



Your welding power

WELDING CONSUMABLES
2023 / 2024



Your welding power

AN ITALIAN STORY	2
FOR THE CLIENT	4
PRODUCT FOCUSED	6
PRODUCTS INDEX	8
APPLICATIONS INDEX	14
PRODUCTS	18
PACKAGING	70
GENERAL INFORMATION AND TABLES	90



AN ITALIAN STORY

INE's history reflects over seventy years of Italian industry history. A fully independent company, in a field dominated by multinationals, that produces and supplies a wide range of consumables and equipment for the welding industry.

It is the story of a company that has been able to create a recognised brand, an authoritative voice in the sector, which is committed to providing reliable, high quality products, the fruit of research and innovation.

Thanks to a pioneering spirit and a vision always focused on the future, **INE** has built a flexible and adaptable corporate structure based on its various clients' needs. The company relies on the expertise of specialist technicians and production capabilities of the two sites of Cittadella and Bagnoli, in the heart of Veneto, the Italian manufacturing district.

FOR THE CLIENT

INE's business is not limited to the production and supply of materials and equipment, but is above all a consultancy and guidance operation that supports clients, to respond to every need and technical requirement for welding. In recent years, the company has invested heavily in training its employees, who have received the most prestigious industry certifications.

A commitment that demonstrates **INE's** invested interest in its clients and attention to an increasingly accurate and qualified customer service.



PRODUCT FOCUSED

Attentiveness towards the product and production is an integral part of **INE's** mission, which is committed to supply select raw materials. Supplier steelworks must meet strict requirements in terms of chemical composition and product quality.

Quality control

From selection of materials to the finished product, excellence is at every stage of **INE's** production. Thanks to the research and development department, engineers and technicians design cutting-edge technologies and products, with the aim of meeting every need. The quality control laboratory is the highlight of the entire process. It is equipped with the most modern equipment for the mechanical and chemical characterisation of metal alloys.

During the assembly process, every single welding machine is tested and subjected to a rigorous process of controls, to verify the quality standard of the products.

INE's products have obtained quality certification and approval from major international bodies. Thanks to consolidated experience in this field, **INE** can accompany and support clients in the certification of welding processes, with a dedicated consultancy service.

Manufacturing Execution System

To ensure maximum product reliability, every single coil is subject to a complete traceability system. The Manufacturing Execution System makes available all production information, via traceability of each coil, from the end product to the individual coil.

The MES collects production data via networked wire drawing machines. These data are then analysed to increase the production efficiency and quality of the end product.



PRODUCTS INDEX

CARBON AND LOW ALLOY STEEL	
MIG/MAG SOLID WIRES	20
TIG RODS	30
METAL CORED WIRES	38
FLUX CORED WIRES	40
SELF-SHIELDED FLUX CORED WIRES	42
COATED ELECTRODES	44
SUBMERGED ARC WELDING WIRES AND FLUX	50
STAINLESS STEEL	58
ALUMINIUM ALLOYS	64
CAST IRON	66
HARDFACING	68

PRODUCTS INDEX

MIG/MAG SOLID WIRES

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
CARBON AND HSLA STEELS	INEFIL 13.7	Page 20
	INEFIL	Page 20
	INEFIL 19.12	Page 20
	INEFIL 19.12 NR	Page 20
	INEFIL TITAN 1	Page 20
	INEFIL NR	Page 20
	INEFIL S2	Page 20
	INEFIL CU	Page 20
LOW TEMPERATURE TOUGHNESS STEELS	INEFIL 80 Ni 1	Page 22
	INEFIL 80 Ni 2	Page 22
	INEFIL 80 Ni 3	Page 22
HIGH STRENGTH STEELS	INEFIL 70	Page 24
	INEFIL NIMO	Page 24
	INEFIL NIMOCR	Page 24
	INEFIL 100	Page 24
	INEFIL 110	Page 24
	INEFIL 120	Page 24
	INEFIL 120 S1	Page 24
CREEP RESISTANT STEELS	INEFIL G2MO	Page 26
	INEFIL D2	Page 26
	INEFIL CROMO 1	Page 26
	INEFIL CROMO 2	Page 26
	INEFIL B2	Page 26
	INEFIL B2 L	Page 26
	INEFIL B3	Page 26
	INEFIL B3 L	Page 26
	INEFIL B6	Page 28
	INEFIL B8	Page 28
	INEFIL B9	Page 28
	INEFIL B9LowNi	Page 28

MIG/MAG SOLID WIRES

TIG RODS

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
CARBON AND HSLA STEELS	INETIG	Page 30
	INETIG 13.7	Page 30
	INETIG 19.12	Page 30
	INETIG S2	Page 30
	INEGAS G2	Page 30
OFW	INEGAS G2	Page 30

TIG RODS

TIG RODS

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
LOW TEMPERATURE TOUGHNESS STEELS	INETIG 80 Ni 1	Page 32
	INETIG 80 Ni 2	Page 32
	INETIG 80 Ni 3	Page 32
HIGH STRENGTH STEELS	INETIG 100	Page 32
	INETIG 110	Page 32
	INETIG 120	Page 32
	INETIG 120 S1	Page 32
CREEP RESISTANT STEELS	INETIG G2MO	Page 34
	INETIG D2	Page 34
	INETIG CROMO 1	Page 34
	INETIG CROMO 2	Page 34
	INETIG B2	Page 34
	INETIG B2 L	Page 34
	INETIG B3	Page 34
	INETIG B3 L	Page 34
	INETIG B6	Page 36
	INETIG B8	Page 36
	INETIG B9	Page 36
	INETIG B9LowNi	Page 36

TIG RODS

METAL
CORED WIRES

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
METAL CORED WIRES	INETUB M71TG	Page 38
	INETUB M71TG-CU	Page 38
	INETUB M81TG-Ni1	Page 38
	INETUB M90	Page 38
	INETUB M110	Page 38
	INETUB M81TG-A1	Page 38

METAL
CORED WIRES

FLUX CORED WIRES

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
RUTILE FLUX CORED WIRES	INETUB R71T1	Page 40
	INETUB R81T1-CU	Page 40
	INETUB R81T1-Ni1	Page 40
BASIC FLUX CORED WIRES	INETUB B71T5	Page 40
	INETUB B71T5-A1	Page 40
	INETUB B81T5-B2	Page 40
	INETUB B91T5-B3	Page 40
SELF-SHIELDED FLUX CORED WIRES	INETUB S71T11	Page 42
	INETUB S71TGS	Page 42
	INETUB BA71T11	Page 42
	INETUB BA71TGS	Page 42

FLUX CORED WIRES

PRODUCTS INDEX

COATED ELECTRODES

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
RUTILE ELECTRODES	INE 45	Page 44
	INE 46	Page 44
	INE 47	Page 44
	INE 48A	Page 44
	INE SUPER	Page 44
	INE AR 150	Page 44
	INE VERTICAL	Page 44
BASIC ELECTRODES	INE 50B	Page 46
	INE 55B	Page 46
	INE RB 86	Page 46
	INE 57 B CNC	Page 46
	INE C3	Page 46
	INE 80B	Page 46
	INE A1	Page 48
	INE B2	Page 48
	INE B2 L	Page 48
	INE B3	Page 48
	INE B3 L	Page 48
	INE B6	Page 48
	INE B8	Page 48
	INE B9	Page 48

COATED ELECTRODES

STAINLESS STEEL

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
SOLID WIRES	INEFIL INOX 307 SI	Page 58
	INEFIL INOX 308 LSI	Page 58
	INEFIL INOX 309 LSI	Page 58
	INEFIL INOX 310	Page 58
	INEFIL INOX 312	Page 58
	INEFIL INOX 316 LSI	Page 58
TIG RODS	INETIG INOX 307 SI	Page 60
	INETIG INOX 308 LSI	Page 60
	INETIG INOX 309 LSI	Page 60
	INETIG INOX 316 LSI	Page 60
ELECTRODES	INOX 307	Page 62
	INOX 308 RLC	Page 62
	INOX 309 RLC	Page 62
	INOX 310 R	Page 62
	INOX 312 R	Page 62
	INOX 316 RLC	Page 62

STAINLESS STEEL

SUBMERGED ARC WELDING WIRES AND FLUX

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
CARBON AND HSLA STEELS	INESUB S1	Page 50
	INESUB S2	Page 50
	INESUB S2CU	Page 50
	INESUB S2Si	Page 50
	INESUB S3Si	Page 50
FLUXES FOR CARBON STEELS	INEFLUX MP	Page 50
	INESUB SP	Page 50
LOW ALLOY STEEL	INESUB S2Ni1	Page 52
	INESUB S2Ni2	Page 52
	INESUB S2Ni3	Page 52
	INESUB S3NIMO	Page 52
	INESUB EF3	Page 52
	INESUB S2MO	Page 54
	INESUB EB2	Page 54
	INESUB EB2R	Page 54
	INESUB EB3	Page 54
	INESUB EB3R	Page 54
	INESUB EB8	Page 56
	INESUB EB9	Page 56
	INESUB EB9LowNi	Page 56
FLUXES FOR LOW ALLOY STEELS	INEFLUX BLKV	Page 54
	INESUB BHA	Page 56

SUBMERGED ARC WELDING WIRES AND FLOWS

ALUMINIUM ALLOYS

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
MIG/MAG SOLID WIRES	INEFIL AL5%SI	Page 64
	INEFIL AL5%MG	Page 64
TIG RODS	INETIG AL5%SI	Page 64
	INETIG AL5%MG	Page 64
ELECTRODES	INE AL5%Si	Page 64

ALUMINIUM ALLOYS

CAST IRON

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
ELECTRODES	INE MONEL	Page 66
	INE NICHEL	Page 66
	INE Ni-Fe	Page 66
	INE GHISA	Page 66

CAST IRON

HARDFACING

SECTION DESCRIPTION	PRODUCT DESCRIPTION	
MIG/MAG SOLID WIRES	INEFIL 350	Page 68
	INEFIL 600	Page 68
ELECTRODES	INE RD 600	Page 68
FLUX CORED WIRES FOR HARDFACING	INETUB MHF 600	Page 68

HARDFACING

APPLICATION INDEX

CARBON AND HSLA STEELS	BASIC MATERIAL TYPE		PRODUCTS TYPE										CARBON AND HSLA STEELS	
			GMAW		GTAW		SMAW		FCAW		SAW			
	CARBON STEEL CONVENTIONAL ROLLING EN 10025-2: from S275 to S355K2 EN 10028-2: from P235GH to P355GH		INEFIL S2	Page 20	INETIG S2	Page 30		INE 45	Page 44	INETUB R71T1 - CO2	Page 40	INESUB S1 + INEFLUX MP		Page 50
			INEFIL 13.7	Page 20	INETIG 13.7	Page 30		INE 47	Page 44			INESUB S2 + INEFLUX SP		Page 50
								INE 48A	Page 44			INEFLUX S2Si + INEFLUX SP		Page 50
								INE SUPER	Page 44					
								INE VERTICAL	Page 44					
								INE AR 150	Page 44					
	HSLA CARBON STEEL CONTROLLED ROLLING EN 10025-3: from S275N to S460NL EN 10025-4: from S275M to S460ML EN 10028-3: from P275N to P460NL2 EN 10028-4: from P355M to P460ML2		INEFIL TITAN 1	Page 20	INETIG	Page 30		INE RB 86	Page 46	INETUB R71T1	Page 40	INESUB S2 + INEFLUX MP		Page 50
			INEFIL	Page 20	INETIG 19.12	Page 30		INE 50B	Page 46	INETUB B71T5	Page 40	INESUB S2Si + INEFLUX MP		Page 50
INEFIL NR			Page 20				INE 55B	Page 46	INETUB M71TG	Page 38	INESUB S3Si + INEFLUX MP	Page 50		
INEFIL 19.12			Page 20											
INEFIL 19.12 NR			Page 20											
HIGH STRENGTH STEELS	MECHANICAL CHARACTERISTICS		PRODUCTS TYPE										HIGH STRENGTH STEELS	
	Min. Yield Strength (MPa)	Min. UTS (MPa)	GMAW		GTAW		SMAW		FCAW		SAW			
	460	550	INEFIL 19.12	Page 20	INETIG 19.12	Page 30		INE 55B	Page 46	INETUB M81TG-Ni1	Page 38	INESUB S3Si + INEFLUX MP		Page 50
	500	590	INEFIL D2	Page 26	INETIG D2	Page 34		INE 57 B CNC	Page 46					
	550	640	INEFIL 70	Page 24				INE 57 B CNC	Page 46	INETUB M90	Page 38	INESUB S3NiMo + INEFLUX BLKV		Page 52
	620	700	INEFIL NIMO	Page 24	INETIG 100	Page 32		INE 80B	Page 46					
			INEFIL 100	Page 24										
	690	770	INEFIL NIMOCR	Page 24	INETIG 110	Page 32				INETUB M110	Page 38			
			INEFIL 110	Page 24										
	790	880	INEFIL 120 S1	Page 24	INETIG 120 S1	Page 32								
890	940	INEFIL 120	Page 24	INETIG 120	Page 32									
CREEP RESISTANT STEELS	ALLOY TYPE		PRODUCTS TYPE										CREEP RESISTANT STEELS	
			GMAW		GTAW		SMAW		FCAW		SAW			
	1/2Mo		INEFIL G2MO	Page 26	INETIG G2MO	Page 34		INE A1	Page 48	INETUB M81TG-A1	Page 38	INESUB S2MO + INEFLUX BLKV		Page 54
			INEFIL D2	Page 26	INETIG D2	Page 34			INETUB B71T5-A1	Page 40				
	1-1/4Cr - 1/2Mo P11 / 10 CrMo 5-5		INEFIL B2	Page 26	INETIG B2	Page 34		INE B2	Page 48	INETUB B81T5-B2	Page 40	INESUB EB2R + INEFLUX BLKV		Page 54
			INEFIL B2L	Page 26	INETIG B2L	Page 34		INE B2L	Page 48					
			INEFIL CROMO 1	Page 26	INETIG CROMO 1	Page 34								
	2-1/4Cr - 1Mo (P22 / 10 CrMo 9-10)		INEFIL B3	Page 26	INETIG B3	Page 34		INE B3	Page 48	INETUB B91T5-B3	Page 40	INESUB EB3R + INEFLUX BLKV		Page 54
			INEFIL B3L	Page 26	INETIG B3L	Page 34		INE B3L	Page 48					
			INEFIL CROMO 2	Page 26	INETIG CROMO 2	Page 34								
5Cr - 1/2Mo		INEFIL B6	Page 28	INETIG B6	Page 36		INE B6	Page 48			INESUB EB6 + INEFLUX BHA	Page 56		
9Cr - 1Mo (P9 / X12 CrMo 9-1)		INEFIL B8	Page 28	INETIG B8	Page 36		INE B8	Page 48			INESUB EB8 + INEFLUX BHA	Page 56		
9Cr - 1 Mo, Nb and V mod. (P91 / X10 CrMoVNb 9-1)		INEFIL B9	Page 28	INETIG B9	Page 36		INE B9	Page 48			INESUB EB9 + INEFLUX BHA	Page 56		
		INEFIL B9 Low-Ni	Page 28	INETIG B9 Low-Ni	Page 36									
LOW TEMPERATURE TOUGHNESS STEELS	CVN IMPACT TOUGHNESS > 47J		PRODUCTS TYPE										LOW TEMPERATURE TOUGHNESS STEELS	
			GMAW		GTAW		SMAW		FCAW		SAW			
	-40°C		INEFIL 19.12	Page 20	INETIG 19.12	Page 30		INE C3	Page 46	INETUB R81T1-Ni1	Page 40	INESUB S3Si + INEFLUX BLKV		Page 50
			INEFIL 19.12 NR	Page 20										
	-50°C, (S460ML, P460ML2)		INEFIL 80 Ni1	Page 22	INETIG 80 Ni1	Page 32				INETUB M81TG-Ni1	Page 38	INESUB S2Ni1 + INEFLUX BLKV		Page 52
	-60°C, (11MnNi5-3, 13MnNi6-3, S460QL1)		INEFIL 80 Ni2	Page 22	INETIG 80 Ni2	Page 32						INESUB S2Ni2 + INEFLUX BLKV		Page 52
	-80°C, (15NiMn6)		INEFIL 80 Ni3	Page 22	INETIG 80 Ni3	Page 32						INESUB S2Ni3 + INEFLUX BLKV		Page 52

APPLICATIONS INDEX

MATERIALS FOR HARDFACING

		WELDING PROCESS	CLASSIFICATION	HADRNESS	STRENGTHS	MICRO-STRUCTURE	TYPICAL APPLICATIONS
INEFIL 350	Page 68	GMAW - MAG 135 (gas M21)	EN 14700: S Fe6 - 350(40)	350 HB 40 HRC	Friction- Impact - High tempera- tures	martensitic + carbides	Roller table, mould, jaw crusher, tiller roller, ploughshare
INEFIL 600	Page 68	GMAW - MAG 135 (gas M21)	EN 14700: S Fe8 - 600(60)	600 HB 60 HRC	Friction - Impact	martensitic + carbides	Roller table, mould, jaw crusher, tiller roller, ploughshare, hammers for crushers
INETUB MHF 600	Page 68	FCAW - MAG 135 (gas M21)	EN 14700: T Fe8 - 600(60)	600 HB 60 HRC	Impact - Friction	martensitic + carbides	Roller table, mould, jaw crusher, tiller roller, ploughshare, hammers for crushers
INE RD 600	Page 68	SMAW - MMA 111	EN 14700: E Fe4 - 600(60)	600 HB 60 HRC	Friction - High temperatures	martensitic + carbides	Cutting blade, punch

MATERIALS FOR HARDFACING

STAINLESS STEEL

ALLOY TYPE	PRODUCTS TYPE		GMAW		GTAW	SMAW	
304/304L	INEFIL INOX 308 LSI	Page 58			INETIG INOX 308 LSI	INOX 308 RLC	Page 62
309	INEFIL INOX 309 LSI	Page 58			INETIG INOX 309 LSI	INOX 309 RLC	Page 62
310	INEFIL INOX 310	Page 58				INOX 310 R	Page 62
316 / 316L	INEFIL INOX 316 LSI	Page 58			INETIG INOX 316 LSI	INOX 316 RLC	Page 62
WeldAll	INEFIL INOX 307 SI	Page 58			INETIG INOX 307 SI	INOX 312 R	Page 62
	INEFIL INOX 312	Page 58					
Hadfield (13%Mn)	INETIG INOX 307 SI	Page 58			INETIG INOX 307 SI	INOX 307	Page 62

STAINLESS STEEL

ALUMINIUM ALLOYS

2 ND ALLOY TO WELD		5052, 5454		5182, 5754		6005, 6061, 6063, 6082, 6116, 6463		6009, 6010, 6111, 6016, 6022		Al-Si casting		Al-Mg casting	
1 ND ALLOY TO WELD	7003, 7004, 7005			INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64					INEFIL AL5%MG	Page 64
				INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64					INETIG AL5%MG	Page 64
	Al-Mg casting	INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64			INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64
		INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64			INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64
	Al-Si casting	INEFIL AL5%SI	Page 64			INEFIL AL5%SI	Page 64	INEFIL AL5%SI	Page 64	INEFIL AL5%SI	Page 64		
		INETIG AL5%SI	Page 64			INETIG AL5%SI	Page 64	INETIG AL5%SI	Page 64	INETIG AL5%SI	Page 64		
		INE AL5%SI	Page 64			INE AL5%SI	Page 64	INE AL5%SI	Page 64	INE AL5%SI	Page 64		
	6009, 6010, 6111, 6016, 6022			INEFIL AL5%MG	Page 64	INEFIL AL5%SI	Page 64	INEFIL AL5%SI	Page 64				
				INETIG AL5%MG	Page 64	INETIG AL5%SI	Page 64	INETIG AL5%SI	Page 64				
						INE AL5%SI	Page 64	INE AL5%SI	Page 64				
	6005, 6061, 6063, 6082, 6116, 6463	INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64						
		INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64						
		INEFIL AL5%SI	Page 64										
		INETIG AL5%SI	Page 64										
		INE AL5%SI	Page 64										
	5182, 5754	INEFIL AL5%MG	Page 64	INEFIL AL5%MG	Page 64								
		INETIG AL5%MG	Page 64	INETIG AL5%MG	Page 64								
	5052, 5454	INEFIL AL5%MG	Page 64										
		INETIG AL5%MG	Page 64										

ALUMINIUM ALLOYS*

(*) Row type aluminium alloy 1 / Column type aluminium alloy 2

PRODUCTS

PRODUCTS
MIG/MAG SOLID WIRES



Scan the QR code
to download the technical
data sheet of the product.



CARBON AND HSLA STEELS

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS		
						YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*				
INEFIL 13.7	Solid wire for carbon steel S235/S275/S355. Indicated for single pass and multipass in general carpentry.	AWS A5.18: ER70S-3 EN ISO 14341-A: G 42 2 M21 2Si EN ISO 14341-A: G 38 2 C1 2Si	INEFIL 13.7	C 0.07 Si 0.60 Mn 1.20	C1	400	490	26	R.T. 100J 0°C 70 J -20°C 50 J				
				M21	420	530	28	R.T. 130J 0°C 90 J -20°C 70 J					
INEFIL	Solid wire SG2 for carbon steel and HSLA steel S355/S420. Top quality materials chosen. Reduced spray. Controlled silicate islands.	AWS A5.18: ER70S-6 EN ISO 14341-A: G 46 4 M21 3Si1 EN ISO 14341-A: G 42 4 M21 3Si1 EN ISO 14341-A: G 42 2 C1 3Si1		INEFIL	C 0.07 Si 0.80 Mn 1.40	C1	440	530	26	-20°C 70 J -30°C 50 J		TÜV DB ABS DNV RINA LR CWB	
					M21	470	560	26	-20°C 90 J -30°C 70 J -40°C 60 J				
						480	580	28	-20°C 80 J -30°C 60 J				
INEFIL NR	Copper free solid wire SG2 for carbon steel and HSLA steel S355/S420/S460. Fully-mechanised and robotic applications with high parameters.	AWS A5.18: ER70S-6 EN ISO 14341-A: G 46 4 M21 3Si1 EN ISO 14341-A: G 42 4 M21 3Si1 EN ISO 14341-A: G 42 2 C1 3Si1		INEFIL NR	C 0.07 Si 0.80 Mn 1.40	C1	440	530	26	-20°C 70 J -30°C 50 J		TÜV DB ABS DNV RINA LR	
					M21	470	560	26	-20°C 90 J -30°C 70 J -40°C 60 J				
INEFIL 19.12	Solid wire SG3 for carbon steel and HSLA steel S355/ S420/S460. Top quality materials chosen. Reduced spray. Controlled silicate islands.	AWS A5.18: ER70S-6 EN ISO 14341-A: G 46 4 M21 4Si1 EN ISO 14341-A: G 42 2 C1 4Si1		INEFIL 19.12	C 0.08 Si 0.90 Mn 1.70	C1	450	550	27	-20°C 70 J -30°C 60 J		TÜV DB RINA DNV ABS CWB	
					M21	510	580	26	-20°C 100 J -30°C 80 J -40°C 70 J				
INEFIL 19.12 NR	Copper free solid wire SG3 for carbon steel and microalloyed steel S355/S420/S460. Fully-mechanised and robotic applications with high parameters.	AWS A5.18: ER70S-6 EN ISO 14341-A: G 46 4 M21 4Si1 EN ISO 14341-A: G 42 2 C1 4Si1		INEFIL 19.12 NR	C 0.08 Si 0.90 Mn 1.70	C1	450	550	27	-20°C 70 J -30°C 60 J		TÜV DB RINA DNV ABS	
					M21	510	580	26	-20°C 100 J -30°C 80 J -40°C 70 J				
INEFIL TITAN 1 GALVANISED STEEL	Solid wire in copper free and bronze version for welding galvanised sheet metal. Stable arc without spray.	AWS A5.18: ER70S-G EN ISO 14341-A: G 42 2 M21 Z		INEFIL TITAN 1		M21	440	520	28	-20°C 70 J			
INEFIL S2	Solid wire for carbon steel S235/S275/ S355. The addition of deoxidizers Ti and Zr enable optimal welding in difficult conditions.	AWS A5.18: ER70S-2 EN ISO 14341-A: G 42 2 M21 2Ti EN ISO 14341-A: G 38 2 C1 2Ti		INEFIL S2	C 0.06 Si 0.50 Mn 1.10 Ti 0.10 Zr 0.09 Al 0.10	C1	400	490	27	-20°C 60 J -30°C 50 J			
					M21	440	520	28	-20°C 70 J -30°C 60 J				
INEFIL CU CORTEN	Ni-Cr-Cu Solid wire for weathering steels (CORTEN/S355J2W).	AWS A5.28: ER80S-G EN ISO 14341-A: G 50 4 M21 Z (EN ISO 16834-A: G Mn3Ni1Cu)	INEFIL CU	C 0.08 Si 0.75 Mn 1.40 Ni 0.70 Cr 0.30 Cu 0.40	M21	530	620	26	-20°C 90 J -40°C 70 J -50°C 50 J		TÜV DB		

CARBON AND HSLA STEELS

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
MIG/MAG SOLID WIRES



Scan the QR code
to download the technical
data sheet of the product.



LOW TEMPERATURE TOUGHNESS STEELS

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					GAS	YS (MPa)*	UTS (MPa)*	El. (%)*		
INEFIL 80 Ni 1	Solid wire 1% Ni for fine grain steel (S460ML) with optimum toughness up to -50°C. Offshore platforms, gas transport.	AWS A5.28: ER80S-Ni1 EN ISO 14341-A: G 46 5 M21 3Ni1	INEFIL 80 Ni 1 INEFIL 80 Ni 2 INEFIL 80 Ni 3	C 0.10 Si 0.60 Mn 1.10 Ni 1.00	M21	490	570	25	-20°C 130 J -40°C 80 J -50°C 60 J	

PRODUCTS
MIG/MAG SOLID WIRES



Scan the QR code
to download the technical
data sheet of the product.



HIGH STRENGTH STEEL

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INEFIL 70	Solid wire for high strength steel with UTS ≥ 640 MPa. Use on earth moving machinery, lifting systems, heavy frames.	AWS A5.28: ER90S-G AWS A5.28: ER100S-G EN ISO 16834-A: G 55 3 M21 Mn3NiCrMo EN ISO 16834-A: G 62 4 M13 Mn3NiCrMo	C 0.08 Si 0.70 Mn 1.40 Cr 0.60 Mo 0.20 Ni 0.60	M21 M13	600 640	680 720	19 20	-20°C 90 J -30°C 70 J -20°C 90 J -30°C 80 J -40°C 70 J		CE UK CA
INEFIL NIMO	Solid wire for high strength steel with UTS ≥ 700 MPa. Use on earth moving machinery, lifting systems, heavy frames.	AWS A5.28: ER100S-G EN ISO 16834-A: G 62 4 M21 Mn3Ni1Mo	C 0.08 Si 0.70 Mn 1.50 Cr 0.10 Mo 0.40 Ni 1.10	M21	680	750	20	-20°C 90 J -30°C 70 J -40°C 60 J		TÜV CE UK CA
INEFIL NIMOCR	Solid wire for high strength steel with UTS ≥ 770 MPa (HY100, S690QL) Optimum toughness up to -50°C. Welding of high strength components.	AWS A5.28: ER110S-G EN ISO 16834-A: G 69 4 M21 Mn3Ni1CrMo EN ISO 16834-A: G 69 5 M13 Mn3Ni1CrMo	C 0.08 Si 0.50 Mn 1.60 Cr 0.30 Mo 0.25 Ni 1.50 V 0.09	M21 M13	750 790	820 840	19 20	-20°C 90 J -40°C 60 J -20°C 100 J -40°C 80 J -50°C 60 J		TÜV DB ABS CE UK CA
INEFIL 100	Solid wire for high strength steel with UTS ≥ 700 MPa (HY90, S620QL). Optimum toughness up to -50°C. Fabrication of high strength components.	AWS A5.28: ER100S-1 EN ISO 16834-A: G 62 5 M13 Mn3Ni1,5Mo	C 0.07 Si 0.50 Mn 1.50 Cr 0.10 Mo 0.30 Ni 1.60	M13	660	760	20	-20°C 140 J -40°C 90 J -50°C 70 J		CE UK CA
INEFIL 110	Copper free, solid wire for high strength steel with UTS ≥ 770 MPa (HY100, S690QL). Optimum toughness up to -50°C. Fabrication of high strength components.	AWS A5.28: ER110S-1 EN ISO 16834-A: G 69 5 M13 Mn3Ni2,5CrMo	C 0.06 Si 0.40 Mn 1.60 Cr 0.30 Mo 0.40 Ni 2.50	M13	730	800	18	-20°C 140 J -40°C 40 J -50°C 70 J		
INEFIL 120	Solid wire for high strength steel with UTS ≥ 940 (S890QL) MPa (S620QL). Fabrication of high strength components.	AWS A5.28: ER120S-G EN ISO 16834-A: G 89 4 M21 Mn4Ni2CrMo	C 0.09 Si 0.80 Mn 1.90 Cr 0.40 Mo 0.50 Ni 2.15	M21	890	940	16	-30°C 100 J -40°C 90 J		TÜV DB CE UK CA
INEFIL 120 S1	Copper free, solid wire for high strength steel with UTS ≥ 880 MPa (A514, A517). Excellent toughness up to -60°C. Fabrication of high strength components.	AWS A5.28: ER120S-1 EN ISO 16834-A: G 79 6 M13 Mn4Ni2Mo	C 0.08 Si 0.50 Mn 1.70 Cr 0.10 Mo 0.50 Ni 2.30	M13	790	890	16	-50°C 100 J -60°C 80 J		

HIGH STRENGTH STEEL

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
MIG/MAG SOLID WIRES



Scan the QR code
to download the technical
data sheet of the product.



CREEP RESISTANT STEEL (Cr-Mo STEEL)

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INEFIL G2MO <i>1/2 Mo</i>	Solid wire for creep resistant steel 0.5Mo. Pipes and superheaters up to 450°C (A204 Gr.A,B,C).	AWS A5.28: ER70S-A1 EN ISO 14341-A: G 46 2 M21 2Mo EN ISO 21952-A: G MoSi	C 0.09 Si 0.60 Mn 1.20 Mo 0.50	M21	500	620	23	R.T. 150J 0°C 130 J -20°C 90 J		TÜV DB CE UK CA
INEFIL D2 <i>HARDOX</i>	Solid wire 0.5Mo. Resistance to hot cracking due to higher Mn. Ideal for welding Hardox 400 and 450 type steel.	AWS A5.28: ER80S-D2 AWS A5.28: ER90S-D2 EN ISO 14341-A: G 50 5 M21 4Mo	C 0.08 Si 0.70 Mn 1.80 Mo 0.50	M21	560	650	22	0°C 120 J -40°C 75 J -50°C 60 J		TÜV CE UK CA
INEFIL CROMO 1 <i>1-1/4Cr - 1/2Mo HIGH Mn</i>	Solid wire for creep resistant steel 1.25Cr – 0.5Mo (P11). Resistance to hot cracking due to higher Mn. Hot piping up to 500°C.	AWS A5.28: ER80S-G EN ISO 21952-A: G CrMo1Si	C 0.10 Si 0.60 Mn 1.10 Cr 1.20 Mo 0.50	M21	460 (T)	570 (T)	23 (T)	R.T. 150 J (T)		TÜV DB CE UK CA
INEFIL CROMO 2 <i>2-1/4Cr - 1Mo HIGH Mn</i>	Solid wire for creep resistant steel 2.5Cr – 1Mo (P22). Resistance to hot cracking due to higher Mn. Petrochemical with operation up to 600°C.	AWS A5.28: ER90S-G EN ISO 21952-A: G CrMo2Si	C 0.09 Si 0.60 Mn 1.00 Cr 2.60 Mo 1.00	M21	540 (T)	650 (T)	23 (T)	R.T. 170 J (T)		TÜV CE UK CA
INEFIL B2 <i>1-1/4Cr - 1/2Mo</i>	Solid wire for creep resistant steel 1.25Cr – 0.5Mo (P11). Heat exchangers, boilers, piping operating up to 550°C.	AWS A5.28: ER80S-B2 EN ISO 21952-B: G 55 M22 1CM	C 0.08 Si 0.60 Mn 0.60 Cr 1.30 Mo 0.50	M22	480 (T)	570 (T)	21 (T)	R.T. 150 J (T)		TÜV CE UK CA
INEFIL B2 L <i>1-1/4Cr - 1/2Mo LOW CARBON</i>	Low carbon solid wire for creep resistant steel 1.25Cr–0.5Mo. C max 0.05% allows a reduction in pre-heatings on smaller thicknesses (tubes).	AWS A5.28: ER70S-B2L EN ISO 21952-B: G 52 M22 1CML	C 0.03 Si 0.60 Mn 0.60 Cr 1.30 Mo 0.50	M22	420 (T)	530 (T)	23 (T)	R.T. 150 J (T)		
INEFIL B3 <i>2-1/4Cr - 1Mo</i>	Solid wire for creep resistant steel 2.25Cr – 1Mo (P22). Petrochemical with operation up to 600°C.	AWS A5.28: ER90S-B3 EN ISO 21952-B: G 62 M22 2C1M	C 0.08 Si 0.60 Mn 0.60 Cr 2.50 Mo 1.00	M22	560 (T)	650 (T)	20 (T)	R.T. 170 J (T)		TÜV CE UK CA
INEFIL B3 L <i>2-1/4Cr - 1Mo LOW CARBON</i>	Low carbon solid wire for creep resistant steel 2.25Cr – 1Mo (P22). C max 0.05% allows a reduction in pre-heatings on smaller thicknesses (tubes).	AWS A5.28: ER80S-B3L EN ISO 21952-B: G 55 M22 2C1ML	C 0.03 Si 0.60 Mn 0.60 Cr 2.50 Mo 1.00	M22	490 (T)	580 (T)	22 (T)	R.T. 170 J (T)		

CREEP RESISTANT STEEL (Cr-Mo STEEL)

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS

MIG/MAG SOLID WIRES



Scan the QR code
to download the technical
data sheet of the product.



PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
						YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INEFIL B6 <i>5Cr - 1/2Mo</i>	Solid wire for creep resistant steel 5Cr–0.5Mo (12 CrMo 19-5). Used to repair moulds with similar composition.	AWS A5.28: ER80S-B6 EN ISO 21952-A: G CrMo5Si	INEFIL B6 INEFIL B8 INEFIL B9 INEFIL B9LowNi	C 0.07 Si 0.40 Mn 0.50 Cr 5.80 Mo 0.55	M22	500 (T)	620 (T)	22 (T)	R.T. 70 J (T)		

CARBON AND HSLA STEELS

CARBON AND HSLA STEELS



OFW

30 Welding consumables



Scan the QR code
to download the technical
data sheet of the product.



	PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS	
							YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*			
LOW TEMPERATURE TOUGHNESS STEELS	INETIG 80 Ni 1	TIG rod 1%Ni for root pass of fine grain steel (S460ML). Optimum toughness up to -50°C. Offshore platforms, gas transport.	AWS A5.28: ER80S-Ni1 EN ISO 636-A: W 46 5 3Ni1	INETIG 80 Ni 1	C 0.10 Si 0.60 Mn 1.10 Ni 1.00	I1	510	600	26	-20°C 130 J -40°C 80 J -50°C 70 J			



Scan the QR code
to download the technical
data sheet of the product.



CREEP RESISTANT STEEL (Cr-Mo STEEL)

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INETIG G2MO <i>1/2 Mo</i>	TIG rod for creep resistant steel 0.5Mo. Piping and superheaters up to 450°C.	AWS A5.28: ER70S-A1 EN ISO 636-A: W 46 2 2Mo EN ISO 21952-A: W MoSi	C 0.09 Si 0.60 Mn 1.20 Mo 0.50	I1	520	630	23	R.T. 200J -20°C 80 J		TÜV DB
INETIG D2 <i>HARDOX</i>	TIG rod 0.5Mo. Resistance to hot cracking due to higher Mn. Ideal for welding Hardox 400 and 450 type steel.	AWS A5.28: ER80S-D2 AWS A5.28: ER90S-D2 EN ISO 636-B: W 57A 5 4M31	C 0.08 Si 0.70 Mn 1.90 Mo 0.50	I1	610	700	24	-40°C 40 J -50°C 35 J		
INETIG CROMO 1 <i>1-1/4Cr - 1/2Mo HIGH Mn</i>	TIG rod for creep resistant steel 1.25Cr–0.5Mo (P11). Resistance to hot cracking due to higher Mn. Hot piping up to 500°C.	AWS A5.28: ER80S-G EN ISO 21952-A: W CrMo1Si	C 0.10 Si 0.60 Mn 1.10 Cr 1.20 Mo 0.50	I1	490 (T)	590 (T)	26 (T)	R.T. 250 J (T)		TÜV DB
INETIG CROMO 2 <i>2-1/4Cr - 1Mo HIGH Mn</i>	TIG rod for creep resistant steel 2.5Cr–1Mo (P22). Resistance to hot cracking due to higher Mn. Petrochemical with operation up to 600°C.	AWS A5.28: ER90S-G EN ISO 21952-A: W CrMo2Si	C 0.10 Si 0.60 Mn 1.10 Cr 2.40 Mo 0.95	I1	500 (T)	610 (T)	23 (T)	R.T. 200 J (T)		TÜV
INETIG B2 <i>1-1/4Cr - 1/2Mo</i>	TIG rod for creep resistant steel 1.25Cr–0.5Mo (P11). Heat exchangers, boilers, piping operating up to 550°C.	AWS A5.28: ER80S-B2 EN ISO 21952-B: W 55 I1 1CM	C 0.08 Si 0.60 Mn 0.60 Cr 1.30 Mo 0.50	I1	490 (T)	590 (T)	25 (T)	R.T. 250 J (T)		TÜV
INETIG B2 L <i>1-1/4Cr - 1/2Mo LOW CARBON</i>	Low carbon TIG rod for creep resistant steel 1.25Cr–0.5Mo. C max 0.05% allows a reduction in pre-heatings on smaller thicknesses (tubes).	AWS A5.28: ER70S-B2L EN ISO 21952-B: W 52 I1 1CML	C 0.03 Si 0.60 Mn 0.60 Cr 1.30 Mo 0.50	I1	450 (T)	560 (T)	23 (T)	R.T. 250 J (T)		
INETIG B3 <i>2-1/4Cr - 1Mo</i>	TIG rod for creep resistant steel 2.25Cr–1Mo (P22). Petrochemical with operation up to 600°C.	AWS A5.28: ER90S-B3 EN ISO 21952-B: W 62 I1 2C1M	C 0.08 Si 0.60 Mn 0.60 Cr 2.50 Mo 1.00	I1	570 (T)	650 (T)	22 (T)	R.T. 230 J (T)		TÜV
INETIG B3 L <i>2-1/4Cr - 1Mo LOW CARBON</i>	Low carbon TIG rod for creep resistant steel 2.25Cr–1Mo (P22). C max 0.05% allows a reduction in pre-heatings on smaller thicknesses (tubes).	AWS A5.28: ER80S-B3L EN ISO 21952-B: W 55 I1 2C1ML	C 0.03 Si 0.60 Mn 0.60 Cr 2.50 Mo 1.00	I1	510 (T)	600 (T)	22 (T)	R.T. 200 J (T)		

CREEP RESISTANT STEEL (Cr-Mo STEEL)

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

CREEP RESISTANT STEEL (Cr-Mo STEEL)

PRODUCTS
METAL CORED WIRES



Scan the QR code
to download the technical
data sheet of the product.



METAL CORED WIRES

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INETUB M71TG <i>MILD STEEL</i>	Metal cored wire for carbon steel and microalloyed steel (S355/ S420/S460). High productivity and excellent toughness at -40°C. Hydrogen < 5ml/100g.	AWS A5.18: E70C-6M H4 EN ISO 17632-A: T 46 4 M M21 2 H5	C 0.05 Si 0.60 Mn 1.50	M21	500	575	25	-20°C 110 J -40°C 80 J		ABS LR RINA DNV TÜV DB
INETUB M71TG-CU <i>CORTEN</i>	Metal cored wire for for weathering steels (CORTEN). High productivity.	AWS A5.28: E80C-W2 EN ISO 17632-A: T 46 3 Z M M21 2 H5	C 0.05 Si 0.60 Mn 1.20 Cr 0.50 Ni 0.50 Cu 0.50	M21	535	615	25	-30°C 50 J		
INETUB M81TG-Ni1 <i>LOW TEMPERATURE</i>	Metal cored wire 1%Ni for fine grain steel (S460ML) with optimum toughness up to -60°C. Controlled hydrogen H5 <5ml/100g. Offshore and gas transport.	AWS A5.28: E80C-Ni1 EN ISO 17632-A: T 46 6 1Ni M M21 2 H5	C 0.05 Si 0.50 Mn 1.55 Ni 0.95	M21	520	610	29	-40°C 115 J -50°C 100 J -60°C 80 J		
INETUB M90 <i>HIGH STRENGTH</i>	Metal cored wire for high strength steel with UTS ≥ 640MPa (HY80, S550Q). Optimum tenacity at -40°C. Reduced heat input.	AWS A5.28 E90C-K3 EN ISO 18276: T 55 4 2NiMo M M21	C 0.06 Si 0.50 Mn 1.20 Ni 2.00 Mo 0.50	M21	630	700	22	-20°C 80 J -40°C 70 J		
INETUB M110 <i>HIGH STRENGTH</i>	Metal cored wire for high strength steel with UTS ≥ 770MPa (HY110/S690QL/ Strenx700). Optimum tenacity at -50°C. Reduced heat input.	AWS A5.28: E120C-K4 EN ISO 18276-A: T 69 5 Mn2NiCrMo M M21	C 0.06 Si 0.50 Mn 1.60 Ni 2.00 Cr 0.40 Mo 0.40	M21	740	830	17	-20°C 80 J -40°C 70 J -50°C 60 J		
INETUB M81TG-A1 <i>1/2Mo</i>	Metal cored wire with 0.5%Mo for creep resistant steel. Good toughness at -40°C. Diffusible hydrogen H5 <5ml/100g.	AWS A5.28: E80C-G EN ISO 17632-A: T 46 A Mo M M21 2 H5	C 0.05 Si 0.40 Mn 1.00 Mo 0.50	M21	470	560	22	-20°C 80 J		

METAL CORED WIRES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
FLUX CORED WIRES



Scan the QR code
to download the technical
data sheet of the product.



RUTILE FLUX CORED WIRES

BASIC FLUX CORED WIRES

RUTILE FLUX CORED WIRES

BASIC FLUX CORED WIRES

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	GAS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INETUB R71T1 <i>ALL POSITIONS, MILD STEEL</i>	Bigas rutile flux cored wire for welding carbon steel and HSLA steel. Optimum toughness tested up to -40°C. Shipyards. Weldable in M21 or 100% CO2.	AWS A5.20: E71T1-M AWS A5.20: E71T1-C EN ISO 17632-A: T 46 2 P M21 1 H5 EN ISO 17632-A: T 46 2 P C1 1 H5	C 0.06 Si 0.50 Mn 1.45	M21	550	600	24	-20°C 110 J -40°C 50 J		TÜV DB ABS LR RINA
INETUB R81T1-CU <i>ALL POSITION, CORTEN</i>	Rutile flux cored wire with added Ni-Cr-Cu for for weathering steels (CORTEN/ S355J2W).	AWS A5.29: E81T1-W2M EN ISO 17632-A: T 50 3 Z P M21 2 H5	C 0.05 Si 0.55 Mn 1.15 Ni 0.60 Cu 0.55 Cr 0.60	M21	570	650	20	-20°C 100 J -30°C 90 J -40°C 80 J		
INETUB R81T1-Ni1 <i>ALL POSITION, LOW TEMPERATURE</i>	Rutile flux cored wire with 1%Ni for vertical-up welding of fine-grained carbon steels with CVN impact toughness down to -40°C.	AWS A5.29: E81T1-Ni1M-J EN ISO 17632-A: T 46 4 1Ni P M21 2 H5	C 0.05 Si 0.40 Mn 1.20 Ni 0.90	M21	550	625	25	-20°C 110 J -30°C 100 J -40°C 85 J		
INETUB B71T5 <i>FLAT/HORIZONTAL - MILD STEEL</i>	Basic flux cored wire for flat or horizontal welding of carbon steels and HSLA steels (S460ML) with excellent toughness up to -40°C.	AWS A5.20: E71T-5M-J EN ISO 17632-A: T 46 4 B M21 2 H5	C 0.05 Si 0.50 Mn 1.20	M21	510	580	26	-20°C 120 J -30°C 95 J -40°C 80 J		TÜV DB ABS LR RINA DNV
INETUB B71T5-A1 <i>FLAT/HORIZONTAL - 1/2Mo</i>	Basic flux cored wire 0.5Mo for flat and horizontal welding of creep resistant steels. Piping up to 450°C.	AWS A5.29: E71T5-A1M EN ISO 17634-A: T Mo B M21 H5	C 0.08 Si 0.20 Mn 1.00 Mo 0.50	M21	520 (T)	620 (T)	26 (T)	-20°C 140 J (T) -40°C 90 J (T) -50°C 70 J (T)		
INETUB B81T5-B2 <i>FLAT/HORIZONTAL - 1-1/4Cr - 1/2Mo</i>	Basic flux cored wire 1.25Cr - 0.5Mo for flat and horizontal welding of creep resistant (P11) steels. Heat exchangers up to 550°C.	AWS A5.29: E81T5-B2M EN ISO 17634-A: T CrMo1 B M21 2 H5	C 0.07 Si 0.40 Mn1.00 Cr 1.20 Mo 0.45	M21	570 (T)	685 (T)	20 (T)	R.T. 140 J (T)		
INETUB B91T5-B3 <i>FLAT/HORIZONTAL - 2-1/4Cr - 1Mo</i>	Basic flux cored wire 2.25Cr - 0.5Mo for flat and horizontal welding of creep resistant (P22) steels. Petrochemical up to 600°C.	AWS A5.29: E91T5-B3M EN ISO 17634-A: T CrMo2 B M21 2 H5	C 0.07 Si 0.35 Mn 1.00 Cr 2.20 Mo 1.00	M21	660 (T)	740 (T)	20 (T)	R.T. 140 J (T)		

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
SELF-SHIELDED FLUX CORED WIRES



Scan the QR code
to download the technical
data sheet of the product.



SELF-SHIELDED FLUX CORED WIRES

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INETUB S71T11 <i>OPEN ARC - MILD STEEL</i>	Self-shielded flux cored wire (open-arc) for welding sheet metal in carbon steel. Easy slag removal. No Barium.	AWS A5.20: E71T-11 EN ISO 17632-A: T 42 Z W NO 1 H15	INETUB S71T11 INETUB S71TGS INETUB BA71T11 INETUB BA71TGS	C 0.18 Si 0.25 Mn 1.00 Al 0.80	430	520	23	-30°C 80 J -40°C 50 J		

PRODUCTS
COATED ELECTRODES



Scan the QR code
to download the technical
data sheet of the product.



RUTILE ELECTRODES

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INE 45	Highly versatile rutile electrode (R). Easy trigger, stable arc, easy slag removal. Usable with OCV > 50 V in CCPD, CCPI, CA.	AWS A5.1: E6013 EN ISO 2560-A: E 42 0 R 1 2	INE 45	C 0.06 Si 0.40 Mn 0.50	450	540	23	0°C 50 J		TÜV DB CE UK CA
INE 46 <i>VERTICAL DOWN WELDING</i>	Rutile-cellulose blue electrode (RC) with high penetration for root pass and welding in position (PF/3G up, PE/4G). Good mechanical properties.	AWS A5.1: E6013 EN ISO 2560-A: E 42 0 RC 1 1	INE 46	C 0.06 Si 0.40 Mn 0.50	440	540	24	0°C 50 J		TÜV CE UK CA
INE 47	Rutile electrode with thick coating (RR). Better weldability on oxidised sheet metal and corner beads. Easy trigger, easy slag removal.	AWS A5.1: E6013 EN ISO 2560-A: E 42 0 RR 1 2	INE 47	C 0.07 Si 0.40 Mn 0.50	470	540	24	0°C 55 J		TÜV DB CE UK CA
INE 48A	Highly versatile rutile electrode (R) and simple use. Immediate trigger and re-ignition, easy slag removal Improved performance. Ideal for tack- welding.	AWS A5.1: E6013 EN ISO 2560-A: E 42 0 R 1 2	INE 48 A	C 0.06 Si 0.40 Mn 0.50	440	540	24	0°C 50 J		CE UK CA
INE SUPER <i>VERTICAL DOWN WELDING</i>	Rutile-cellulose electrode (RC) with high penetration for root pass and welding in position (PF/3G up, PE/4G). Good mechanical properties.	AWS A5.1: E6013 EN ISO 2560-A:	INE SUPER	C 0.06 Si 0.35 Mn 0.50	460	540	24	0°C 50 J		TÜV DB CE UK CA
INE AR 150 <i>HIGH DEPOSITION</i>	High performance rutile electrode ~150%. Head/head and flat corner joint welding on medium to large thicknesses in shipyards.	AWS A5.1: E7024 EN ISO 2560-A: E 42 0 RR 5 4	INE AR 150	C 0.07 Si 0.40 Mn 0.80	460	550	24	0°C 60 J		
INE VERTICAL <i>VERTICAL DOWN WELDING</i>	Rutile- cellulose (RC) electrode for welding in a vertical ascending and descending position (PG/3G down)	AWS A5.1: E6012 EN ISO 2560-A: E 42 0 RC 1 1	INE VERTICAL	C 0.06 Si 0.35 Mn 0.70	460	530	24	0°C 60 J		TÜV CE UK CA

RUTILE ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
COATED ELECTRODES



Scan the QR code
to download the technical
data sheet of the product.



BASIC ELECTRODES

PRODUCT	PRODUCT DESCRIPTION	NORMS	TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
				YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INE 50B	H5 low hydrogen basic electrode and high yield for fine grain carbon steel (S420N). Excellent mechanical properties up to -40°C.	AWS A5.1: E7018 EN ISO 2560-A: E 42 4 B 4 2 H5	C 0.05 Si 0.40 Mn 1.30 Ni 0.10 Cr 0.10 Mo 0.08	470	540	26	-30°C 80 J -40°C 50 J		RINA ABS LRS DNV CE UK CA
INE 55B <i>LOW HYDROGEN</i>	H5 low hydrogen basic electrode for fine grain carbon steel with CVN toughness at -50°C (P355NL2). Boiler works, shipyard.	AWS A5.1: E7018-1 H4 EN ISO 2560-A: E 42 5 B 4 2 H5	C 0.05 Si 0.40 Mn 1.40 P 0.015 S 0.010 Ni 0.05 Cr 0.05 Mo 0.05 V 0.01	450 430 (T)	550 520 (T)	26 26 (T)	-20°C 200 J -40°C 140 J -45°C 80 J -50°C 60 J -20°C 200 J -40°C 150 J -45°C 80 J -50°C 60 J		TÜV DB ABS LRS RINA DNV CE UK CA
INE RB 86	Special basic electrode with double coating for carbon steel S355. Excellent arc thrust and appearance of bead, low spattering.	AWS A5.1: E7016 EN ISO 2560-A: E 42 2 B 1 2 H10	C 0.07 Si 0.50 Mn 1.20	470	540	26	-20°C 70 J -30°C 50 J		CE UK CA
INE 57 B CNC <i>CORTEN</i>	Basic electrode for weathering steels (Corten) and high strength steels (P500QL1). Excellent mechanical properties and good strength against corrosion.	AWS A5.5: E8018-W2 EN ISO 2560-A: E 50 4 Z B 4 2	C 0.06 Si 0.40 Mn 0.70 Cr 0.50 Ni 0.60 Cu 0.50	530	600	24	-40°C 50 J		
INE C3 <i>LOW TEMPERATURE</i>	Basic electrode with 1% Ni with low hydrogen content for fine grain steel (S460ML). Optimum toughness up to -50°C. Offshore platforms.	AWS A5.5: E8018-C3 EN ISO 2560-A: E 46 4 1Ni B 4 2	C 0.05 Si 0.30 Mn 1.00 Ni 0.90 Ni 3.40	480	570	26	-40°C 85 J -50°C 50 J		
INE 80B <i>HIGH STRENGTH</i>	Basic electrode with low hydrogen content (<5ml/100g) for high strength steel with UTS ≥ 700 MPa (S620QL1, HY80). Optimum radiographic quality.	AWS A5.5: E10018M EN ISO 18275-A: E 62 4 1,5NiMo B 4 2 H5	C 0.05 Si 0.40 Mn 1.30 Cr 0.30 Ni 1.50 Mo 0.40	660	750	22	-50°C 50 J		

BASIC ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
COATED ELECTRODES



Scan the QR code
to download the technical
data sheet of the product.



BASIC ELECTRODES

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INE A1 <i>1/2Mo</i>	Basic electrode 0.5Mo for creep resistant steel. Controlled hydrogen H4. Heat exchangers up to 500°C.	AWS A5.5: E7018-A1 H4 EN ISO 2560-A: E 46 2 Mo B 4 2 EN ISO 3580-A: E Mo B 4 2 H5	INE A1 INE B2 INE B2 L INE B3 INE B3 L INE B6 INE B8 INE B9	C 0.04 Si 0.40 Mn 0.70 Mo 0.50	480 (T)	510-600 (T)	26 (T)	-20°C 80 J (T) -40°C 47 J (T)		
INE B2 <i>1-1/4Cr - 1/2Mo</i>	Basic electrode 1.25Cr-0.5Mo for creep resistant steel (P11). Low hydrogen content (H4). Heat exchangers and boilers operating at 550°C.	AWS A5.5: E8018-B2 H4 EN ISO 3580-A: E CrMo1 B 4 2 H5		C 0.07 Si 0.40 Mn 0.70 Cr 1.30 Mo 0.50	520 (T)	550-690 (T)	24 (T)	-20°C 90 J (T) -40°C 47 J (T)		
INE B2 L <i>1-1/4Cr - 1/2Mo LOW CARBON</i>	Basic electrode 1.25Cr-0.5Mo for creep resistant steel (P11). Low hydrogen content (H4). Cmax 0.05% allows reduced PWHT on small thicknesses.	AWS A5.5: E7018-B2L H4 EN ISO 3580-A: E CrMo1L		C 0.03 Si 0.40 Mn 0.70 Cr 1.25 Mo 0.50	480 (T)	520-650 (T)	25 (T)	R.T. 150 J (T) -20°C 90 J (T) -40°C 47 J (T)		
INE B3 <i>2-1/4Cr - 1Mo</i>	Basic electrode 2.25Cr- 1Mo for creep resistant steel (P22). Low hydrogen content (H4). Petrochemical up to a 600°C.	AWS A5.5: E9018-B3 H4 EN ISO 3580-A: E CrMo2 B 4 2 H5		C 0.07 Si 0.40 Mn 0.70 Cr 2.25 Mo 1.00	580 (T)	630-720 (T)	22 (T)	R.T. 140 J (T) -30°C 47 J (T)		
INE B3 L <i>2-1/4Cr - 1Mo LOW CARBON</i>	Basic electrode 2.25Cr- 1Mo for creep resistant steel (P22). Low hydrogen content (H4). Cmax 0.05% allows reduced PWHT on small thicknesses.	AWS A5.5: E8018-B3L H4 EN ISO 3580-A: E CrMo2L		C 0.03 Si 0.40 Mn 0.70 Cr 2.30 Mo 1.00	520 (T)	630-720 (T)	22 (T)	R.T. 160 J (T) -30°C 47 J (T)		
INE B6 <i>5Cr - 1/2Mo</i>	Basic electrode 5Cr-0.5Mo for creep resistant steel (12 CrMo 19-5). Low hydrogen content (H4). Repair of moulds with similar composition.	AWS A5.5: E8018-B6 H4 EN ISO 3580-A: E CrMo5 B 3 2 H5		C 0.07 Si 0.40 Mn 0.70 Cr 4.50 Mo 0.50 Mo 0.50	560 (T)	580-700 (T)	22 (T)	R.T. 60 J (T)		
INE B8 <i>9Cr - 1Mo</i>	Basic electrode 9Cr- 1Mo for creep resistant steel (P9). Low hydrogen content (H4). Heat exchangers, boilers, piping with working T up to 600°C.	AWS A5.5: E8018-B8 H4 EN ISO 3580-A: E CrMo9		C 0.07 Si 0.30 Mn 0.70 Cr 9.00 Mo 1.00	600 (T)	710 (T)	22 (T)	R.T. 60 J (T)		
INE B9 <i>9Cr - 1Mo - V - Nb</i>	Basic electrode for creep resistant steel 9CrMoVNb9-1 (P91). Heat exchangers, boilers, piping operating up to 600°C. X and J controlled factors.	AWS A5.5: E9018-B91 H4 EN ISO 3580-A: E CrMo91		C 0.08 Si 0.20 Mn 0.70 Cr 9.00 Mo 0.95 V 0.20 N 0.05 Nb 0.05	610 (T)	620-700 (T)	22 (T)	R.T. 70 J (T)		

BASIC ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
SUBMERGED ARC WELDING WIRES AND FLUX



Scan the QR code
to download the technical
data sheet of the product.



CARBON AND HSLA STEELS

CARBON AND HSLA STEELS

FLUX FOR SUBMERGED ARC

FLUX FOR SUBMERGED ARC

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					FLUX	YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*	
INESUB S1 <i>+ INEFLUX MP</i>	Solid wire SAW 0.5%Mn for welding carbon steel S235/S275. Recommended flux: INEFLUX MP.	AWS A5.17: EL12 EN ISO 14171-A: S1	INESUB S1	C 0.06 Si 0.07 Mn 0.50	INEFLUX MP	>400	>500	>24	0°C >70 -20°C >50	TÜV
	INESUB S2 <i>+ INEFLUX MP</i> <i>+ INEFLUX SP</i>	Solid wire SAW 1%Mn for carbon steel S355N. RINA and LR approved, available with INEFLUX MP. Improved productivity combined with INEFLUX SP.		C 0.10 Si 0.12 Mn 1.00	INEFLUX MP	>420	>500	>22	0°C >100 -20°C >70 -40°C >27	TÜV RINA (INEFLUX MP) LR (INEFLUX MP)
	INESUB S2Si <i>+ INEFLUX MP</i> <i>+ INEFLUX SP</i>	Solid wire SAW 1%Mn with high Si for carbon steel and HSLA steel S355N/ S420N. Recommended flux: INEFLUX MP for improved mechanical performance at low temperature or INEFLUX SP for higher productivity.		C 0.10 Si 0.20 Mn 1.00	INEFLUX MP	>420	>500	>22	0°C >100 -20°C >70 -40°C >27	TÜV
	INESUB S3Si <i>+ INEFLUX MP</i>	Solid wire SAW with >1,5%Mn and >0.2%Si for carbon steel and HSLA steel S420N/S460N. Flows: INEFLUX MP or INEFLUX BLKV for toughness up to -60°C.		C 0.10 Si 0.30 Mn 1.70	INEFLUX MP	>420	>570	>22	0°C >100 -20°C >80 -40°C >47	TÜV
	INESUB S2CU <i>+ INEFLUX MP</i>	Solid wire SAW in Ni-Cr-Cu for weathering steels (CORTEN/S355J2W). Recommended flux: INEFLUX MP.		C 0.10 Si 0.25 Mn 1.00 Ni 0.75 Cr 0.20 Cu 0.45	INEFLUX MP	>470	>520	>22	0°C >100 -20°C >60	TÜV
INEFLUX MP	Semi-basic aluminised agglomerate flux for welding carbon steel and HSLA steel. Boniszewski basicity: 1.7, Average pick-up of Si and Mn.	EN ISO 14174: S A AB 1 67 AC H5 EN 760: SA AB 1 67 AC H5*	INEFLUX MP							
	INEFLUX SP	Rutile agglomerate flux for high productivity welding of carbon steel and micro-alloy steel. Boniszewsky basicity: 0.6, Medium pick-up of Mn for welding carbon steel and HSLA steel. Boniszewsky basicity: 1.7, Average pick-up of Si and Mn.								

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
SUBMERGED ARC WELDING WIRES AND FLUX



Scan the QR code
to download the technical
data sheet of the product.



LOW ALLOY STEEL

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INESUB S2Ni1 <i>+ INEFLUX BLKV</i>	Solid wire SAW 1% Ni for fine grain steel (S460ML). Optimum toughness up to -60°C with INEFLUX BLKV. Offshore platforms, gas transport.	AWS A5.23: ENi1 EN ISO 14171-A: S2Ni1	INESUB S2Ni1	C 0.10 Si 0.15 Mn 1.00 Ni 0.95	>440	>540	>22	0°C >150 -20°C >140 -40°C >100 -60°C >80		TÜV CE UK CA
INESUB S2Ni2 <i>+ INEFLUX BLKV</i>	Solid wire SAW 2% Ni for Nickel-Manganese steel (11MnNi5-3) Optimum toughness up to -80°C with INEFLUX BLKV. LPG transport and storage.	AWS A5.23: ENi2 EN ISO 14171-A: S2Ni2	INESUB S2Ni2	C 0.10 Si 0.15 Mn 1.00 Ni 2.25	>470	>550	>22	0°C >150 -20°C >140 -40°C >120 -60°C > 80 -80°C > 47		CE UK CA
INESUB S2Ni3 <i>+ INEFLUX BLKV</i>	Solid wire SAW 3.5% Ni for Nickel-Manganese steel (A203 Gr.A). Optimum toughness up to -80°C with INEFLUX BLKV. LPG transport and storage.	AWS A5.23: ENi3 EN ISO 14171-A: S2Ni3	INESUB S2Ni3	C 0.10 Si 0.15 Mn 1.00 Ni 3.50	>500	>590	>22	-20°C >160 -40°C >140 -60°C >100 -80°C >100		CE UK CA
INESUB S3NiMO <i>+ INEFLUX BLKV</i>	Solid wire SAW for high strength steel (S500QL1). Combined with INEFLUX BLKV, it produces welds with UTS ≥ 640 Mpa and good toughness at -60°C.	AWS A5.23: EG EN ISO 26304-A: S3Ni1Mo	INESUB S3NiMO	C 0.10 Si 0.15 Mn 1.50 Mo 0.50 Ni 1.00	>570	>670	>22	0°C >120 -20°C >80 -40°C >70 -60°C >47		TÜV CE UK CA
INESUB EF3 <i>+ INEFLUX BLKV</i>	Solid wire SAW for high strength steel and fine grain (S460QL1/S500QL1). Combined with INEFLUX BLKV, it produces welds with UTS ≥ 640 Mpa and good toughness at -60°C.	AWS A5.23: EF3 EN ISO 26304-B: SUN2M33	INESUB EF3	C 0.15 Si 0.15 Mn 2.30 Mo 0.50 Ni 0.90	>570	>670	>22	0°C >120 -20°C >80 -40°C >70 -60°C >47		

LOW ALLOY STEEL

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
SUBMERGED ARC WELDING WIRES AND FLUX



Scan the QR code
to download the technical
data sheet of the product.



	PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS	
						YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*			
LOW ALLOY STEEL	INESUB S2MO <i>+ INEFLUX BLKV</i>	Solid wire SAW with 0.5%Mo for creep resistant steel. Recommended flux: INEFLUX BLKV	AWS A5.23: EA2 EN ISO 14171-A: S2Mo	INESUB S2MO	C 0.10 Si 0.10 Mn 1.10 Mo 0.55	>450 (T)	>560 (T)	>20 (T)	0°C >120 (T) -20°C >100 (T) -40°C >47 (T)		TÜV CE UK CA	LOW ALLOY STEEL
	INESUB EB2 <i>+ INEFLUX BLKV</i>	Solid wire SAW for creep resistant steel 1.25Cr – 0.5Mo (P11). Heat exchangers, boilers, piping operating up to 550°C. Flux: INEFLUX BLKV	AWS A5.23: EB2 EN ISO 24598-A: S CrMo1	INESUB EB2	C 0.12 Si 0.15 Mn 0.80 Cr 1.10 Mo 0.50	>470 (T)	>560 (T)	>22 (T)	0°C >120 (T) -20°C >80 (T) -40°C >40 (T)		TÜV CE UK CA	
	INESUB EB2R <i>+ INEFLUX BLKV</i>	Copper free, solid wire SAW for creep resistant steel 1.25Cr – 0.5Mo (P11). Controlled chemical (R) with low impurities, Xfmax = 15. Flux: INEFLUX BLKV	AWS A5.23: EB2R EN ISO 24598--A: S CrMo1	INESUB EB2R	C 0.12 Si 0.15 Mn 0.80 Cr 1.10 Mo 0.50	>470 (T)	>560 (T)	>22 (T)	0°C >120 (T) -20°C >80 (T) -40°C >40 (T)			
	INESUB EB3 <i>+ INEFLUX BLKV</i>	Solid wire SAW for creep resistant steel 2.25Cr – 1Mo (P22). Petrochemical with operation up to 600°C. Flux: INEFLUX BLKV	AWS A5.23: EB3 EN ISO 24598-A: S CrMo2	INESUB EB3	C 0.12 Si 0.15 Mn 0.60 Cr 2.50 Mo 1.00	>470 (T)	>560 (T)	>22 (T)	0°C >120 (T) -40°C >40 (T)		TÜV CE UK CA	
	INESUB EB3R <i>+ INEFLUX BLKV</i>	Copper free, solid wire SAW for creep resistant steel 2.25Cr – 1Mo (P22). Controlled chemical (R) with low impurities, Xfmax = 15. Flux: INEFLUX BLKV	AWS A5.23: EB3R EN ISO 24598-A: S CrMo2	INESUB EB3R	C 0.12 Si 0.15 Mn 0.60 Cr 2.50 Mo 1.00	>470 (T)	>560 (T)	>22 (T)	0°C >120 (T) -40°C >40 (T)			
FLUX FOR SUBMERGED ARC	INEFLUX BLKV	Basic agglomerate flux for low-alloy steel welding. Boniszewsky basicity: 3.2. Neutral for Si and Mn.	EN ISO 14174: SA FB 1 55 AC H5	INEFLUX BLKV								FLUX FOR SUBMERGED ARC

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
WIRES FOR SUBMERGED ARC



Scan the QR code
to download the technical
data sheet of the product.



	PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS	
						YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*			
LOW ALLOY STEEL	INESUB EB6 <i>+ INEFLUX BHA</i>	Solid wire SAW for creep resistant steel 5Cr–0.5Mo (12 CrMo 19-5). Recommended flux: INEFLUX BHA.	AWS A5.23: EB6 EN ISO 24598-A: S CrMo5	INESUB EB6	C 0.07 Si 0.40 Mn 0.50 Cr 5.60 Mo 0.55	>470 (T)	>600 (T)	>718 (T)	RT > 70 (T)		TÜV CE UK CA	LOW ALLOY STEEL
	INESUB EB8 <i>+ INEFLUX BHA</i>	Solid wire SAW for creep resistant steel 9Cr–1Mo (P9). Heat exchangers, boilers, piping with operating T up to 600°C. Recommended flux: INEFLUX BHA.	AWS A5.23: EB8 EN ISO 24598-A: S CrMo9	INESUB EB8	C 0.07 Si 0.35 Mn 0.50 Cr 9.00 Mo 1.00	> 470 (T)	>600 (T)	>17 (T)	RT > 47 (T)		TÜV	
	INESUB EB9 <i>+ INEFLUX BHA</i>	Copper free solid wire SAW for creep resistant steel 9CrMoVNb9–1(P91) Heat exchangers, boilers, piping with operating temperatures up to 600°C. Recommended flux: INEFLUX BHA.	AWS A5.23: EB91 EN ISO 24598-A: S CrMo91	INESUB EB9	C 0.10 Si 0.20 Mn 0.60 Cr 8.80 Mo 0.95 V 0.20 Ni 0.60 N 0.05 Nb 0.06	> 540 (T)	>660 (T)	>17 (T)	RT > 47 (T)		TÜV CE UK CA	
	INESUB EB9LowNi <i>+ INEFLUX BHA</i>	Copper free, solid wire SAW with Nickel base for creep resistant steel 9CrMoVNb9-1 (P91). Ni + Mn < 1% allows you to carry out PWHT at higher temperatures.	AWS A5.23: EB91	INESUB EB9LowNi	C 0.09 Si 0.20 Mn 0.60 Cr 8.80 Mo 0.95 V 0.20 Ni 0.03 N 0.05 Nb 0.08	> 540 (T)	>660 (T)	>17 (T)	RT > 47 (T)			
FLUX FOR SUBMERGED ARC	INEFLUX BHA	Semi-basic flux for welding austenitic stainless steel and Cr-Mo high alloys. Boniszewsky basicity: 1.3, Low pick-up of Si and burn-out of Mn.	ISO 14174 -S F CS 2 5742 DC (stainless steel) ISO 14174 -S F CS 1 63 DC (stainless steel)	INEFLUX BHA								FLUX FOR SUBMERGED ARC

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness



Scan the QR code
to download the technical
data sheet of the product.



MIG/MAG SOLID WIRES

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					GAS	YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*	
INEFIL INOX 307 SI <i>AISI 307</i>	ER307 stainless steel solid wire suitable for heterogeneous welds, steel with 13% Mn (Hadfield type), buffer layers for cladding.	AWS A5.9: ER307 EN ISO 14343-A: G 18 8 Mn	INEFIL INOX 307 SI INEFIL INOX 308 LSi INEFIL INOX 309 LSi INEFIL INOX 310 INEFIL INOX 312 INEFIL INOX 316 LSi	C 0.05 Si 0.70 Mn 6.80 Ni 8.00 Cr 18.50 Mo 0.10	M13	490	650	34	R.T. >47 J	TÜV DB   
INEFIL INOX 308 LSi <i>AISI 308 Wr.Nr. 1.4316</i>	ER308LSi solid stainless steel wire for AISI 304. The low carbon provides good intergranular corrosion resistance. Increased silicon for better control of the weld pool.	AWS A5.9: ER308LSi EN ISO 14343-A: G 19 9 L Si		C 0.03 Si 0.85 Mn 1.80 Ni 10.00 Cr 20.00 Mo 0.10	M13	440	580	42	R.T. >47 J	TÜV DB   
INEFIL INOX 309 LSi <i>AISI 309</i>	ER309LSi solid stainless steel wire for AISI 309. Also suitable for heterogeneous welds and buffer layers for cladding.	AWS A5.9: ER309LSi EN ISO 14343-A: G 23 12 L Si		C 0.02 Si 0.70 Mn 1.80 Ni 14.00 Cr 24.00 Mo 0.10	M13	440	560	40	R.T. >47 J	  
INEFIL INOX 310 <i>AISI 310 Wr.Nr.1.4841</i>	ER310 solid stainless steel wire for welding AISI 310. It is used on pressure vessels and exchangers in the petrochemical industry.	AWS A5.9: ER310 EN ISO 14343-A: G 25 20		C 0.10 Si 0.40 Mn 1.80 Ni 21.00 Cr 26.00 Mo 0.20	M13	355	610	35		
INEFIL INOX 312 <i>AISI 312 - WELDALL</i>	ER312 (WeldAll) solid stainless steel wire for heterogeneous welds, for steels with Mn13% (Hadfield) and hard to weld high-carbon steels.	AWS A5.9: ER312 EN ISO 14343-A: G 29 9		C 0.10 Si 0.40 Mn 1.80 Ni 9.20 Cr 30.00 Mo 0.20	M13	450	660	22		
INEFIL INOX 316 LSi <i>AISI 316 Wr.Nr. 1.4430</i>	Low carbon ER316LSi solid wire for AISI 316. The low carbon provides good intergranular corrosion resistance. Increased silicon for better control of the weld pool.	AWS A5.9: ER316LSi EN ISO 14343-A: G 19 12 3 L Si		C 0.02 Si 0.80 Mn 1.70 Ni 12.20 Cr 18.50 Mo 2.50	M13	440	560	40	R.T. >47 J	TÜV DB   

MIG/MAG SOLID WIRES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

TIG RODS



Scan the QR code
to download the technical
data sheet of the product.



ELECTRODES

PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS
					YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
INOX 307 <i>HADFIELD 12%Mn</i>	Semi-basic electrode suitable for heterogeneous welds, steels with 13% Mn (Hadfield type) and buffer layers in hardfacing.	AWS A5.4: E307-16 EN ISO 3581-A: E 18 9 Mn Mo R	INOX 307 INOX 308 RLC INOX 309 RLC INOX 310 R INOX 312 R INOX 316 RLC	C 0.10 Mn 3.80 Si 0.80 Cr 20.00 Ni 10.00 Mo 0.60	450	620	35			
INOX 308 RLC	Rutile electrode for AISI 304. The low carbon content offers good resistance against intergranular corrosion.	AWS A5.4: E308L-17 EN ISO 3581-A: E 19 9 L R		C 0.03 Mn 0.70 Si 0.70 Cr 19.00 Ni 10.00	350	520	35			
INOX 309 RLC	Low carbon rutile electrode for AISI 309. Also suitable for heterogeneous welds and buffer layers in hardfacing.	AWS A5.4: E309L-16 EN ISO 3581-A: E 23 12 L R		C 0.03 Mn 1.30 Si 0.80 Cr 24.00 Ni 13.00	440	600	32			
INOX 310 R	Rutile electrode for welding AISI 310. It is used on pressure vessels and exchangers in the petrochemical industry.	AWS A5.4: E310-16 EN ISO 3581-A: E 25 20 R		C 0.10 Mn 1.80 Si 0.60 Cr 27.00 Ni 21.00	450	580	30	R.T. 60J		
INOX 312 R <i>WELDALL</i>	Rutile electrode for heterogeneous welds between stainless steel and carbon steel, for steel with Mn13% (Hadfield) and high carbon steel difficult to weld.	AWS A5.4: E312-16 EN ISO 3581-A: E 29 9 R		C 0.10 Mn 1.20 Si 0.80 Cr 30.00 Ni 10.00	610	760	23	R.T. 35J		
INOX 316 RLC	Rutile electrode for AISI 316. The low carbon content offers good resistance against intergranular corrosion.	AWS A5.4: E316L-17 EN ISO 3581-A: E 19 12 3 L R		C 0.03 Mn 1.00 Si 0.70 Cr 18.00 Ni 12.00 Mo 2.70	440	580	35			

ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PRODUCTS
ALUMINIUM ALLOYS



Scan the QR code
to download the technical
data sheet of the product.



	PRODUCT	PRODUCT DESCRIPTION	NORMS		TYPICAL CHEMICAL ANALYSIS	TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment)				WELDING POSITIONS	APPROVALS	
						GAS	YS (MPa)*	UTS (MPa)*	El. (%)*	CVN (J)*		
MIG/MAG SOLID WIRES	INEFIL AL5%SI - 4043 <i>Wr.Nr. 3.2245</i>	Solid wire 5%Si for aluminium series 6XXX. High resistance to hot cracking under high dilution conditions and binding joints.	AWS A5.10: ER4043 EN ISO 18273: S AlSi5 EN ISO 18273: S Al 4043	INEFIL AL5%SI - 4043 INEFIL AL5%MG - 5356	Mn 0.01 Si 5.00 Fe 0.14 Al Bal.	I1	40	150	10		 	MIG/MAG SOLID WIRES
	INEFIL AL5%MG <i>Wr.Nr. 3.3556</i>	Solid wire 5% Mg for aluminium series 6XXX and 5XXX. Welds with good appearance and better resistance to corrosion.	AWS A5.10: ER5356 EN ISO 18273: S AlMg5Cr(A) EN ISO 18273: S Al 5356		Mn 0.15 Mg 5.00 Fe 0.13 Cr 0.14 Al Bal.	I1	110	240	17		 	
TIG RODS	INETIG AL5%SI <i>Wr.Nr. 3.2245</i>	TIG rod 5%Si for aluminium series 6XXX. High resistance to hot cracking under high dilution conditions and binding joints.	AWS A5.10: ER4043 EN ISO 18273: S AlSi5 EN ISO 18273: S Al 4043	INETIG AL5%SI - 4043 INETIG AL5%MG - 5356	Mn 0.01 Si 5.00 Fe 0.14 Al Bal.	I1	40	120	8		 	TIG RODS
	INETIG AL5%MG <i>Wr.Nr. 3.3556</i>	TIG rod 5% Mg for aluminium series 6XXX and 5XXX. Welds with good appearance and better resistance to corrosion.	AWS A5.10: ER5356 EN ISO 18273: S AlMg5Cr(A) EN ISO 18273: S Al 5356		Mn 0.15 Mg 5.00 Fe 0.13 Cr 0.14 Al Bal.	I1	120	250	18		 	
ELECTRODES	INE AL5%Si	Electrode 5%Si for aluminium series 6XXX. High resistance to hot cracking under high dilution conditions and binding joints.	AWS A5.3: E4043	INE AL5%Si	Mn 0.04 Si 5.00 Mg 0.04 0.08 Fe 0.30 Cu 0.05 Al Rem.							ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

ELECTRODES



Scan the QR code
to download the technical
data sheet of the product.



	PRODUCT	PRODUCT	NORMS		NORMS	GAS TYPICAL MECHANICAL CHARACTERISTICS (T = after heat treatment) YS (MPa)* UTS (MPa)* El. (%)* CVN (J)* HARDNESS (HRC, HB)	WELDING POSITIONS	APPROVALS	
MIG/MAG SOLID WIRES	INEFIL 350 <i>Wr.Nr. 1.7363</i>	Solid wire for hardfacing (Wr.Nr.~ 1.7363) with an all weld hardness of 350 HB (38 HRC). Good resistance against abrasion and impact. Deposit free of cracks.		INEFIL 350	C 0.07 Si 0.40 Mn 0.50 Cr 5.80 Mo 0.60	M21 HB 350			MIG/MAG SOLID WIRES
	INEFIL 600 <i>Wr.Nr. 1.4718</i>	Solid wire for hardfacing (Wr.Nr. 1.4718) with all weld hardness of 600 HB (57 HRC). Good resistance against abrasion and impact. Deposit free of cracks.	EN 14700: S Fe8	INEFIL 600	C 0.45 Si 3.00 Mn 0.40 Cr 9.50	M21 HRc 58			
FLUX CORED WIRES FOR HARDFACING	INETUB MHF 600	Metal cored wire for hardfacing 600HB (60HRC). Optimum resistance against abrasion from friction and impact.	EN 14700: T Fe8	INETUB MHF 600	C 0.55 Si 0.60 Mn 1.40 Cr 5.60 Mo 0.80	HRc 56			FLUX CORED WIRES FOR HARDFACING
ELECTRODES	INE RD 600	Basic electrode for hardfacing with All Weld hardness 600 HB (57 HRC). Good resistance against abrasion and impact. Deposit free of cracks.	EN 14700: E Fe4	INE RD 600	C 0.40 Mn 1.90 Cr 2.80	HRc 56			ELECTRODES

(*) YS (MPa): El. yield strength (%): Elongation % 5d
UTS (MPa): Tensile strength
CVN (J): Average toughness

PACKAGING

PACKAGING MIG/MAG WIRES

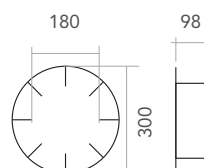
PALLET: 72 SPOOLS OF 15KG / 56 SPOOLS OF 18KG PER PALLET



K 300

STEEL

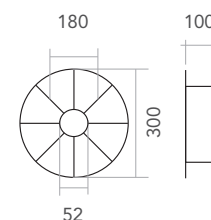
Net weight 15 kg



BS 300

STEEL

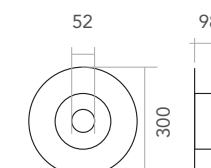
Net weight 15 kg



D 100

PLASTIC

Net weight 0.45 kg - 0.90 kg - 1kg



SUBMERGED ARC

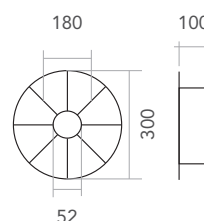
PALLET: 40 SPOOLS OF 25KG PER PALLET



BS 300

STEEL

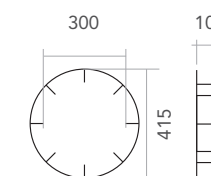
Only for INEFIL NR and INEFIL 19.12
NR Net weight 18 kg



K 415/25

STEEL

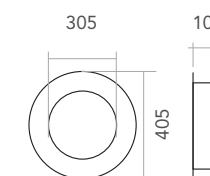
Net weight 25 kg



D 400/25

PLASTIC

Net weight 25 kg



MIG/MAG WIRES / FLUX CORED WIRE

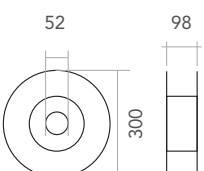
PALLET: 72 SPOOLS OF 15KG PER PALLET



D 300

PLASTIC

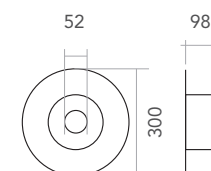
Net weight 15 kg



D 200

PLASTIC

Net weight 5 kg



MIG/MAG WIRE / SUBMERGED ARC / FLUX CORED WIRE

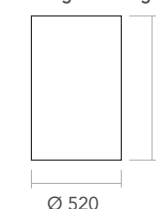
PALLET: 4 DRUMS 250 - 2 DRUMS 350 - 1 DRUM 500

**DRUM
BOX**

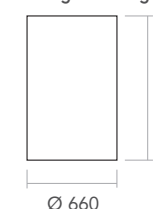


MIG/MAG WIRES / FLUX CORED WIRE

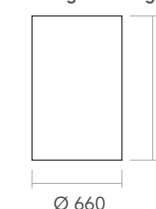
Weight 250kg



Weight 350kg

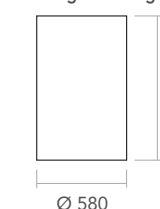


Weight 500kg



SUBMERGED ARC WIRE

Weight 300kg



COVER

In cardboard for drum
250 kg

In cardboard with metal closure
350 kg and 500 kg

PACKAGING
ELECTRODES



PACKET

Dimensions 66x40x300 mm
66x40x350 mm
66x78x300 mm
66x78x350 mm
66x78x450 mm



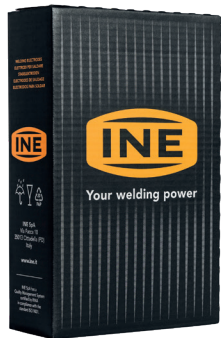
TIG RODS

Dimensions 1045mm x 45 mm diameter
Weight 5kg
Packaging: box 50 pcs -250 kg 1060x390x300 mm
box 100 pcs - 500 kg 1040x362x700 mm



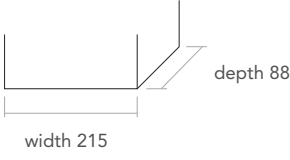
BLISTER

Dimensions 415x275x125 mm



BOX

Contains 6 packets 66x40 mm or Vacuum
3 packets 66x78 mm or Vacuum
Lengths 330 / 380 / 480 mm



TUBE FOR ELECTRODES

Dimensions 67x31x300 mm
67x31x350 mm
67x31x450 mm



VACUUM

Dimensions 375x85x368 mm
375x85x394 mm





ELECTRODES

PRODUCT	ø (mm)	L (mm)	PIECES PER KG (~)	PACKAGING	DIM. PACKET (*)	PACKET NET WEIGHT (kg)(~)	PIECES PER PACKET (~)
INE 45	1.6	300	140.0	PACKET	A	2.0	280
	2	300	90.0	PACKET	C	3.9	350
	2.5	300	61.0	PACKET	C	3.8	230
	3.2	450	24.0	PACKET	E	6.2	150
	4	450	16.0	PACKET	E	6.2	100
	5	450	10.0	PACKET	E	6.2	60
INE 46 (blue)	2.5	350	54.0	PACKET	D	5.0	270
	3.2	350	35.0	PACKET	D	5.0	175
	4	350	23.0	PACKET	D	5.0	115
	2.5	350	54.0	PACKET	B	2.5	135
	3.2	350	35.0	PACKET	B	2.5	88
	4	350	23.0	PACKET	B	2.5	58
INE 47	2	300	90.0	PACKET	C	3.9	350
	2.5	300	53.0	PACKET	C	4.3	230
	3.2	450	23.0	PACKET	E	6.5	150
	4	450	16.0	PACKET	E	6.2	100
	5	450	10.0	PACKET	E	6.0	60
INE 48 A (red)	2	300	90.0	PACKET	C	3.9	350
	2.5	300	59.0	PACKET	C	3.8	230
	3.2	450	24.0	PACKET	E	6.0	150
INE 50B	2	300	83.0	PACKET	C	4.2	350
	2.5	300	50.0	PACKET	C	4.8	240
	2.5	350	42.0	PACKET	D	5.0	210
	3.2	350	27.0	PACKET	D	5.0	135
	3.2	450	21.0	PACKET	E	6.7	140
	4	350	19.0	PACKET	D	5.0	96

(*) PACKETS A: 66x40x300 B: 66x40x350 C: 66x78x300 D: 66x78x350 E: 66x78x450
VACUUM F: 67x31x300 G: 67x31x350 H: 67x31x450

DIM. BOX (*2)	PACKETS PER BOX	BOX NET WEIGHT (kg)(~)	PIECES PER BOX (~)	BOX PER PALLET	PALLET NET WEIGHT (kg)(~)	PIECES PER PALLET (~)
A	6	12.0	1,680	72	864	120,960
A	3	11.7	1,050	72	842	75,600
A	3	11.4	690	72	821	49,680
C	3	18.6	450	54	1,004	24,300
C	3	18.6	300	54	1,004	16,200
C	3	18.6	180	54	1,004	9,720
B	3	15.0	810	72	1,080	58,320
B	3	15.0	525	72	1,080	37,800
B	3	15.0	345	72	1,080	24,840
B	6	15.0	810	72	1,080	58,320
B	6	15.0	528	72	1,080	38,016
B	6	15.0	348	72	1,080	25,056
A	3	11.7	1,050	72	842	75,600
A	3	12.9	690	72	929	49,680
C	3	19.5	450	54	1,053	24,300
C	3	18.6	300	54	1,004	16,200
C	3	18.0	180	54	972	9,720
A	3	11.7	1,050	72	842	75,600
A	3	11.4	690	72	821	49,680
C	3	18.0	450	54	972	24,300
A	3	12.6	1,050	72	907	75,600
B	3	14.4	720	72	1,037	51,840
B	3	15.0	630	72	1,080	45,360
B	3	15.0	405	72	1,080	29,160
C	3	20.1	420	54	1,085	22,680
B	3	15.0	288	72	1,080	20,736

(*2) A: 215x88x330 B: 215x88x380 C: 215x88x480

DIM. PAL: 93x75

ELECTRODES



ELECTRODES

PRODUCT	ø (mm)	L (mm)	PIECES PER KG (~)	PACKAGING	DIM. PACKET (*)	PACKETS NET WEIGHT (kg)(~)	PIECES PER PACKET (~)
INE 50B	4	450	15.0	PACKET	E	5.3	80
	5	450	10.0	PACKET	E	5.0	50
	2	300	83.0	VACUUM	F	2.0	166
	2.5	300	50.0	VACUUM	F	2.0	100
	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	3.2	450	21.0	VACUUM	H	2.5	53
	4	350	19.0	VACUUM	G	2.0	38
	4	450	15.0	VACUUM	H	2.5	38
	5	450	10.0	VACUUM	H	2.5	25
INE 55B	2	300	83.0	PACKET	C	4.0	350
	2.5	300	50.0	PACKET	C	4.7	240
	2.5	350	42.0	PACKET	D	5.0	210
	3.2	350	27.0	PACKET	D	5.0	135
	3.2	450	21.0	PACKET	E	7.0	140
	4	350	19.0	PACKET	D	5.0	95
	4	450	15.0	PACKET	E	5.6	80
	5	450	10.0	PACKET	E	5.0	50
	2	300	83.0	VACUUM	F	2.0	166
	2.5	300	50.0	VACUUM	F	2.0	100
	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	3.2	450	21.0	VACUUM	H	2.5	53
	4	350	19.0	VACUUM	G	2.0	38
	4	450	15.0	VACUUM	H	2.5	38
	5	450	10.0	VACUUM	H	2.5	25

(*) PACKETS A: 66x40x300 B: 66x40x350 C: 66x78x300 D: 66x78x350 E: 66x78x450
VACUUM F: 67x31x300 G: 67x31x350 H: 67x31x450

DIM. BOX (*2)	PACKETS PER BOX	BOX NET WEIGHT (kg)(~)	PIECES PER BOX (~)	BOXES PER PALLET	PALLET NET WEIGHT (kg)(~)	PIECES PER PALLET (~)
C	3	15.9	240	54	859	12,960
C	3	15.0	150	54	810	8,100
A	6	12.0	996	72	864	71,712
B	6	12.0	600	72	864	43,200
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	15.0	318	72	1,080	22,896
B	6	12.0	228	72	864	16,416
B	6	15.0	228	72	1,080	16,416
C	6	15.0	150	54	810	8,100
A	3	12.0	1,050	72	864	75,600
B	3	14.1	720	72	1,015	51,840
B	3	15.0	630	72	1,080	45,360
B	3	15.0	39	72	1,080	2,808
C	3	21.0	420	54	1,134	22,680
B	3	15.0	282	72	1,080	20,304
C	3	16.8	240	54	907	12,960
C	3	15.0	144	54	810	7,776
A	6	12.0	996	72	864	71,712
B	6	12.0	600	72	864	43,200
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	15.0	318	72	1,080	22,896
B	6	12.0	228	72	864	16,416
B	6	15.0	228	72	1,080	16,416
C	6	15.0	150	54	810	8,100

(*2) A: 215x88x330 B: 215x88x380 C: 215x88x480

DIM. PAL: 93x75

ELECTRODES



ELECTRODES

PRODUCT	ø (mm)	L (mm)	PIECES PER KG (~)	PACKAGING	DIM. PACKET (*)	PACKETS NET WEIGHT (kg)(~)	PIECES PER PACKET (~)
INE 57 B CNC	2.5	300	50.0	VACUUM	F	2.0	100
	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	3.2	450	21.0	VACUUM	H	2.5	42
	4	350	19.0	VACUUM	G	2.0	38
	4	450	15.0	VACUUM	H	2.5	38
	5	450	10.0	VACUUM	H	2.5	25
INE 80B	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE A 1	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE AR 150	3.2	450	14.5	PACKET	E	7.0	100
	4	450	10.0	PACKET	E	7.0	70
	5	450	6.3	PACKET	E	7.0	45
INE B2	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE B2 L	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25

(*) PACKETS A: 66x40x300 B: 66x40x350 C: 66x78x300 D: 66x78x350 E: 66x78x450
VACUUM F: 67x31x300 G: 67x31x350 H: 67x31x450

DIM. BOX (*2)	PACKETS PER BOX	BOX NET WEIGHT (kg)(~)	PIECES PER BOX (~)	BOXES PER PALLET	PALLET NET WEIGHT (kg)(~)	PIECES PER PALLET (~)
A	6	12.0	600	72	864	43,200
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	15.0	318	72	1,080	22,896
B	6	12.0	228	72	864	16,416
C	6	15.0	228	54	810	12,312
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
C	6	12.0	324	54	648	17,496
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
C	3	21.0	300	54	1,134	16,200
C	3	21.0	210	54	1,134	11,340
C	3	21.0	135	54	1,134	7,290
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
B	6	15.0	150	72	1,080	10,800

(*2) A: 215x88x330 B: 215x88x380 C: 215x88x480

DIM. PAL: 93x75

ELECTRODES



ELECTRODES

PRODUCT	ø (mm)	L (mm)	PIECES PER KG (~)	PACKAGING	DIM. PACKET (*)	PACKETS NET WEIGHT (kg)(~)	PIECES PER PACKET (~)
INE B3	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE B3 L	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE B6	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE B8	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE B9	2.5	350	42.0	VACUUM	G	2.0	84
	3.2	350	27.0	VACUUM	G	2.0	54
	4	350	19.0	VACUUM	G	2.0	38
	5	450	10.0	VACUUM	H	2.5	25
INE C3	2.5	350	42.0	VACUUM	G	2.0	84
	4	350	27.0	VACUUM	G	2.0	54
	4	350	27.0	VACUUM	G	2.0	54
	5	450	10.0	VACUUM	H	2.5	25
INE GHISA	2.5	300	74.0	PACKET	C	2.0	145
INE MONEL	2.5	300	55.0	VACUUM	F	2.0	110

(*) PACKETS A: 66x40x300 B: 66x40x350 C: 66x78x300 D: 66x78x350 E: 66x78x450
VACUUM F: 67x31x300 G: 67x31x350 H: 67x31x450

DIM. BOX (*2)	PACKETS PER BOX	BOX NET WEIGHT (kg)(~)	PIECES PER BOX (~)	BOX PER PALLET	PALLET NET WEIGHT (kg)(~)	PIECES PER PALLET (~)
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
B	6	15.0	150	72	1,080	10,800
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
B	6	12.0	228	72	864	16,416
C	6	15.0	150	54	810	8,100
B	6	12.0	504	72	864	36,288
B	6	12.0	324	72	864	23,328
C	6	12.0	324	54	648	17,496
C	6	15.0	150	54	810	8,100
A	3	6.0	435	72	432	31,320
A	6	12.0	660	72	864	47,520

(*2) A: 215x88x330 B: 215x88x380 C: 215x88x480

DIM. PAL: 93x75

ELECTRODES



ELECTRODES

PRODUCT	ø (mm)	L (mm)	PIECES PER KG (~)	PACKAGING	DIM. PACKET (*)	PACKETS NET WEIGHT (kg)(~)	PIECES PER PACKET (~)
INE MONEL	3.2	350	30.0	VACUUM	G	2.0	60
INE NICHEL	2.5	350	47.0	VACUUM	G	2.0	94
	3.2	350	32.0	VACUUM	G	2.0	64
INE NI-FE	2.5	300	62.0	VACUUM	F	2.0	124
	3.2	350	32.0	VACUUM	G	2.0	64
	4	350	21.0	VACUUM	G	2.0	42
INE RB 86	2.5	350	50.0	VACUUM	G	2.0	95
	3.2	350	30.0	VACUUM	G	2.0	60
	4	350	19.0	VACUUM	G	2.0	38
	3.2	450	24.0	VACUUM	G	2.0	48
INE RD 600	2.5	300	50.0	PACKET	C	4.8	240
	3.2	350	27.0	PACKET	D	5.0	135
	3.2	450	21.0	PACKET	E	6.7	140
	4	450	15.0	PACKET	E	5.3	80
	5	450	10.0	PACKET	E	5.0	50
INE SUPER	2	300	90.0	PACKET	C	5.0	450
	2	350	75.0	PACKET	D	5.0	370
	2.5	350	54.0	PACKET	D	5.0	270
	3.2	350	35.0	PACKET	D	5.0	175
	4	350	23.0	PACKET	D	5.0	115
	1.6	300	140.0	PACKET	A	2.5	350
	2	300	90.0	PACKET	A	2.5	225
	2	350	75.0	PACKET	B	2.5	188
	2.5	350	54.0	PACKET	B	2.5	135
	3.2	350	35.0	PACKET	B	2.5	88
	4	350	23.0	PACKET	B	2.5	58

(*) PACKETS A: 66x40x300 B: 66x40x350 C: 66x78x300 D: 66x78x350 E: 66x78x450
VACUUM F: 67x31x300 G: 67x31x350 H: 67x31x450

DIM. BOX (*2)	PACKETS PER BOX	BOX NET WEIGHT (kg)(~)	PIECES PER BOX (~)	BOX PER PALLET	PALLET NET WEIGHT (kg)(~)	PIECES PER PALLET (~)
B	6	12.0	360	72	864	25,920
B	6	12.0	564	72	864	40.608
B	6	12.0	384	72	864	27.648
A	6	12.0	744	72	864	53.568
B	6	12.0	384	72	864	27.648
B	6	12.0	252	72	864	18,144
B	6	12.0	12	72	864	864
B	6	12.0	12	72	864	864
B	6	12.0	12	72	864	864
B	6	12.0	12	72	864	864
B	3	14.4	14	72	1,037	1,037
B	3	15.0	15	72	1,080	1,080
C	3	20.1	20	54	1,085	1,085
C	3	15.9	16	54	859	859
C	3	15.0	15	54	810	810
A	3	15.0	15	72	1,080	1,080
B	3	15.0	15	72	1,080	1,080
B	3	15.0	15	72	1,080	1,080
B	3	15.0	15	72	1,080	1,080
B	3	15.0	15	72	1,080	1,080
A	6	15.0	2,100	72	1,080	151,200
A	6	15.0	1,350	72	1,080	97,200
B	6	15.0	1,128	72	1,080	81,216
B	6	15.0	810	72	1,080	58,320
B	6	15.0	528	72	1,080	38,016
B	6	15.0	348	72	1,080	25,056

(*2) A: 215x88x330 B: 215x88x380 C: 215x88x480

DIM. PAL: 93x75

ELECTRODES

[illegible]

PACKAGING
BLISTER



TUBES

BLISTER

PRODUCT	ø (mm)	L (mm)	PACKAGING	PIECES PER BLISTER (~)	DIM. BOX (*)	BLISTERS PER BOX	PIECES PER BOX	BOXES PER PALLET
INE 45	1.6	300	BLISTER	20	A	25	500	54
	2.0	300	BLISTER	25	A	25	625	54
	2	300	BLISTER	50	A	25	1250	54
	2.5	300	BLISTER	50	A	25	1250	54
	2.5	300	BLISTER	14	A	25	350	54
INE NI-FE	2.5	300	BLISTER	11	A	25	275	54
	3.2	350	BLISTER	9	A	25	225	54
INE SUPER	1.6	300	BLISTER	20	A	25	500	54
	2.0	350	BLISTER	25	A	25	625	54
	2.0	350	BLISTER	50	A	12	600	54
	2.5	350	BLISTER	14	A	25	350	54
	2.5	350	BLISTER	50	A	10	500	54
	3.2	350	BLISTER	9	A	25	225	54
	3.2	350	BLISTER	55	A	10	550	54
	4.0	350	BLISTER	6	A	25	150	54
	2.0	300	BLISTER	12	A	25	300	54
INOX 308 RLC	2.5	300	BLISTER	10	A	25	250	54
	3.2	350	BLISTER	8	A	25	200	54
INOX 312 R	2.0	300	BLISTER	12	A	25	300	54
	2.5	300	BLISTER	10	A	25	250	54
	3.2	350	BLISTER	8	A	25	200	54
INOX 316 RLC	2.0	300	BLISTER	12	A	25	300	54
	2.5	300	BLISTER	10	A	25	250	54
	3.2	300	BLISTER	8	A	25	200	54

TUBES

PRODUCT	ø (mm)	L (mm)	PCS-KG (~)	PACKAG-ING	NET TUBE WEIGHT (kg)(~)	PIECES PER TUBE	DIM. BOX (*)	TUBE per BOX	PIEC-ES per BOX	NET WEIGHT	BOX per PAL	PALLET NET WEIGHT (~)
INE AL.5%	2.5	350	111	TUBE	2	222	B	4	888	8	72	576
	3.2	350	75	TUBE	2	149	B	4	596	8	72	576
INOX 307	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	75	B	4	300	10	72	720
	4	350	20	TUBE	2.5	50	B	4	200	10	72	720
INOX 308 RLC	2	300	89	TUBE	2.5	230	A	4	920	10	72	720
	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	75	B	4	300	10	72	720
	4	350	20	TUBE	2.5	50	B	4	200	10	72	720
INOX 309 RLC	2	300	89	TUBE	2.5	230	A	4	920	10	72	720
	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	75	B	4	300	10	72	720
	4	350	19	TUBE	2.5	50	B	4	200	10	72	720
INOX 310 R	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	70	B	4	280	10	72	720
	4	350	20	TUBE	2.5	50	B	4	200	10	72	720
INOX 312 R	2	300	89	TUBE	2.5	140	A	4	560	10	72	720
	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	75	B	4	300	10	72	720
	4	350	20	TUBE	2.5	50	B	4	200	10	72	720
INOX 316 RLC	2	300	89	TUBE	2.5	230	A	4	920	10	72	720
	2.5	300	55	TUBE	2.5	140	A	4	560	10	72	720
	3.2	350	29	TUBE	2.5	75	B	4	300	10	72	720
	4	350	20	TUBE	2.5	50	B	4	200	10	72	720

GENERAL INFORMATION AND TABLES

SOLID WIRES

EN ISO 14341-A
FILLER MATERIALS FOR CONTINUOUS WIRE WELDING UNDER GAS PROTECTION OF FINE GRAIN NON-ALLOY STEEL



G464M213Si1

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGA-TION, %
35	355	410-780	22
38	380	470-600	20
42	420	500-640	20
46	460	530-680	20
50	500	560-720	18

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE THOUGHNESS ENERGY OF 47J, °C
Z	no requirement
A	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60
7	-70
8	-80
9	-90
10	-100

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %											
	C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Al	Ti + Zr
2Si	0.06 -0.14	0.9-1.3	0.50-0.80	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.02	0.15
3Si1	0.06 -0.14	1.30-1.60	0.70-1.00	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.02	0.15
3Si2	0.06 -0.14	1.30-1.60	1.00-1.30	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.02	0.15
4Si1	0.06 -0.14	1.60-1.90	0.80-1.20	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.02	0.15
2Ti	0.04-0.14	0.90-1.40	0.40-0.80	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.05-0.20	0.05-0.25
2Al	0.08-0.14	0.90-1.30	0.30-0.50	0.025	0.025	0.15	0.15	0.15	0.03	0.35	0.35-0.75	0.15
3Ni1	0.06-0.14	1.00-1.60	0.50-0.90	0.02	0.02	0.80-1.50	0.15	0.15	0.03	0.35	0.02	0.15
2Ni2	0.06-0.14	0.80-1.40	0.40-0.80	0.02	0.02	2.10-2.70	0.15	0.15	0.03	0.35	0.02	0.15
2Mo	0.08-0.12	0.90-1.30	0.30-0.70	0.02	0.02	0.15	0.15	0.40-0.60	0.03	0.35	0.02	0.15
4Mo	0.06-0.14	1.70-2.10	0.50-0.80	0.025	0.025	0.15	0.15	0.40-0.60	0.03	0.35	0.02	0.15
Z	any other agreed composition											

NOTE 1 = The individual values indicate maximum values

SYMBOL FOR PROTECTIVE GAS

SYMBOL	
M12	Ar - O2
M13	Ar - O2
M20	Ar - CO2
M21	Ar - CO2
C1	CO2
Z	Not specified

NOTE1= Symbol in agreement with ISO 14175

SOLID WIRES

AWS A5.18
SPECIFICATION FOR WIRE AND TIG RODS FOR WELDING UNDER PROTECTIVE GAS OF CARBON STEEL

ER70S-6

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	MINIMUM TENSILE STRENGTH MPa
70	400 (58 000 psi)	515 (75 000 psi)

TYPE OF WIRE

SYMBOL	
S	Solid wire
C	Flux cored wire

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %												
	C	Mn	Yes	P	S	Ni	Cr	Mo	V	Ti	Zr	Al	Cu
ER70S-2	0.07	0.90-1.40	0.40-0.70	0.025	0.035	0.15	0.15	0.15	0.03	0.05-0.15	0.02-0.12	0.05-0.15	0.50
ER70S-3	0.06-0.15	0.90-1.40	0.45-0.75	0.025	0.035	0.15	0.15	0.15	0.03	-	-	-	0.50
ER70S-4	0.06-0.15	1.00-1.50	0.65-0.85	0.025	0.035	0.15	0.15	0.15	0.03	-	-	-	0.50
ER70S-6	0.06-0.15	1.40-1.85	0.80-1.15	0.025	0.035	0.15	0.15	0.15	0.03	-	-	-	0.50
ER70S-7	0.07-0.15	1.50-2.00	0.50-0.80	0.025	0.035	0.15	0.15	0.15	0.03	-	-	-	0.50
ER70S-8	-	1.40-1.90	0.55-1.10	0.025	0.035	0.15	0.15	0.15	0.03	-	-	-	0.50

GENERAL INFORMATION AND TABLES

SOLID WIRES

EN ISO 16384-A

FILLER MATERIALS FOR CONTINUOUS WIRE WELDING UNDER GAS PROTECTION OF HIGH STRENGTH STEEL



G 69 4 M21 Mn3Ni1CrMo

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGA-TION, %
55	550	640-820	18
62	620	700-890	18
69	690	770-940	17
79	790	880-1080	16
89	890	940-1180	15

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE TOUGHNESS ENERGY OF 47J, °C
Z	no requirement
A	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %										
	C	Mn	Yes	P	S	Ni	Cr	Mo	V	Cu	Other
Mn3NiCrMo	0.14	1.30-1.80	0.60-0.80	0.015	0018	0.50-0.65	0.40-0.65	0.15-0.30	0.03	0.30	0.25
Mn3Ni1CrMo	0.12	1.30-1.80	0.40-0.70	0015	0018	1.20-1.60	0.20-0.40	0.20-0.30	0.05-0.13	0.35	0.25
Mn3Ni1Mo	0.12	1.30-1.90	0.40-0.80	0015	0018	0.80-1.30	0.15	0.25-0.65	0.03	0.30	0.25
Mn3Ni1.5Mo	0.08	1.30-1.80	0.20-0.60	0015	0018	1.40-2.10	0.15	0.25-0.65	0.03	0.30	0.25
Mn3Ni1Cu	0.12	1.20-1.80	0.20-0.60	0015	0018	0.80-1.25	0.15	0.20	0.03	0.30-0.65	0.25
Mn3Ni1MoCu	0.12	1.20-1.80	0.20-0.60	0015	0018	0.80-1.25	0.15	0.20-0.55	0.03	0.30-0.65	0.25
Mn3Ni2.5CrMo	0.12	1.30-1.80	0.40-0.70	0015	0018	2.30-2.80	0.20-0.60	0.30-0.65	0.03	0.30	0.25
Mn4Ni1Mo	0.12	1.60-2.10	0.50-0.80	0015	0018	0.80-1.25	0.15	0.20-0.55	0.03	0.30	0.25
Mn4Ni2Mo	0.12	1.60-2.10	0.25-0.60	0015	0018	2.00-2.60	0.15	0.30-0.65	0.03	0.30	0.25
Mn4Ni1.5CrMo	0.12	1.60-2.10	0.50-0.80	0015	0018	1.30-1.90	0.15-0.40	0.30-0.65	0.03	0.30	0.25
Mn4Ni2CrMo	0.12	1.60-2.10	0.60-0.90	0015	0018	1.80-2.30	0.20-0.45	0.45-0.70	0.03	0.30	0.25
Mn4Ni2.5CrMo	0.13	1.60-2.10	0.50-0.80	0015	0018	2.30-2.80	0.20-0.60	0.30-0.65	0.03	0.30	0.25
Z	any other agreed composition										

NOTE 1 = The individual values indicate maximum values

SYMBOL FOR PROTECTIVE GAS

SYMBOL	
M12	Ar - O2
M13	Ar - O2
M20	Ar - CO2
M21	Ar - CO2
C1	CO2
Z	Not specified

NOTE1= Symbol in agreement with ISO 14175

SOLID WIRES

AWS A5.28

SPECIFICATION FOR WIRE AND TIG RODS FOR WELDING UNDER PROTECTIVE GAS OF LOW ALLOY STEEL

ER 80 S - B2

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa
70	400 (58 000 psi)	515 (75 000 psi)
80	470 (68 000 psi)	550 (80 000 psi)
90	540 (78 000 psi)	620 (90 000 psi)
100	610 (88 000 psi)	690 (100 000 psi)
110	660 (95 000 psi)	760 (110 000 psi)
120	750 (108 000 psi)	830 (120 000 psi)

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %													
	C	Mn	Yes	P	S	Ni	Cr	Mo	V	Ti	Zr	Al	Cu	Others
ER70S-A1	0.12	1.30	0.30-0.70	0.25	0.25	0.20	-	0.40-0.65	-	-	-	-	0.35	0.50
ER80S-B2	0.07-0.12	0.40-0.70	0.40-0.70	0.25	0.25	0.20	1.20- 1.50	0.40-0.65	-	-	-	-	0.35	0.50
ER70S-B2L	0.05	0.40-0.70	0.40-0.70	0.25	0.25	0.20	1.20- 1.50	0.40-0.65	-	-	-	-	0.35	0.50
ER90S-B3	0.07-0.12	0.40-0.70	0.40-0.70	0.25	0.25	0.20	2.30- 2.70	0.40-0.65	-	-	-	-	0.35	0.50
ER80S-B3L	0.05	0.40-0.70	0.40-0.70	0.25	0.25	0.20	2.30- 2.70	0.90-1.20	-	-	-	-	0.35	0.50
ER80S-B6	0.10	0.40-0.70	0.50	0.25	0.25	1.00	4.50- 6.00	0.45-0.65	-	-	-	-	0.35	0.50
ER80S-B8	0.10	0.40-0.70	0.50	0.25	0.25	0.50	8.00-10.50	0.80-1.20	-	-	-	-	0.35	0.50
ER90S-B91	0.07-0.13	1.20	0.15- 0.50	0.10	0.10	1.20	8.00-10.50	0.85-1.20	0.15-0.30	-	-	0.04	0.20	0.50
ER80S-Ni1	0.12	1.25	0.40- 0.80	0.25	0.25	0.80- 1.10	0.15	0.35	0.05	-	-	-	0.35	0.50
ER80S-Ni2	0.12	1.25	0.40- 0.80	0.25	0.25	2.00- 2.75	-	-	-	-	-	-	0.35	0.50
ER80S-Ni3	0.12	1.25	0.40- 0.80	0.25	0.25	3.00- 3.75	-	-	-	-	-	-	0.35	0.50
ER80S-D2	0.07-0.12	1.60- 2.10	0.50- 0.80	0.25	0.25	0.15	-	0.40- 0.60	-	-	-	-	0.50	0.50
ER90S-D2	0.07-0.12	1.60- 2.10	0.50- 0.80	0.25	0.25	0.15	-	0.40- 0.60	-	-	-	-	0.50	0.50
ER100S-1	0.08	1.25- 1.80	0.20- 0.55	0.10	0.10	1.40- 2.10	0.30	0.25- 0.55	0.05	0.10	0.10	0.10	0.25	0.50
ER110S-1	0.09	1.40- 1.80	0.20- 0.55	0.10	0.10	1.90- 2.60	0.50	0.25- 0.55	0.04	0.10	0.10	0.10	0.25	0.50
ER120S-1	0.10	1.40- 1.80	0.25- 0.60	0.10	0.10	2.00- 2.80	1.00	0.30- 0.65	0.03	0.10	0.10	0.10	0.25	0.50

TYPE OF WIRE

SYMBOL	
S	Solid wire
C	Cored wire

GENERAL INFORMATION AND TABLES

CORED WIRES

EN ISO 17632-A

FILLER MATERIALS FOR WELDING TUBULAR CORED WIRE FOR ARC WELDING, WITH OR WITHOUT PROTECTIVE GAS OF FINE GRAIN ALLOY STEEL



T 46 2 1Ni P M21 1 H5

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGATION, %
35	350	440-570	22
38	380	470-600	20
42	420	500-640	20
46	460	530-680	20
50	500	560-720	18

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE TOUGHNESS ENERGY OF 47J, °C
Z	no requirement
A	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60
7	-70
8	-80
9	-90
10	-100

SYMBOL FOR CHEMICAL COMPOSITION OF PURE FILLER

SYMBOL	CHEMICAL COMPOSITION, mass %											
	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu	Nb	Al
no symbol	-	-	2.0	-	-	0.5	0.2	0.2	0.08	0.30	0.05	2.0
Mo	-	-	1.4	-	-	0.5	0.2	0.3-0.6	0.08	0.30	0.05	2.0
MnMo	-	-	1.4-2.0	-	-	0.5	0.2	0.3-0.6	0.08	0.30	0.05	2.0
1Ni	-	0.80	1.4	-	-	0.6-1.2	0.2	0.2	0.08	0.30	0.05	2.0
1.5Ni	-	-	1.6	-	-	1.2-1.8	0.2	0.2	0.08	0.30	0.05	2.0
2Ni	-	-	1.4	-	-	1.8-2.6	0.2	0.2	0.08	0.30	0.05	2.0
3Ni	-	-	1.4	-	-	2.6-3.8	0.2	0.2	0.08	0.30	0.05	2.0
Mn1Ni	-	-	1.4-2.0	-	-	0.6-1.2	0.2	0.2	0.08	0.30	0.05	2.0
1NiMo	-	-	1.4	-	-	0.6-1.2	0.2	0.3-0.6	0.08	0.30	0.05	2.0
Z	any other agreed composition											

NOTE 1 = The individual values indicate maximum values

SYMBOL FOR DIFFUSIBLE HYDROGEN

SYMBOL	MAXIMUM HYDROGEN CONTENT IN METAL DEPOSITED, ml/100g
H 5	5
H 10	10
H 15	15

SYMBOL FOR WELDING POSITION

WELDING POSITIONS ACCORDING TO ISO 6947	
1 - PA, PB, PC, PD, PE, PF, PG	
2 - PA, PB, PC, PD, PE, PF	
3 - PA, PB	
4 - PA	
5 - PA, PB, PG	

NOTE1= Welding positions in agreement with ISO 6947

SYMBOL FOR PROTECTIVE GAS

SYMBOL	
M12	Ar - O2
M13	Ar - O2
M20	Ar - CO2
M21	Ar - CO2
C1	CO2
Z	Not specified

NOTE1= Symbol in agreement with ISO 14175

SYMBOL FOR TYPE OF ELECTRODE CORE

SYMBOL	CHARACTERISTICS	WELDING PROCESS	PROTECTIVE GAS
R	Rutile, slow cooling slag	Single pass and multipass	Yes
P	Rutile, fast cooling slag	Single pass and multipass	Yes
B	Basic	Single pass and multipass	Yes
M	Metal powder	Single pass and multipass	Yes
V	Rutile or Basic/with fluorides	Single pass	No
W	Basic/with fluorides, slow cooling slag	Single pass and multipass	No
Y	Basic/with fluorides, fast cooling slag	Single pass and multipass	No
Z	Other type		

ELECTRODES

EN ISO 2560-A

COATED ELECTRODES FOR MANUAL ARC WELDING OF NON-ALLOY STEEL AND WITH FINE GRAIN

E 46 3 1Ni B 5 4 H5

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGATION, %
35	355	410-780	22
38	380	470-600	20
42	420	500-640	20
46	460	530-680	20
50	500	560-720	18

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE TOUGHNESS ENERGY OF 47J, °C
Z	no requirement
A	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60

SYMBOL FOR CHEMICAL COMPOSITION OF PURE FILLER

SYMBOL	CHEMICAL COMPOSITION, mass %		
	Mn	Mo	Ni
no symbol	2.0	-	-
Mo	1.4	0.3-0.6	-
MnMo	1.4-2.0	0.3-0.6	-
1Ni	1.4	-	0.6-1.2
2Ni	1.4	-	1.8-2.6
3Ni	1.4	-	2.6-3.8
Mn1Ni	1.4-2.0	-	0.6-1.2
Mn2Ni	1.4-2.0	-	1.2-2.6
1NiMo	1.4	0.3-0.6	0.6-1.2
Z	any other agreed composition		

NOTE 1 = The individual values indicate maximum values

SYMBOL FOR DIFFUSIBLE HYDROGEN

SYMBOL	MAXIMUM HYDROGEN CONTENT IN METAL DEPOSITED, ml/100g
H5	5
H10	10
H15	15

SYMBOL FOR WELDING POSITION

WELDING POSITIONS ACCORDING TO ISO 6947	
1 - PA, PB, PC, PD, PE, PF, PG	
2 - PA, PB, PC, PD, PE, PF	
3 - PA, PB	
4 - PA	
5 - PA, PB, PG	

NOTE1= Welding positions in agreement with ISO 6947

SYMBOL FOR ELECTRODE YIELD AND TYPE OF CURRENT

SYMBOL	DEPOSIT EFFICIENCY	TYPE OF CURRENT
1	<105	AC + DC
2	<105	DC
3	>105 <125	AC + DC
4	>105 <125	DC
5	>125 <160	AC + DC
6	>125 <160	DC
7	>160	AC + DC
8	>160	DC

NOTE1 AC = alternating current , DC = direct current

SYMBOL FOR COATING TYPE

SYMBOL	
A	Acid
C	Cellulose
R	Rutile
PM	Rutile-Cellulose
RA	Rutile-Acid
RB	Rutile-Basic
RR	Rutile, large coating
B	Basic

GENERAL INFORMATION AND TABLES

SAW

EN ISO 14171-A
COMBINATION OF ELECTRODE WIRE/FLUX AND DEPOSIT OF ALL FILLER METAL



S385AB S2Si

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGATION, %
35	355	440-570	22
38	380	470-600	20
42	420	500-640	20
46	460	530-680	20
50	500	560-720	18

SYMBOL FOR CHEMICAL COMPOSITION OF FLUX

SYMBOL	
MS	Manganese-silicate
CS	Calcium-silicate
ZS	Zirconium-silicate
RS	Rutile-silicate
AR	Aluminate-rutile
AB	Aluminate-basic
AS	Aluminate-silicate
AF	Aluminate-fluoride-basic
FB	Fluoride-basic
GS	Magnesium-silicate
Z	Any other composition

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE TENSILE ENERGY OF 47J, °C
Z	no requirement
A	20
0	0
2	-20
3	-30
4	-40
5	-50
6	-60
7	-70
8	-80

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %						
	C	Yes	Mn	Ni	Mo	Cr	Other
SZ							
S1	0.05-0.15	0.15	0.35-0.60	0.15	-0.15	-0.15	
S2	0.07-0.15	0.15	0.80-1.30	-0.15	-0.15	-0.15	
S3	0.07-0.15	0.15	1.30-1.75	-0.15	-0.15	-0.15	
S4	0.07-0.15	0.15	1.75-2.25	-0.15	-0.15	-0.15	
S1Si	0.07-0.15	0.15-0.40	0.35-0.60	-0.15	-0.15	-0.15	
S2Si	0.07-0.15	0.15-0.40	0.80-1.30	-0.15	-0.15	-0.15	
S2Si2	0.07-0.15	0.40-0.60	0.80-1.20	-0.15	-0.15	-0.15	
S3Si	0.07-0.15	0.15-0.40	1.30-1.85	-0.15	-0.15	-0.15	
S4Si	0.07-0.15	0.15-0.40	1.85-2.25	-0.15	-0.15	-0.15	
S1Mo	0.05-0.15	0.05-0.25	0.35-0.60	-0.15	0.45-0.65	-0.15	
S2Mo	0.07-0.15	0.05-0.25	0.80-1.30	-0.15	0.45-0.65	-0.15	
S2MoTiB	0.05-0.15	0.15-0.35	1.00-1.35	-	0.40-0.65	-	
S3Mo	0.07-0.15	0.05-0.25	1.30-1.75	-0.15	0.45-0.65	-0.15	
S4Mo	0.07-0.15	0.05-0.25	1.75-2.25	-0.15	0.45-0.65	-0.15	
S2Ni1	0.07-0.15	0.05-0.25	0.80-1.30	0.80-1.20	-0.15	-0.15	
S2Ni1.5	0.07-0.15	0.05-0.25	0.80-1.30	1.20-1.80	-0.15	-0.15	
S2Ni2	0.07-0.15	0.05-0.25	0.80-1.30	1.80-2.40	-0.15	-0.15	
S2Ni3	0.07-0.15	0.05-0.25	0.80-1.30	2.80-3.70	-0.15	-0.15	
S2Ni1Mo	0.07-0.15	0.05-0.25	0.80-1.30	0.80-1.20	0.45-0.65	-0.20	
S3Ni1.5	0.07-0.15	0.05-0.25	1.30-1.70	1.20-1.80	-0.15	-0.20	
S3Ni1Mo	0.07-0.15	0.05-0.25	1.30-1.80	0.80-1.20	0.45-0.65	-0.20	
S3Ni1Mo0.2	0.07-0.15	0.10-0.35	1.20-1.60	0.80-1.20	0.15-0.30	-0.15	P, S: -0.015
S3Ni1.5Mo	0.07-0.15	0.05-0.25	1.20-1.80	1.20-1.80	0.30-0.50	-0.20	
S2Ni1Cu	0.06-0.12	0.15-0.35	0.70-1.20	0.65-0.90	0.15	-0.40	Cu 0.40-0.65
S3Ni1Cu	0.05-0.15	0.15-0.40	1.20-1.70	0.60-1.20	0.15	-0.15	Cu 0.30-0.60

SAW

AWS A5.17
SPECIFICATION FOR WIRE AND FLUX FOR SUBMERGED ARC WELDING OF CARBON STEEL

F7A5-EM12K

SYMBOL OF RESISTANCE AND ELONGATION OF PURE FILLER

SYMBOL	MINIMUM YIELD STRENGTH, MPa	TENSILE STRENGTH, MPa	MIN ELONGATION, %
6	330	415-550	22
7	340	480-650	20

SYMBOL THAT SPECIFIES STATUS OF MATERIAL AFTER WELDING

SYMBOL	
A	As Welded
P	PWHT 620°C/1h

SYMBOL FOR IMPACT PROPERTIES OF PURE FILLER

SYMBOL	TEMPERATURE FOR THE MINIMUM AVERAGE TENSILE ENERGY OF 27J, °C
Z	no requirement
2	-18
3	-29
4	-40
5	-46
6	-51
8	-62

SYMBOL FOR CHEMICAL COMPOSITION OF WIRE

SYMBOL	CHEMICAL COMPOSITION, mass %						
	C	Mn	Si	S	P	Cu(4)	Ti
LOW MANGANESE WIRES							
EL8	0.1	0.25/0.60	0.07	0.03	0.03	0.35	-
EL8K	0.1	0.25/0.60	0.10/0.25	0.03	0.03	0.35	-
EL12	0.04/0.14	0.25/0.60	0.1	0.03	0.03	0.35	-
MEDIUM MANGANESE WIRES							
EM11K	0.07/0.15	1.00/1.50	0.65/0.85	0.03	0.025	0.35	-
EM12	0.06/0.15	0.80/1.25	0.1	0.03	0.03	0.35	-
EM12K	0.05/0.15	0.80/1.25	0.10/0.35	0.03	0.03	0.35	-
EM13K	0.06/0.16	0.90/1.40	0.35/0.75	0.03	0.03	0.35	-
EM14K	0.06/0.19	0.90/1.40	0.35/0.75	0.025	0.025	0.35	0.03/0.17
EM15K	0.10/0.20	0.80/1.25	0.10/0.35	0.03	0.03	0.35	-
HIGH MANGANESE WIRES							
EH10K	0.07/0.15	1.30/1.70	0.05/0.25	0.025	0.025	0.35	-
EH11K	0.07/0.15	1.40/1.85	0.80/1.15	0.03	0.03	0.35	-
EH12K	0.06/0.15	1.50/2.00	0.20/0.65	0.025	0.025	0.35	-
EH14	0.10/0.20	1.70/2.20	0.1	0.03	0.03	0.35	-

NOTE 1 = The individual values indicate maximum values



S A AB 1 67 AC H5

SYMBOL FOR FLUX PRODUCTION METHOD

SYMBOL	
F	Fused flux
A	Agglomerate flux
M	Mixed flux

SYMBOL FOR CHEMICAL COMPOSITION OF FLUX

SYMBOL	
MS	Manganese-silicate
CS	Calcium-silicate
ZS	Zirconium-silicate
RS	Rutile-silicate
AR	Aluminate-rutile
AB	Aluminate-basic
AS	Aluminate-silicate
AF	Aluminate-fluoride-basic
FB	Fluoride-basic
GS	Magnesium-silicate
Z	Any other composition

APPLICATION

SYMBOL	
1	Submerged arc welding of carbon steel and low alloy steel.
2 or 2B	(2) Flux for welding and facing of stainless steel and creep resistant steel. Cr and Cr-Ni steel and/or Nickel alloys. (2B) indicates flows for facing with strip fillers.
3	Flux for hardfacing with the addition of C, Cr and Mo to filler metal.
4	Other flux not in class 1-3.

SYMBOL FOR CURRENT TYPE

SYMBOL	
AC	Alternating current and direct current
DC	Exclusively direct current

SYMBOL FOR METALLURGY REACTIVITY OF FLUX

SYMBOL (SEQUENCE: Si, Mn)	METALLURGY ACTION	FLUX CONTRIBUTION
1	Burn-out	>0.7
2	Burn-out	0.5-0.7
3	Burn-out	0.3-0.5
4	Burn-out	0.1-0.3
5	Neutral	0.0-0.1
6	Pick-up	0.1-0.3
7	Pick-up	0.3-0.5
8	Pick-up	0.5-.07
9	Pick-up	>0.7

SYMBOL FOR DIFFUSIBLE HYDROGEN

SYMBOL	MAXIMUM HYDROGEN CONTENT IN METAL DEPOSITED, ML/100G
H5	5
H10	10
H15	15



Your welding power

The images outlined are added for illustrative purposes. They are purely by way of example and do not constitute a contractual element.



Your welding power

Scan QR Code and find out more.



INE SpA

Via Facca, 10 - 35013 Cittadella (PD) Italy

T. +39 049 94 81 111

F. +39 049 94 00 249

ine@ine.it / www.ine.it

Distributed by:

