER1604	2.4 mm	5 Kg
WER1605	3.2 mm	5 Kg

Nevinox 308L Stainless Steel TIG Rods

AWS A5.9 ER308L EN 12072 2000 19.9 L

Nevinox 308L is for welding austenitic stainless steel, 304 series and 321 stainless steels. Approvals: CE, TUV



Chemical Analysis (WT%)

C	Si	Mn	Cr	Ni
0.012	0.40	1.9	19.5	10.5
Welding Process: TIG				
Gas:		Argon		

Part No.	Diameter	Weight
WER1606	0.8 mm	5 Kg
WER1607	1.0 mm	5 Kg
WER1608	1.2 mm	5 Kg
WER1609	1.6 mm	5 Kg
WER1610	2.4 mm	5 Kg
WER1611	3.2 mm	5 Kg

Nevinox 309L Stainless Steel TIG Rods

AWS A5.9 ER309L EN 12072 2000 23.12 L

Nevinox 309L is a high alloyed wire. It is for the welding of dissimilar steels e.g stainless steel to mild steel, will give crack resistant welds under normal conditions. Approvals: CE, TUV



Chemical Analysis (WT%)

C	Si	Mn	Cr	Ni
0.02	0.06	1.9	23.5	12.5
Welding Process: TIG				
Gas:		Argon		

Part No.	Diameter	Weight
WER1616	1.0 mm	5 Kg
WER1617	1.2 mm	5 Kg
WER1618	1.6 mm	5 Kg
WER1619	2.4 mm	5 Kg
WER1620	3.2 mm	5 Kg

Nevinox 310 Stainless Steel TIG Rods

AWS A5.9 ER310 EN 12072 2000 25.20

Nevinox 310 is designed to weld high temperature steels up to 1100°C such as 310 grade stainless steel. Approvals: CE, TUV



Chemical Analysis (WT%)

C	Si	Mn	Cr	Ni
0.11	0.45	1.7	25	20
Welding Process: TIG				
Gas:		Argon		

Part No.	Diameter	Weight
WER1621	1.0 mm	5 Kg
WER1622	1.2 mm	5 Kg
WER1623	1.6 mm	5 Kg
WER1624	2.4 mm	5 Kg
WER1625	3.2 mm	5 Kg