3 **Application sheet**, Linde Welding Wire



Packing

)	Din 100	D200	D300	\$300	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



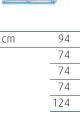
Palett

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	Weight kg (15 kg reels)	1080
	50		750
	56		840
	72		1080
	72		1080



4 Application sheet, Linde Welding Wire

Accessories Plastic dome for 250 kg

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







Fillet for connection hose













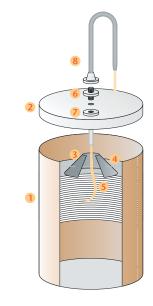








Descripton



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.



LINDE Welding Wires



1 **Application sheet**, Linde Welding Wire



LINDE Welding Wires

Non- and low-alloy steels. Technical Properties

SG 2

SG 3

SG 1

		30 1	3U Z	30 3
Classification	EN ISO 14341	G2 Si	G3 Si 1	G4 Si 1
Classification	DIN 8559	SG 1	SG 2	SG 3
	AWS A5.18	ER 70 S-3	ER 70 S-6	ER 70 S-6
	- NO AO. 10	LK 70 3 3	LK 70 3 0	LK 70 3 0
Chemical Composition of	С	0.06 - 0.14	0.06 - 0.14	0.06 - 0.14
Wire - %	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)	
Sile Difficultion	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 fre	ee	
Packing	Welding wire types: Wire spool		ee 5 kg – 15 kg	5 kg - 15 kg
Packing		Coated or Copper fre	5 kg - 15 kg	5 kg - 15 kg 50/250/450/500 kg
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg	5 kg - 15 kg 50/250/450/500 kg	50/250/450/500 kg
Packing Applications and Features	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg S235, S355, P235GH,	5 kg - 15 kg 50/250/450/500 kg	50/250/450/500 kg S235, S355, E295,
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH,	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH,
	Wire spool	Coated or Copper free 5 kg - 15 kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH	5 kg – 15 kg 50/250/450/500 kg S235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1,	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1,
	Wire spool	5 kg – 15 kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2,	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH,
	Wire spool	5 kg – 15 kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH
	Wire spool	5 kg – 15 kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2,	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH	5 kg - 15 kg 50/250/450/500 kg S235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH P255NH, P420NH, S255NH, S420N	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH
	Wire spool	5 kg – 15 kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH GE200	5 kg - 15 kg 50/250/450/500 kg 5235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH P255NH, P420NH, S255NH, S420N GE200	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355TR1, P235G1TH, P235G1TH P235G1TH, P255G1TH GE200
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH	5 kg - 15 kg 50/250/450/500 kg 5235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH P255NH, P420NH, S255NH, S420N GE200	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH P235G1TH, P255G1TH GE200 Used for the same weld-
	Wire spool	Coated or Copper free 5 kg – 15 kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH GE200 Welding of thin	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355T1, P235TR2, P355T2, P235G1TH, P255NH, P420NH, \$255NH, \$420N GE200 Steel construction and	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH P235G1TH, P255G1TH GE200 Used for the same welding purposes as \$G2 Its resistance is
	Wire spool	5 kg – 15 kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH GE200 Welding of thin walled parts	5 kg - 15 kg 50/250/450/500 kg 5235, S355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235TR2, P355T2, P235G1TH, P255G1TH P255NH, P420NH, S255NH, S420N GE200 Steel construction and machinery production Welding of ships, boil-	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH P235G1TH, P255G1TH P235G1TH, P255G1TH GE200 Used for the same welding purposes as \$G2
	Wire spool	5 kg - 15 kg 15 Kg 15 Kg 15 Kg 15 Kg S235, S355, P235GH, P265GH, P255NH, P295GH, P355GH P235TR2, P355T2, P235G1TH, P255G1TH L210, L290MB S255N, S355N, P255NH, P355NH GE200 Welding of thin walled parts Root pass welding	5 kg - 15 kg 50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH E235, P355T1, P235G1TH, P255G1TH, P255NH, P420NH, S255NH, S420N GE200 Steel construction and machinery production Welding of ships, boiler tanks, pipe parts	50/250/450/500 kg \$235, \$355, E295, E360, P235GH, P265GH, P255NH, P295GH, P355GH P235TR1, P355TR1, P235G1TH, P255G1TH P235G1TH, P255G1TH GE200 Used for the same welding purposes as \$G2 Its resistance is increased by \$i-Mn

2 **Application sheet**, Linde Welding Wire



LINDE Welding Wires and rods Aluminium alloys. Technical Properties

Linde		, .	
		Linde-Alu 5356 Al Mg 5	Linde-Alu 4043 Al Si 5
Standard		AA 5356	AA4043
Standard		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	Si	0.2	4.5 - 6
Wire - %	Fe	0.4	0.6
	Си	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
	CL	0.05 - 0.2	0.0000
	Al	rem	rem
	other	0.15	0.15
	A (%) Tf (°C) Wire Ø 0.80 - 0.90 - 1.00 - Note: mechanical propetrt	25 - 35 526 - 633 - 1.20 - 1.60 ties of continuous cast redrow rod.	15 - 20 573 - 625
Description		Welding wires and rods for TIG	A Silicon alloyed Aluminium
Description		and MIG welding of Aluminium	
		alloys with Magnesium con-	_
		tent max 6%. This Magnesium	
		alloyed Aluminium, thanks to	- '
		its exelent corrosion resistance	
1. 1. Will the May !		and its high mechanical prop-	suitable for anodising. This
		erties are used in ship yards, car and railway indrusty.	filler metal has excellent properties of smoothness.
	Copper Free		
		1. 1. 10.	
	the ecological	l 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 strearates 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

Betting ahead through innovation.

With its innovative concepts, Linde is playing a pioneering role in the global market. As a technology leader, it is our taskto constantly raise the bar. Traditionally driven by entrepreneurship, we are working steadily on new high-quality products and innovative processes.

Linde offers more. We create added value, clearly discernible competitive advantages, and greater pro tability. Each concept is tailored speci cally to meet our customers' requirements – offering standardized as well as customized solutions. This applies to all industries and all companies regardless of their size.

If you want to keep pace with tomorrow's competition, you need a partner by your side for whom top quality, processoptimization, and enhanced productivity are part of daily business. However, we de ne partnership not merely as beingthere for you but being with you. After all, joint activities form the core of commercial success.

Linde – ideas become solutions.