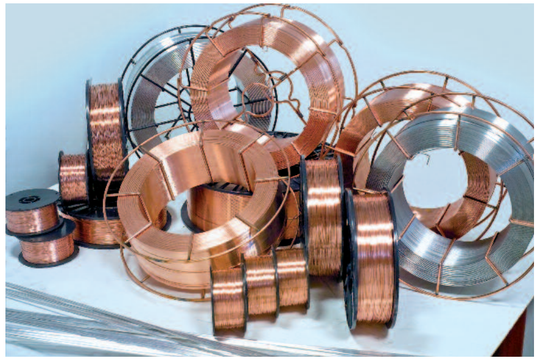


Packing

Din 100	D200	D300	S300	K300
700 gr – 1 kg	5 kg	15 -20 kg	sndwik 15–18 kg	15 –18 kg

Standard pack – 50 kg
Standard pack – 100 kg
Standard pack – 250 kg
Standard pack – 350 kg
Standard pack – 450 kg
Eco pack – 250 kg

Palett

Dimension		
	93 x 93	2 VIE
	120 x 80	4 VIE
	120 x 80	4 VIE EUR
	120 x 93	4 VIE
	72 x 96	4 VIE

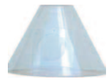
No. Boxes	
	72
	50
	56
	72
	72

Weight kg (15 kg reels)	
	1080
	750
	840
	1080
	1080

Heigh cm	
	94
	74
	74
	74
	124

Accessories

Plastic dome for 250 kg drum
Diameter 510 mm

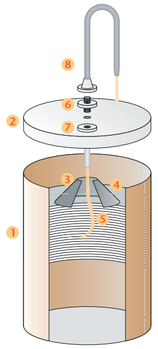


Flexible hose
Connecting the dome to the welding unit
Internal diameter: 3.5 and 5.5 mm
lenght: 3.5 and 5.5 mm
On request, it is also avaible in the following size

Fillet for connection hose

Warning

Descripton



Eco pack

1. Drum
2. Cover
3. Internal pirced cone
4. Stick
5. Wire
6. Nut
7. Lock nut
8. Liner

Directions for use

- Let the wire crossing the cone from the internal after removing the stick lock cone.
- Unwind the wire for some metres, pierce the middle of the cover, put the nut on little hole from the outside and the lock nut from the inside.
- Fix the liner on the nut and fush wire in the nut/liner before closing the cover.

Eco-pack

- Ecologic because it is completly recyclabe.
- Easy handling packing (each drum on a mini-pallet).
- Innovative winding of wire.
- No wire crossing.

Advantages

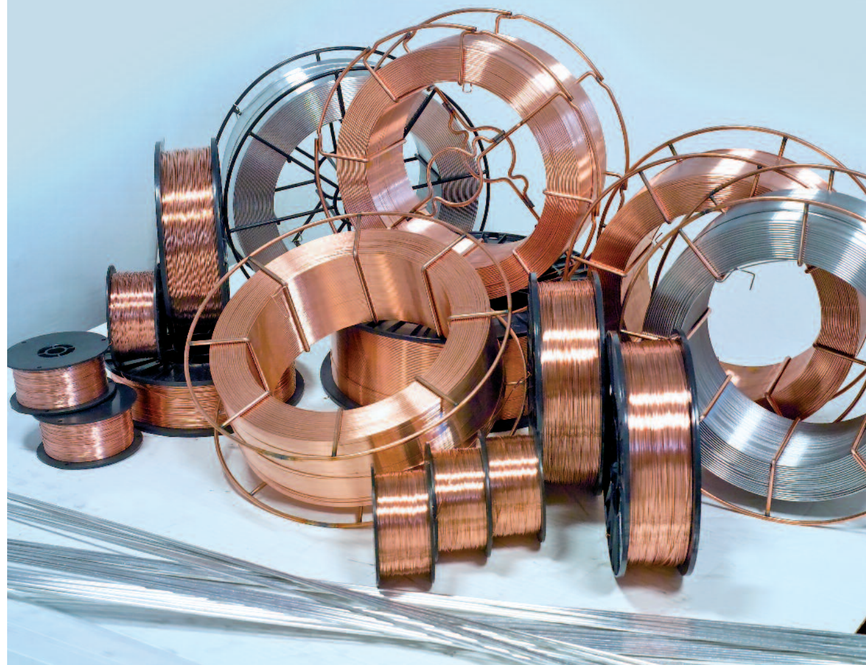
- No need plastic dones.
- Wire without torsion and helix.
- Regular slide in the nozzle (incrase life of the nozzle).
- Storage optimization.

Accessories

- Conduit of min 5.5 mt.
- Connection kit.

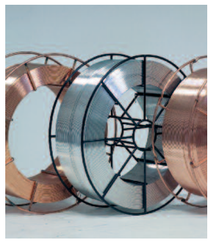
THE LINDE GROUP

LINDE Welding Wires



LINDE Welding Wires
Non- and low-alloy steels. Technical Properties

		SG 1	SG 2	SG 3
Classification	EN ISO 14341	G2 Si	G3 Si 1	G4 Si 1
	DIN 8559	SG 1	SG 2	SG 3
	AWS A5.18	ER 70 S-3	ER 70 S-6	ER 70 S-6
Chemical Composition of Wire - %	C	0.06 – 0.14	0.06 – 0.14	0.06 – 0.14
	Si	0.5 – 0.8	0.7 – 1.0	0.8 – 1.2
	Mn	0.9 – 1.3	1.3 – 1.6	1.6 – 1.9
Mechanical Properties (TIG)	Yield Strength (N/mm²)	min. 420	min. 460	min. 500
	Tensile Strength (N/mm²)	500–640	530–680	560–720
	Impact Strength (ISO – V/40°)	min. 47 J	min. 47 J	min. 47 J
	Elongation (L_0=5D_0) (%)		min. 27	min. 25
Welding Parameters and Dimension	Welding Position	All position (PA, PB, PC, PE, PF, PG)		
	Welding wires Ø mm	0.8 (0.9)	0.8 (0.9)	0.8 (0.9)
		1.0	1.0	1.0
		1.2 (1.4)	1.2 (1.4)	1.2 (1.4)
		1.6	1.6	1.6
	Welding wire types:	Coated or Copper free		
Packing	Wire spool	5 kg – 15 kg	5 kg – 15 kg	5 kg – 15 kg
	Drum (Bigpack)	15 Kg	50/250/450/500 kg	50/250/450/500 kg
Applications and Features		S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH	S235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH	S235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH
		P235TR2, P355T2, P235G1TH, P255G1TH	E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH	P235TR1, P355TR1, P235G1TH, P255G1TH
		L210, L290MB	P255NH, P420NH, S255NH, S420N	P235G1TH, P255G1TH
		S255N, S355N, P255NH, P355NH		
		GE200	GE200	GE200
		Welding of thin walled parts	Steel construction and machinery production	Used for the same welding purposes as SG2
		Root pass welding	Welding of ships, boiler tanks, pipe parts	Its resistance is increased by Si-Mn
		For making galvanized coating	Welding of thin walled steels	Low spatter although used under CO_2 atmosphere
		TIG welding of pipes	Thin sheet welding in automotive industry	Excellent wire feeding capability



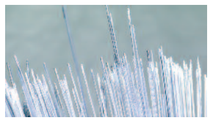
LINDE Welding Wires and rods
Aluminium alloys. Technical Properties

		Linde-Alu 5356 Al Mg 5	Linde-Alu 4043 Al Si 5
Standard		AA 5356	AA4043
		UNI S - Al Mg 5	UNI S – Al Si 5
		BS 2901 Pt. 4 5356	BS 2901 Pt. 4 4043A
		AFNOR AG 5	AFNOR AS 5
		DIN – S Al Mg 5	DIN – S Al Si 5
Chemical Composition of Wire - %	Si	0.2	4.5 - 6
	Fe	0.4	0.6
	Cu	0.1	0.05
	Mn	0.05 - 2	0.05
	Mg	4.5 - 5.5	0.05
	Zn	0.1	0.1
	Ti	0.06 - 0.12	0.02
	Be	0.0008	0.0008
	Cr	0.05 - 0.2	
	Al	rem	rem
	other	0.15	0.15
Mechanical Properties (TIG)	Rm (N/mm²)	275 - 315	105 - 130
	Rp 0.2 (N/mm²)	115 - 140	70 - 90
	A (%)	25 - 35	15 - 20
	Tf (°C)	526 - 633	573 - 625

Wire Ø 0.80 - 0.90 - 1.00 - 1.20 - 1.60

Note: mechanical propetrties of continuous cast redrow rod.

Description



Welding wires and rods for TIG and MIG welding of Aluminium alloys with Magnesium content max 6%. This Magnesium alloyed Aluminium, thanks to its exelent corrosion resistance and its high mechanical properties are used in ship yards, car and railway indrusty.	A Silicon alloyed Aluminium welding wires and rods for TIG and MIG welding laminates, draw pieces, and casting of Al Si alloys with a Silicon content max 6%. Not suitable for anodising. This filler metal has excellent properties of smoothness.

Copper Free
the ecological welding wire

Copper Free is wire for welding under protective gases which strongly reduces the gas emissions in the working environment to is cleaning process.
The wire surface is, in fact, removed from carbon residual elemnts, calcium and sodium streararates and from oil and grease, allowing a perfect consistent adhesion and good boding of the wires coating.

- Smooth feed through the torch liner
- Stable arc voltage with consequent homogeneity of the weld beads
- No fumes due to low impurities
- Increased performance at high amperages
- Less polluting of the working environment