## Inox 2 purple

Rod electrode: E 19 9 L R 1 2 EN 1600
Material No.: 1.4316
AWS: A 5.4: E 308 L – 17
Coating: rutil

| dia. in mm | Length in mm | Amp. in A | Weight in kg | **Art. No.** | P. Qty. |
|---|---|---|---|---|---|
| 2.5 | 300 | 50 – 90 | 1.7 | **0982 253** | 90 |
| 3.2 | 350 | 70 – 130 | 2.1 | **0982 325 3** | 55 |

**Properties:**
- Very good weldability.
- Particularly suitable for stainless steel A2.
- Smooth, clean weld texture.
- Good re-ignition.
- Few splash losses.
- Easy slag removal.
- Maximum operating temperature 350°C.

**Welding positions:** 

**Welding instructions:**
The electrode can be welded with direct current +pole and alternating current.

**Applications:**
For welding stainless and heat-resistant steels in vehicle construction, container construction, shipbuilding and apparatus construction.
Material No. 1.4301, 1.4303, 1.4306, 1.4308, 1.4312, 1.4325, 1.4541, 1.4550 also for heat-resistant chromium steels 1.4001, 1.4016, 1.4057.
**Approvals, suitability tests: DB, TÜV.**

## Inox 4 red

Rod electrode: E 19 12 3 L R 1 2 EN 1600
Material No.: 1.4430
AWS: A 5.4: E 3162 – 17
Coating: rutil

| dia. in mm | Length in mm | Amp. in A | Weight in kg | **Art. No.** | P. Qty. |
|---|---|---|---|---|---|
| 2.5 | 300 | 45 – 90 | 1.7 | **0982 254** | 87 |
| 3.2 | 350 | 60 – 125 | 2.0 | **0982 325 4** | 53 |

**Properties:**
- Very good weldability.
- Particularly suitable for stainless steel A4.
- Smooth, clean weld texture.
- Good re-ignition.
- Few splash losses.
- Easy slag removal.
- Maximum operating temperature 400°C.

**Welding positions:** 

**Welding instructions:**
The electrode can be welded with direct current +pole and alternating current.

**Applications:**
For welding stainless and heat-resistant steels in container, steel, vehicle and apparatus construction.
Material No. 1.4301, 1.4308, 1.4311, 1.4312, 1.4401, 1.4404, 1.4410, 1.4435, 1.4541, 1.4550, 1.4571, 1.4580, 1.4583 also suitable for austenitic-ferrite joints.
**Approvals, suitability tests: DB, TÜV.**

## Inox 29.9 yellow

Rod electrode: E 29 9 R 1 2 EN 1600
Material No.: 1.4337
AWS: A 5.4: E 312 – 17
Coating: rutil

| dia. in mm | Length in mm | Amp. in A | Weight in kg | **Art. No.** | P. Qty. |
|---|---|---|---|---|---|
| 3.2 | 350 | 55 – 120 | 1.9 | **0982 325 5** | 55 |

**Properties:**
- Universal electrode with very good welding properties.
- Also suitable for work on stainless steel A4 with St 37.
- Smooth weld texture.
- Few splash losses.
- Easy slag removal.

**Welding positions:** 

**Welding instructions:**
The electrode can be welded with direct current (+pole) and conditionally with alternating current.

**Applications:**
For steels that are difficult to weld, application welds on hot work tools and also rails, rollers and plastic compression moulds. Tough stress equalising intermediate layers on hard application welds. Tough welded joints on higher-strength steels and between different types of materials. Welded joints on austenitic manganese steel.

## Cast 100 black

Rod electrode: EC Ni – C13 EN ISO 1071
AWS: A 5.15

| dia. in mm | Length in mm | Amp. in A | Weight in kg | **Art. No.** | P. Qty. |
|---|---|---|---|---|---|
| 2.5 | 300 | 55 – 110 | 2.0 | **0982 256** | 112 |
| 3.2 | 350 | 80 – 140 | 2.5 | **0982 325 6** | 77 |

**Properties:**
- Good weldability.
- Stable arc.

**Welding positions:** 

**Welding instructions:**
The electrode can be welded with direct current + or –pole and with alternating current.

**Applications:**
Pure nickel electrode for cold welding and semi-cold welding of grey cast iron, repair welds, sealing welding of blowholes and cracks in cast parts, junctions:
The weld metal of this electrode is file-soft, enabling metal to be removed easily and is highly resistant to cracking.

## Comparison of the quality values of the pure weld metal

| Designation | Yield strength in N/mm² | Strength in N/mm² | Elongation $\delta_5$ in % | Notched bar work ISO-VJ |
|---|---|---|---|---|
| Normal green | ≥ 420 | ≥ 500 | ≥ 20 | ≥ 47 |
| Universal blue | ≥ 380 | ≥ 510 | ≥ 22 | ≥ 47 -10°C |
| Special white | ≥ 400 | ≥ 490 | ≥ 22 | ≥ 47 - 20°C |
| Inox 2 purple | ≥ 320 | ≥ 520 | ≥ 33 | ≥ 32 - 60°C |
| Inox 4 red | ≥ 320 | ≥ 520 | ≥ 27 | ≥ 32 - 60°C |
| Inox 29.9 yellow | ≥ 450 | ≥ 660 | ≥ 20 | – |