



**PRODUCT**  
CATALOGUE

ISSUE 2

**parweld**

WELDING THE FUTURE



# BE PARWELD PROTECTED

Staying safe and protected is essential when working in any environment, a welding one is no different. Parweld offers a range of hard wearing welding safety equipment ideal for workshop use.



WELDING HOOD

WELDING HELMET

PANTHER LEATHER SLEEVE

PANTHER APRON

PANTHER LEATHER JACKET

PANTHER GAUNTLET

PANTHER LEATHER SPAT



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# WELDING GAUNTLETS



## PANTHER PRO GAUNTLET



### COW GRAIN LEATHER

#### FEATURES

- Fully reinforced palm and thumb
- Reinforced fingers
- Fully Lined
- 1.2mm Leather for durability
- Extra length cuff (180mm)
- A grade leather



4244



313X3X

STOCK CODE	SIZES
P3824-10	10

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 12477:2001
- BS EN 407:2020

## PANTHER PRO LONG SLEEVE GAUNTLET



### COW GRAIN LEATHER

#### FEATURES

- Fully reinforced palm and thumb
- Long sleeve covers whole arm for extra protection
- 'A' grade leather
- 480mm cuff length



4244



313X3X

STOCK CODE	SIZES
P3822-10	10

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 12477:2001
- BS EN 407:2020

# WELDING GAUNTLETS



## PANTHER BLACK MIG GAUNTLET GLOVE



**NEW  
PRODUCT**

### GOAT SKIN SOFT LEATHER

#### FEATURES

- Soft leather construction
- Close fit for maximum control
- Split leather cow hide cuff
- Superior fingertip control
- Superior positional control



4244



313X3X

STOCK CODE	SIZES
P3833-8	8
P3833-9	9
P3833-10	10
P3833-11	11

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 12477:2001
- BS EN 407:2020

## PANTHER GAUNTLET



**NEW  
SIZES**

### COW SPLIT LEATHER

#### FEATURES

- Double Kevlar® stitched
- Reinforced palm and thumb
- 'A' grade leather
- Minimum palm thickness 1.2mm
- Fully lined and fully welted
- Extra length cuff (180mm)



4244



313X3X

STOCK CODE	SIZES
P3825-9	9
P3825-10	10
P3825-11	11

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 12477:2001
- BS EN 407:2020

# WELDING GAUNTLETS



## PANTHER ALUMINISED GAUNTLET



SCAN FOR MORE INFORMATION



### COW SPLIT LEATHER

STOCK CODE	SIZES
P3828-10	10

### FEATURES

- Aluminium backing giving enhanced protection against radiated heat
- Kevlar® stitching
- Fully lined



4244



313X3X

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 12477:2001
- BS EN 407:2020

## REVERSIBLE GAUNTLETS



SCAN FOR MORE INFORMATION



### COW SPLIT LEATHER

STOCK CODE	SIZES
P3826-11	11

### FEATURES

- Double Kevlar® stitched
- Reversible design reduces costs
- Minimum palm thickness 1.2mm
- Fully lined and fully welted



4244



313X3X

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020

# WELDING GAUNTLETS



## WELDERS GAUNTLET



### COW SPLIT LEATHER

#### FEATURES

- One piece back
- Reinforced palm
- Fully lined
- Minimum palm thickness 1.2mm



3244



414X4X

STOCK CODE	SIZES
P3820-10	10

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020

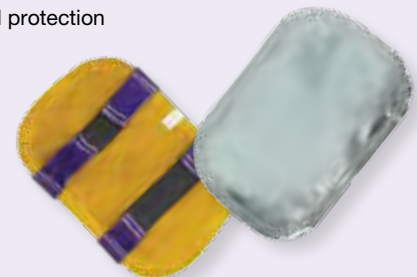
## ALUMINISED HAND SHIELD



### SPLIT HIDE LEATHER WITH ALUMINISED FRONT

#### FEATURES

- Provides additional protection from reflected heat
- Elasticated straps



STOCK CODE	SIZES
P3829	One

# TIG GLOVES



## PANTHER PRO TIG GLOVE



**NEW  
SIZES**

**GOAT SKIN WITH COW HIDE  
CUFF AND REAR**

### FEATURES

- Cow hide rear to give improved heat protection
- Reinforced hand rest for improved durability
- Thumb patch for filler rod feeding
- Elasticated cuff for secure fit



1111



41XX2X

STOCK CODE	SIZES
P3839-8	8
P3839-9	9
P3839-10	10

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020

## PANTHER PRO DEER SKIN TIG GLOVE



**NEW  
PRODUCT**

**DEER SKIN SOFT LEATHER**

### FEATURES

- Deer skin soft leather body
- Split leather cow hide cuff
- Superior fingertip control
- Reinforced palm for durability

STOCK CODE	SIZES
P3837-7	7
P3837-8	8
P3837-9	9
P3837-10	10

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020



1111



41XX2X



# TIG GLOVES



## PANTHER BLACK SHORT TIG GLOVE



GOAT SKIN SOFT LEATHER

### FEATURES

- Soft leather construction
- Close fit for maximum control
- Split leather cow hide cuff
- Superior fingertip control
- Ideal for fine work



1111



212X1X

STOCK CODE	SIZES
P3832-7	7
P3832-8	8
P3832-9	9
P3832-10	10

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020

## PANTHER FINGERTIP SENSITIVITY TIG GLOVE



GOAT SKIN WITH COW HIDE CUFF

### FEATURES

- Reinforced thumb
- Reinforced wrist patch
- Extra long cuff (150mm)



1111



41XX2X

STOCK CODE	SIZES
P3838-8	8
P3838-9	9
P3838-10	10

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020

# PARWELD GLOVES

## TIG GLOVE



### GOAT SKIN WITH COW HIDE CUFF

STOCK CODE	SIZE
P3835-10	10

### FEATURES

- Reinforced thumb
- Reinforced wrist patch
- Extra long cuff (150mm)
- With gusseted fingers for improved dexterity

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020



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## TIG GLOVE



### COW HIDE GRAIN LEATHER

STOCK CODE	SIZE
P3830-10	10

### FEATURES

- Extra long cuff

### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN 407:2020
- BS EN 12477:2001
- BS EN ISO 21420:2020



1111 212X1X



## TIG FINGER HEAT SHIELD



### METAL MATERIAL

STOCK CODE	SIZES
TF1	Standard
TF2	XL Size

### FEATURES

- Provides additional heat protection
- Allows you to steady your hand on the work piece



# PANTHER WELDING JACKET



STOCK CODE	SIZES
P3788-M	Medium
P3788-L	Large
P3788-XL	Xtra Large
P3788-XXL	XXtra Large
P3788-XXXL	XXXtra Large



## FEATURES

- Worn over garments to protect body and arms from sparks and spatter
- Leather front and shoulders
- Stand up collar
- Adjustable wrists
- Inside pocket
- Side take up straps
- Kevlar® stitched
- 1.2mm thick split cow hide

- Flame retardant cloth back with shoulder vent to improve comfort
- Flame retardant cloth under arm for improved flexibility
- Head phone slot

## STANDARDS

- BS EN ISO 11611:2015 Class 1

# PANTHER BLACK LEATHER SLEEVE WELDERS JACKET



## SPLIT COW SKIN LEATHER WITH FR COTTON BODY

STOCK CODE	SIZES
P3787-M	Medium
P3787-L	Large
P3787-XL	Xtra Large
P3787-XXL	XXtra Large
P3787-XXXL	XXXtra Large

## FEATURES

- Leather sleeves for arm protection
- Adjustable wrists for spark protection
- Flame retardant cotton body for improved comfort and flexibility
- Internal pockets
- Kevlar stitched

## STANDARDS

- BS EN ISO 11611:2015 Class 1



# PANTHER BLACK LEATHER CAPE WELDERS JACKET



## SPLIT COW SKIN LEATHER WITH FR COTTON BODY

STOCK CODE	SIZES
P3786-M	Medium
P3786-L	Large
P3786-XL	Xtra Large
P3786-XXL	XXtra Large
P3786-XXXL	XXXtra Large

## FEATURES

- Leather sleeves for arm protection
- Leather cape top for shoulder protection
- Great for overhead welding
- Adjustable wrists for spark protection
- Flame retardant cotton body for improved comfort and flexibility
- Internal pockets
- Kevlar stitched

## STANDARDS

- BS EN ISO 11611:2015 Class 1



# WELDERS CLOTHING

## RED WELDING JACKET



GOAT SKIN WITH COW HIDE CUFF

STOCK CODE	SIZES
P3780-M	Medium
P3780-L	Large
P3780-XL	Xtra Large
P3780-XXL	XXtra Large
P3780-XXXL	XXXtra Large

### FEATURES

- Worn over garments to protect body and arms from sparks and spatter
- Velcro and stud fastening
- Protective flap for fasteners

### STANDARDS

- BS EN ISO 11611:2015 Class 1



## PANTHER APRON



C/W BUCKLE AND TIES

STOCK CODE	SIZES
P3725	61cm x 91cm (24" x 36")

### FEATURES

- Offers protection from sparks and heat generated from welding and industrial applications
- Kevlar® stitched
- Strong cotton webbing
- 1.2mm thick split cow hide
- Click fasteners for waist and neck look

### STANDARDS

- BS EN ISO 11611:2015 Class 1



## RED APRON



C/W BUCKLE AND TIES

STOCK CODE	SIZES
P3720	61cm x 91cm (24" x 36")

### FEATURES

- Heavy duty leather apron with reinforced ties
- Offers protection from sparks and heat generated from welding and industrial applications
- Click fasteners for waist and neck look

### STANDARDS

- BS EN ISO 11611:2015 Class 1



# WELDERS CLOTHING

## PANTHER LEATHER SLEEVE



### FLEXIBLE PROTECTION FOR YOUR ARMS

STOCK CODE	SIZES
P3765	46cm (18")

### FEATURES

- Offers protection for clothes and arms from sparks and heat generated from welding and industrial applications
- Kevlar® stitched
- Superior quality split leather
- Elasticised at both ends
- 1.2mm thick split cow hide
- Flame retardant cloth insert to improve flexibility

### STANDARDS

- BS EN ISO 11611:2015 Class 1



## RED LEATHER SLEEVE



### PROTECTION FOR CLOTHES AND ARMS

STOCK CODE	SIZES
P3760	46cm (18")

### FEATURES

- Offers protection for clothes and arms from sparks and heat generated from welding and industrial applications
- Elasticised cuff

### STANDARDS

- BS EN ISO 11611:2015 Class 1



## RED LEATHER SPAT

STOCK CODE	SIZES
P3740	One



### STANDARDS

- BS EN ISO 11611:2015 Class 1



## PANTHER LEATHER SPAT



### WORN OVER FOOT AND LOWER LEG

STOCK CODE	SIZES
P3745	One

### FEATURES

- Offers protection for shoes and trousers from sparks and heat generated from welding and industrial applications
- 1.2mm thick split cow hide
- Secured with velcro and securing leather strap

### STANDARDS

- BS EN ISO 11611:2015 Class 1



# FLAME PROTECTION

## FLAME RETARDANT HOOD

CODE	SIZE
P3940	One



### FEATURES

- Front fastening
- Adjustable
- Lined hood
- Navy blue
- 335g 100% Cotton fabric with flame retardant treatment

### STANDARDS

- BS EN ISO 14116:2015



A1 B1 C1

## EVERYDAY FLAME RETARDANT HOOD

CODE	SIZE
P3942	One

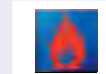


### FEATURES

- Front fastening
- Adjustable
- Navy Blue
- 335g 100% Cotton fabric with flame retardant treatment

### STANDARDS

- BS EN ISO 14116:2015



A1 B1 C1

## FLAME RETARDANT HOOD LONG

CODE	SIZE
P3950	One

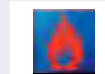


### FEATURES

- Front fastening
- Adjustable
- Lined Hood
- Navy Blue
- Longer Cape
- 335g 100% Cotton fabric with flame retardant treatment

### STANDARDS

- BS EN ISO 14116:2015



A1 B1 C1

## BANDANA

CODE	SIZE
P3960	One



### DURABLE FLAME TREATED COTTON

### FEATURES

- 335g 100% Cotton fabric with flame retardant treatment

### STANDARDS

- BS EN ISO 14116:2015



# DRIVER GLOVES

## PANTHER DRIVER GLOVES



### COW HIDE GRAIN LEATHER

#### FEATURES

- Fully lined for extra comfort
- Key set thumb for extra movement and flexibility
- Rolled hem
- Elasticated back
- Reinforced palm for extended life.

#### STANDARDS

- BS EN 388:2016 +A1:2018

STOCK CODE	SIZES
P3855-7	7
P3855-8	8
P3855-9	9
P3855-10	10



4133

## PANTHER CUT-RESISTANT DRIVERS GLOVE



### COW HIDE GRAIN LEATHER

#### FEATURES

- Premium soft grain Leather.
- Half elastication to back of cuff.
- Para-Aramid lining.

#### STANDARDS

- BS EN 388:2016+A1:2018

STOCK CODE	SIZES
P3856-9	9
P3856-10	10



4X44D

# DRIVER GLOVES

## PANTHER MESH BACK DRIVERS GLOVE



### COW GRAIN LEATHER

#### FEATURES

- Soft leather palm and finger facing
- Mesh rear for cooling
- Neoprene knuckle guard

#### STANDARDS

- BS EN 388:2016 +A1:2018

STOCK CODE	SIZES
P3854-7	7
P3854-8	8
P3854-9	9
P3854-10	10



4133

## PANTHER IMPACT PROTECTION DRIVERS GLOVE



**NEW  
PRODUCT**

### COW HIDE GRAIN LEATHER

#### FEATURES

- TPE impact protectors to rear of hand and fingers
- Fully lined for comfort
- Elasticated back
- Reinforced palm for durability

STOCK CODE	SIZES
P3857-8	8
P3857-9	9
P3857-10	10



4133XP

#### STANDARDS

- BS EN 388:2016+A1:2018

# DRIVER GLOVES

## PANTHER THERMAL LEATHER GLOVE



**NEW**  
PRODUCT

**COW HIDE SPLIT LEATHER WITH THERMAL LINING**

STOCK CODE	SIZE
P3815-10	10

### FEATURES

- Premium Cowhide Split Leather
- G-150gram Thinsulate and Micro Fleece
- Nylon Cuff

### STANDARDS

- BS EN 388:2016+A1:2018
- BS EN 511:2006



4X34B



13X

## DRIVERS GLOVE



**NEW**  
PRODUCT

**GOAT HIDE GRAIN LEATHER**

STOCK CODE	SIZES
P3850-7	7
P3850-8	8
P3850-9	9
P3850-10	10

### FEATURES

- Fully lined for extra comfort
- Key set thumb for extra movement and flexibility
- Rolled hem
- Elasticated back
- Reinforced palm for extended life.



3122

### STANDARDS

- BS EN 388:2016 +A1:2018

# HANDLING GLOVES

## LEATHER FREEZER GLOVE



### WITH ELASTICATED CUFF

STOCK CODE	SIZE
P3803	10

### FEATURES

- Full grain soft cowhide leather
- Elasticated cuff with integral vein patch
- Fully cotton fleece lined
- Robust hard wearing, multi purpose glove ideal for low temperature working



2143

### STANDARDS

- BS EN 388:2016+A1:2018

# PROTECTION SLEEVES

## PARA-ARAMID SLEEVE



### FEATURES

- Increased protection against cuts, slashes and abrasion
- Soft flexible yarn and seamless construction will not irritate arms, even during long periods of wear
- Thumb slot cut out helps to locate the sleeve securely and also increases protection to the palm area
- Provides shield protection from heat vapors

STOCK CODE	SIZES
P4210	10"
P4212	12"
P4218	18"
P4222	22"



EN407  
42XXX



EN388  
152X

### STANDARDS

- BS EN 11612
- BS EN 388:2016+A1:2018
- BS EN 21420:2020

# RIGGER GLOVES

## PANTHER CANADIAN RIGGER GLOVE



### COW SKIN AND COTTON

#### FEATURES

- Premium split cow skin
- 50mm reinforced cuff incorporating vein patch
- Minimum palm thickness 1.2mm
- Hi-Vis strip on knuckle protection

STOCK CODE	SIZES
P3805-7	7
P3805-8	8
P3805-9	9
P3805-10	10



4133

#### STANDARDS

- BS EN 388:2016 +A1:2018

## PANTHER CUT-RESISTANT RIGGER GLOVE



### COW HIDE AND COTTON WITH PARA-ARAMID LINING

#### FEATURES

- Premium split leather
- Heavyweight cotton backing and safety cuff
- Para-Aramid lining

STOCK CODE	SIZES
P3806-7	7
P3806-8	8
P3806-9	9
P3806-10	10



4X44E

#### STANDARDS

- BS EN 388:2016+A1:2018

# RIGGER GLOVES

## POWER RIGGER GLOVE



COW SPLIT LEATHER

STOCK CODE	SIZE
P3802-10	10

### FEATURES

- Shoulder split leather
- Rubberised cuff
- Elasticated back
- Fully lined for extra comfort

### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



2244X

## DOUBLE PALM RIGGER GLOVE



COW SPLIT LEATHER

STOCK CODE	SIZE
P3801-10	10

### FEATURES

- Shoulder split leather
- Double palm finger and thumb
- Rubberised cuff
- Elasticated back
- Fully lined for extra comfort

### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



3242X

## MECHANIC GLOVE



SYNTHETIC LEATHER

STOCK CODE	SIZE
P3810-10	10

### FEATURES

- Velcro fasten cuff
- Spandex back for snug fit
- Reinforced palm and knuckles
- Finger tip wear pads

### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



4133

# GRIP GLOVES

## COLOUR CODED PROTECTION

### PANTHER NITRILE GRIPPER



#### NITRILE COATED NYLON 13G

STOCK CODE	SIZES
P3870-6	6
P3870-7	7
P3870-8	8
P3870-9	9
P3870-10	10
P3870-11	11

#### FEATURES

- Improved grip for wet or oily items
- Foam nitrile dual density coating helps keep glove surface dry
- Long lasting construction
- Close fitting

#### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



3131X

### NITRILE GRIPPER GLOVE LITE



#### NITRILE COATED 13G POLYESTER

STOCK CODE	SIZES
P3872-8	8
P3872-9	9
P3872-10	10
P3872-11	11



#### FEATURES

- Improved grip for wet or oily items
- Smooth nitrile coating give good grip for wet or oily parts
- Close fitting construction

#### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



3131X

### PU GRIPPER GLOVE LITE



#### PU COATED NYLON

STOCK CODE	SIZES
P3862-8	8
P3862-9	9
P3862-10	10
P3862-11	11



#### FEATURES

- Ideal for light handling
- PU coating gives grip and abrasion resistance
- Knitted wrist
- Coated palm

#### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018



3121X

# GRIP GLOVES

## COLOUR CODED PROTECTION

### PANTHER PU RED CUT A



PU NYLON 15G COATED

#### FEATURES

- Good breathability
- Excellent dexterity
- Low particle shed, good for dry working
- Nylon woven body

#### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018

STOCK CODE	SIZES
P3860-6	6
P3860-7	7
P3860-8	8
P3860-9	9
P3860-10	10
P3860-11	11



4131A

### PANTHER PU AMBER CUT B



13G POLYESTER YARN  
WITH PU PALM COATING

#### FEATURES

- Good cut protection
- Good breathability
- Good dexterity
- Low particle shed, good for dry working
- Polyester woven body

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 150:3997



STOCK CODE	SIZES
P3843-9	9
P3843-10	10
P3843-11	11



4X42B



# GRIP GLOVES

## COLOUR CODED PROTECTION

### PANTHER PU GREEN CUT D



13G HPPE YARN WITH PU PALM COATING

#### FEATURES

- Excellent cut protection
- Reinforced PU coating
- Good dexterity
- Low particle shed, good for dry working
- HPPE woven body

STOCK CODE	SIZES
P3845-7	7
P3845-8	8
P3845-9	9
P3845-10	10
P3845-11	11

#### STANDARDS

- BS EN 388:2016 +A1:2018
- BS EN ISO 21420:2020
- BS EN 150:3997



4X43D

### THERMAL GRIPPER LATEX GLOVE



LATEX

#### FEATURES

- Ideal for outdoor and cold store applications
- Textured latex palm coating for superb grip
- Ribbed knitted wrist
- Brushed terry lining for added comfort and warmth
- General handling
- Knitted wrist
- Abrasion resistance
- Colour safe identification

STOCK CODE	SIZES
P3840-9	9
P3840-10	10
P3840-11	11



2242X

#### STANDARDS

- BS EN ISO 21420:2020
- BS EN 388:2016 +A1:2018

# SAFETY SPECTACLES

## CLEAR WRAP ROUND ANTI FOG SAFETY SPECTACLES



STOCK CODE	STYLE
P3446	Clear

### FEATURES

- One piece wrap round polycarbonate lens
- Anti fog coating

- TPE brow bar and nose support for ultimate comfort

- Weight 25g

### STANDARDS

- BS EN166:2002 1F



## SPORTS STYLE IN RED AND BLUE FRAMES

NYLON FRAME WITH METALLIC PAINT /  
CLEAR POLYCARBONATE LENS

### FEATURES

- Optical Class 1
- Low profile
- Panoramic vision
- Cushioned side arms
- Moulded nose bridge
- Lightweight
- 99.9% UV protection
- Supplied with neck cord



STOCK CODE	STYLE
P3442R	Red
P3442	Blue

### STANDARDS

- BS EN 166:2002 1FT

# SAFETY SPECTACLES

## LARGE LENS SPECTACLES



STOCK CODE	STYLE
P3448	Clear

### CLEAR POLYCARBONATE LENS

#### FEATURES

- Lightweight wrap round spectacle
- One piece wrap round polycarbonate lens
- TPE coated nose support and side legs
- Weight 31.5G
- Adjustable arms
- Non-slip nose piece

#### STANDARDS

- BS EN 166:2002 1FT

## BLACK NYLON FRAME CLEAR POLYCARBONATE LENS



STOCK CODE	STYLE
P3400	Clear
P3400A	Amber
P3400S	Smoked
P3400-5	Welding Shade 5



#### FEATURES

- Optical Class 1
- Low Profile
- Wrap Around Sports Design
- Moulded Nose Bridge
- Comfortable Flexible Frame
- 99.9% UV Protection

#### STANDARDS

- BS EN166:2002 1F

# SAFETY SPECTACLES

# GOGGLES

## NYLON BLACK FRAME SPECTACLE



### NYLON FRAME POLYCARBONATE LENS

STOCK CODE	STYLE
P3410	Clear
P3410A	Amber
P3410S	Glare Protection

### FEATURES

- Optical Class 1
- Low profile, panoramic vision
- Wrap around sports and anti-scratch design

- Cushioned and adjustable side arms
- C/w Neck cord

### STANDARDS

- BS EN 166:2002 1FT

## CLEAR SKI GOGGLE



### POLYCARBONATE LENS PVC SEAL

### FEATURES

- Optical Class 1
- Soft PVC seal for comfort
- Impact rating B
- Indirect ventilation
- Lightweight

STOCK CODE	STYLE
P3305	Clear

- Can be worn over prescription spectacles
- Adjustable strap

### STANDARDS

- BS EN 166:2002 1B

## CLEAR SAFETY SPECTACLES

STOCK CODE	STYLE
P3420	Clear



### BLACK NYLON FRAME CLEAR POLYCARBONATE LENS

### FEATURES

- Optical Class 1
- Black nylon frame with internal brow guard
- Panoramic vision

- Adjustable arms
- Non-slip nose piece

### STANDARDS

- BS EN 166:2002 1FT

## CLEAR VISITOR SPECTACLES

STOCK CODE	STYLE
P3430	Clear



### POLYCARBONATE FRAME & LENS

### FEATURES

- Optical class 1
- Vented side shields
- Lightweight Polycarbonate lens

- Can be worn over prescription spectacles

### STANDARDS

- BS EN 166:2002 1FT

# GOGGLES



## PANORAMIC SAFETY GOGGLE DIRECT



PVC

### FEATURES

- Designed for impact protection
- Clear PVC frame With direct ventilation
- Can be worn over prescription spectacles

STOCK CODE	STYLE
P3300D	Clear

- Adjustable strap

### STANDARDS

- BS EN 166:2002 1-49BT

## PANORAMIC SAFETY GOGGLE INDIRECT



PVC

### FEATURES

- Designed for impact protection
- Clear PVC frame with indirect ventilation
- Can be worn over prescription spectacles

STOCK CODE	STYLE
P3300	Clear

- Adjustable strap

### STANDARDS

- BS EN 166:2002 1-49BT

## EYE PROTECTION WELDING SPECTACLES



### FEATURES

- One piece polycarbonate lens for improved protection
- Nylon frame with polycarbonate side screens
- Adjustable side legs (10mm)

STOCK CODE	STYLE
P3444	Welding

- Weight 31.9g
- 99.9% UV protection
- Shade 5

### STANDARDS

- BS EN166:2002 1F

## SKI TYPE WELDING GOGGLE



PVC

### FEATURES

- One piece goggle with soft moulded body
- Spatter resistant acetate lens
- Wide vision
- Shade 5 lens

STOCK CODE	STYLE
P3310	Welding

### STANDARDS

- BS EN 166:2002
- BS EN 169:2002

## FLIP UP WELDING GOGGLE



### FEATURES

- One piece goggle with soft moulded body
- Flip front design
- Indirect vent PVC housing
- Clear and shade 5 lens

STOCK CODE	STYLE
P3390	Welding

- 108mm x 50mm (4¼" x 2")

### STANDARDS

- BS EN 166:2002
- BS EN 175:1997
- BS EN 169:2002

## ROUND LENS FLIP UP WELDING GOGGLE



### FEATURES

- One piece goggle with soft moulded body
- Flip front design
- Indirect vent PVC housing
- 50mm Polycarbonate lens

STOCK CODE	STYLE
P3330	Welding

- Clear and shade 5 lens

### STANDARDS

- BS EN 166:2002
- BS EN 175:1997
- BS EN 169:2002

# VISORS

## SHADE 3 VISOR - P3260-3



### STANDARDS

- BS EN 166:2002 IB
- BS EN 169:2002
- Size 8" x 12"

## SHADE 5 VISOR - P3260-5



### STANDARDS

- BS EN 166:2002 IB
- BS EN 169:2002
- Size 8" x 12"

## SHADE 5 VISOR - P3261-5



### STANDARDS

- BS EN 166:2002 IB
- BS EN 169:2002
- Size 8" x 15½"

## CLEAR VISOR - P3261



### STANDARDS

- BS EN 166:2002 IB
- Size 8" x 15½"

## BROW GUARD - P3266



### STANDARDS

- BS EN1736:2007

## WELDING TENT KIT



STOCK CODE	DESCRIPTION
WT1222	Welding Tent Full Kit – Includes Cover & Frame

# EAR PROTECTION

## EAR DEFENDER - P3590



### FEATURES:

- Comfortable noise reducing ear defender
- General purpose adjustable headband
- SNR = 24db

### STANDARDS

- BS EN 352-1:2020

## FOAM EAR PLUG - P3530

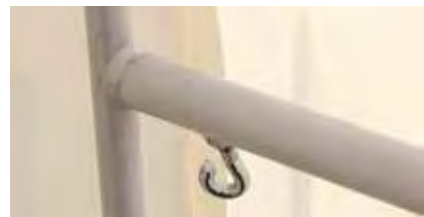


### FEATURES:

- Cylindrical soft foam, compress to fit, disposable ear plug
- Designed to provide the ultimate in comfort, SNR = 37db

### STANDARDS

- BS EN 352-2:2020



STOCK CODE	DESCRIPTION
WT1222/FR	Welding Tent Frame only
WT1222/C	Welding Tent Cover only

# HAZARD PROTECTION



## ORANGE PVC WELDING CURTAIN



### STOCK CODE

- P3646O - Size 1.2m x 1.8m (4ft x 6ft)
- P3666O - Size 1.8m x 1.8m (6ft x 6ft)
- P3886O - Size 2.4m x 1.8m (8ft x 6ft)
- P3610 - Curtain Rings

### FEATURES

- Low visibility orange PVC welding curtain for MIG and TIG welding

### STANDARDS

- BS EN ISO 25980:2014
- Supplied with eyelets on 4 sides

### UV STABILISED / PVC

## GREEN PVC WELDING CURTAIN



### STOCK CODE

- P3646G - Size 1.2m x 1.8m (4ft x 6ft)
- P3666G - Size 1.8m x 1.8m (6ft x 6ft)
- P3886G - Size 2.4m x 1.8m (8ft x 6ft)
- P3610 Curtain Rings

### FEATURES

- Low visibility dark green PVC welding curtain for MIG and TIG welding

### STANDARDS

- BS EN ISO 25980:2014
- Supplied with eyelets on 4 sides

### UV STABILISED / PVC / DARK GREEN

## STEEL FRAME



### STOCK CODE

- P3666FR - Size 1.8m x 1.8m (6ft x 6ft)
- P3886FR - Size 2.4m x 1.8m (8ft x 6ft)
- FR-EXT - Steel Frame Extension 0.6m (2ft)

### FEATURES

- Steel Frame.

## CANVAS WELDING CURTAIN



### STOCK CODE

- P3646CG - Size 1.2m x 1.8m (4ft x 6ft)
- P3666CG - Size 1.8m x 1.8m (6ft x 6ft)
- P3886CG - Size 2.4m x 1.8m (8ft x 6ft)
- P3610 Curtain Rings

### FEATURES

- Low visibility dark green canvas welding curtain for MIG and TIG welding
- Supplied with eyelets on 4 sides

### STANDARDS

- BS EN ISO 25980:2014

### GREEN CANVAS

Parweld's range of welding blankets & curtains protect the user from accidents caused by welding sparks. All Parweld welding blankets conform to BS EN 1869:2019

### DEFINITIONS BS EN ISO 1869:2019

#### THE PRODUCT MUST:

- Protect workers whilst having the added benefit of shielding flammable materials, machinery, vehicles & plant & equipment from molten metal globules, spatter, etc. Welding blankets are reusable dependent upon the application.
- Parweld's welding curtains can be used to isolate an area offering protection to workers working outside of the welding area from welding sparks, UV/IR light welding spatter by creating a moveable welding bay.
- Parweld's safety apparel offers the users protection against the hazards in the workplace.

## WELDING BLANKET/ROLL

WOVEN GLASS FIBRE  
WITH THERMAL  
TREATMENT



600°C

### STOCK CODE

- P3630 50m x 1m
- P3621 2m x 1m
- P3622 2m x 2m
- P3623 3m x 2m

### FEATURES

- Provides protection from sparks and weld spatter
- 430G/Sq m

1000°C

### STOCK CODE

- P3631 50m x 1m
- P3624 2m x 1m
- P3625 2m x 2m

### FEATURES

- Provides protection from sparks and weld spatter
- 880G/Sq m

### STANDARDS

- BS EN 1869:2019

# XR935H

## EVERYDAY LIGHT REACTIVE WELDING AND GRINDING HELMET



### FEATURES

- Slim and lightweight
- Automatic light adjustment from light to dark in 1/30,000th of a second
- Shade control from DIN9-13
- Variable sensitivity
- Grinding mode
- Variable delay
- Viewing area 100mm x 41mm (3.94" x 1.62")
- Full face coverage
- Suitable for TIG welding
- Automatic power on/off
- Built in battery
- UV/IR protection up to shade DIN 16
- 12 months warranty

### TECHNICAL DATA

Viewing Area	100mm x 41mm (3.94" x 1.62")
Cartridge Size	110mm x 90mm (4.33" x 3.54")
UV/IR Protection	Permanent Shade DIN16
Light State	DIN Shade 4
Dark State	DIN Shade 9 to 13 Variable
Power Supply	Solar cells with built in battery
Power On/Off	Fully Automatic
Switching Time Light to Dark	1/30,000 seconds
Dark to Light	0.1-1.0 seconds (Internal variable)
Operating Temp	-10C to +60°C (14°F to 140°F)
Storage Temp	-20°C to +70°C (-4°F to -158°F)
Helmet Material	High Impact Polyamide Nylon
Total Weight	466g
Min Amp Req	10A

### CONFORMS TO EUROPEAN STANDARDS

The XR935H Light Reactive Helmet is independently certified to: BS EN 379 and BS EN 175, EN 166, BS EN 379:2003+A1:2009, BS EN 175:1997, BS EN 166:2002.

### DIOPTER LENS

STOCK CODE	MAGNIFICATION
LD1050	1.0
LD1550	1.5
LD2050	2.0
LD2550	2.5
LD3050	3.0

### SPARES INFORMATION

STOCK CODE	DESCRIPTION
XR935H	Everyday Light Reactive Welding and Grinding Helmet
XR420	Front Cover Lens
XR350	Auto Darkening Filter Cartridge
XR430	Inside Cover Lens
XR370	Sweat Band
XR340	Adjustable Headband

### STANDARDS

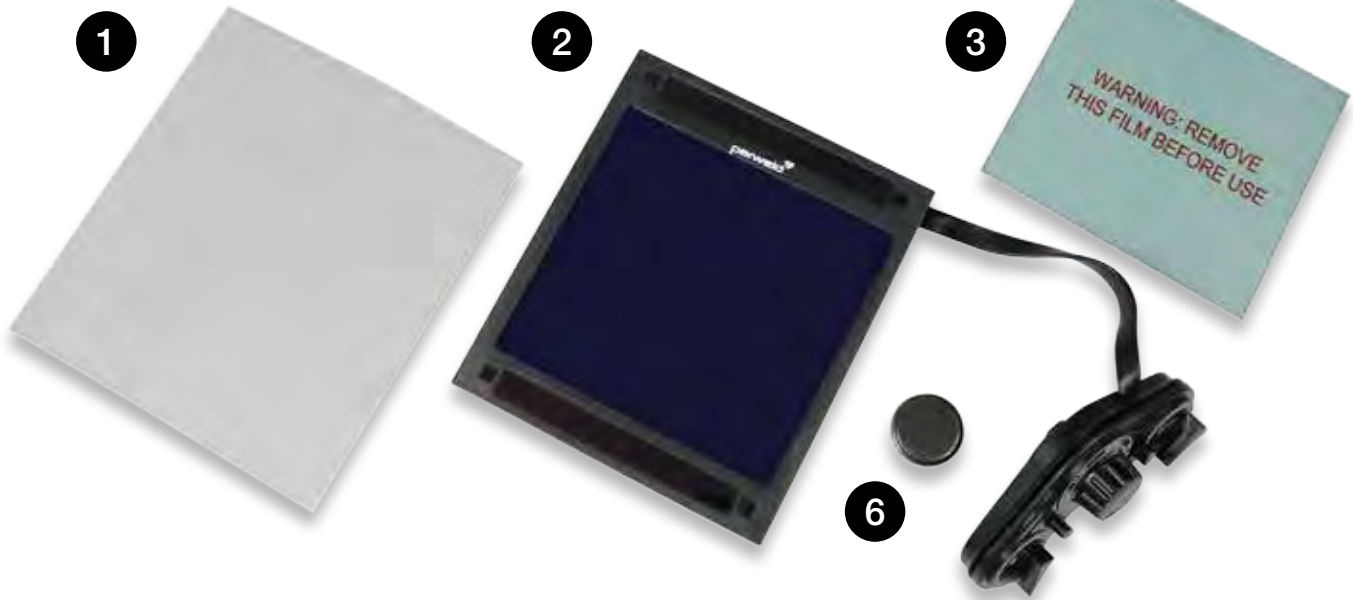
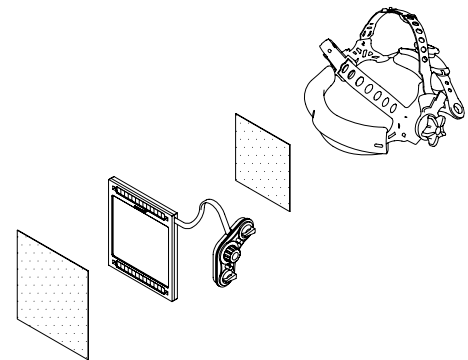
- BS EN 166:2002 1F • BS EN 379:2003+A1:2009 • BS EN 175:1997 • EN 166:2002



# XR937H PARTS LIST

## SPARES INFORMATION

STOCK CODE	DESCRIPTION
1 XR9720	Front Cover Lens
2 XR9700	Auto Darkening Filter (ADF)
3 XR9730	Inside Cover Lens
4 XR9740	Head Band Assembly
5 XR1012	Sweat Band
6 XR363	Twin Battery
CR2450	Single Battery



# XR938H

## TRUE COLOUR LIGHT REACTIVE WELDING AND GRINDING HELMET



CR2450 (3V BATTERY)

### DIOPTRER LENS

STOCK CODE	MAGNIFICATION
LD1050	1.0
LD1550	1.5
LD2050	2.0
LD2550	2.5
LD3050	3.0

### SPARES INFORMATION

STOCK CODE	DESCRIPTION
XR938H/P	True Colour Light Reactive Helmet - Graphite
XR938H	True Colour Light Reactive Helmet - Silver
XR938H/BL	True Colour Light Reactive Helmet - Blue
XR938H/E	True Colour Light Reactive Helmet - Eagle
XR938H/F	True Colour Light Reactive Helmet - Flame
XR938H/R	True Colour Light Reactive Helmet - Red
XR720	Front Cover Lens
XR380	True Colour ADF 110mm x 90mm
XR730	Inside Cover Lens
XR770	Sweat Band
XR740	Adjustable Headband
CR2450	3V Battery

### FEATURES

- True colour lens
- Slim and lightweight
- Automatic light adjustment from light to dark in 1/30,000th of a second
- Shade control from DIN 5-13
- Variable sensitivity
- Grinding mode
- Variable delay
- Viewing area 100 x 53mm (3.94" x 2.08")
- Full face coverage
- Suitable for TIG welding
- Automatic power on/off
- Battery life expectancy 2 years
- UV/IR protection up to shade DIN 16
- 24 months warranty

### TECHNICAL DATA

Viewing Area	100 x 53mm (3.94" x 2.08")
Cartridge Size	110mm x 90mm (4.33" x 3.54")
UV/IR Protection	Permanent Shade DIN 16
Light State	DIN Shade 4
Dark State	DIN Shade 5 to 13 Variable
Power Supply	Built in solar cells and replaceable battery
Power On/Off	Fully Automatic
Switching Time Light to Dark	1/30,000 seconds
Dark to Light	0.1-1.0 seconds (External variable)
Operating Temp	-10°C to +60°C (14°F to 140°F)
Storage Temp	-20°C to +70°C (-4°F to -158°F)
Helmet Material	High Impact Polyamide Nylon
Total Weight	470g
Min Amperage Req	5A

### STANDARD

- BS EN 166:2002 1F

# XR938H

## TRUE COLOUR LIGHT REACTIVE WELDING AND GRINDING HELMET



XR938H



XR938H/BL



XR938H/R



XR938H/P



XR938H/E



XR938H/F

### MOULDED CONSTRUCTION

The XR938H is both slim and lightweight in construction. Manufactured from a high impact polyamide nylon material which ensures the helmet provides high levels of comfort and durability. The metallic paint finish ensures maximum heat reflection.

### FULL FACE COVERAGE

A curved design with a clear spatter shield over the optics provides maximum clarity. The helmet is fully adjustable to suit all head and body types. Features full neck coverage, locking headgear and automatic power on/off switch.

### FAST SWITCHING

The auto on, auto darkening, wide view lens switches from light to dark in 1/30,000th of a second and offers continuous eye protection against UV and IR radiation, even when the lens is in the light state mode.

The grinding switch is conveniently located on the outside of the helmet. The switch locks the filter in the light state (Shade DIN 4) to enable the helmet to be used as a grinding visor.

### SOLAR POWERED

The helmet is powered by a solar cell with replaceable backup battery CR2450 (3V BATTERY).

### FILTERS

The welding filter has 4 sensors that react independently as the welding arc is struck enabling the almost instantaneous darkening of the filter.

The switching sensitivity knob is located on the inside of the helmet and allows the helmet to be tuned to work in different ambient light levels.

All Parweld filters have a Shade 4 light state, ideal for welding preparation.

### CONFORMS TO EUROPEAN STANDARDS

The XR938H True Colour Light Reactive Welding and Grinding Helmet is independently certified to; BS EN 379 and BS EN 175, EN 166, BS EN 379:2003+A1:2009, BS EN 175:1997, BS EN 166:2002.

### STANDARD LENS:



### TRUE COLOUR LENS:



# XR940A POWERED AIR PURIFYING RESPIRATOR FOR PARTICULATE ENVIRONMENTS



**PAPR HELMET**  
Supplied with XR940A (XR1002)  
Large View Welding Helmet.

**XR1002**  
LARGE VIEW

## TECHNICAL DATA

Air flow rate	170 or 220nl/min
Material	PC + ABS
Motor	Brushless
Fuse	Electronic
Battery	Li-ion 14.8V rechargeable
Battery Charging time	Approx 2.5h
Charging Cycles	>350
Run time	11 hour @ 170nl/min 9 hour @ 220nl/min (min fully charged new battery & filter room temp.)
Noise	Max. 60dB(A)
Voltage/Capacity	14.8V/2.2Ah
Pre filter	Carbon (odour)
Weight	288g (1097g incl. Filter and Battery)
Dimensions	224 x 190 x 70 mm (MAX)
Air hose length	850mm
Master Filter Type	P3 TH3P R SL for TH3P system (Europe)
Standards	EN12941:1998/A1:2003/ A2:2008 TH3 P R SL

## XR940 HELMET

PART NO.	DESCRIPTION	QTY
XR1002	Large View Helmet with face seal and head gear	1
XR1011	Head gear inc air duct	1
XR1012	Sweat band for head gear	1
XR1013	Head gear fittings kit, one set left and right and hook screws for the front of the air duct	1
XR1014	Face seal and fixings	1
XR9720	Front Cover Lens	1
XR9700	Auto-Darkening Filter (ADF) c/w Control	1
XR9730	Inside Cover Lens	1
XR9740	Headband assembly	1

## PAPR SPARE PARTS LIST

PART NO.	DESCRIPTION	QTY
XR1003	Blower unit without belt (no filters but with cover)	1
XR1004	Filter cover with purple catch	1
XR1005	Spark Arrestor	1
XR1006	Carbon Pre-filter	10
XR1007	P3 HEPA filter	1
XR1008	Comfort belt with shoulder straps	1
XR1009	Flex air hose (inc Flame Retardant cover) 0.9m	1
XR1119	Flex air hose (inc Flame Retardant cover) 1.2m	1
XR1010	Flame Retardant hose cover 0.9m	1
XR1110	Flame Retardant hose cover 1.2m	1
XR1016	BATTERY Li/ion	1
XR1017	Universal charger	1
XR1018	PAPR unit excluding helmet	1
XR1001	Nylon carry bag	1

## WARRANTY

**2 YEARS FOR HELMET**  
**1 YEAR FOR PAPR**  
**BLOWER AND BATTERY**

# PAPR FEATURES



## FILTRATION

The unit uses a P3 Particulate main filter combined with a carbon odour filter and a mesh spark trap, all of which are user replaceable. The unit is suitable for use in areas without a restricted oxygen supply.

The TH3P filter has a protection factor of 50 and the lifetime of the filter is dependent upon local fume levels.

XR940A is a battery powered air purifying respirator for protection against dust and particles.

This system is TH3P certified in accordance with European standard EN12941: 1998/A 1:2004/A2:2008 TH3P

## TH3P FILTER APPLICATIONS

- Metal Grinding and Cutting Applications
- Welding of Aluminium by MIG or TIG Processes
- Welding of Stainless Steel by MIG & TIG Processes
- Welding of Steel by MMA, MIG or TIG
- Welding of Zinc Coated Steel by MIG or TIG

## FEATURES:

XR940A supplies clean, filtered air to the welder. The blower unit has an electronic control unit that constantly monitors and adjusts the fan to ensure a minimum of 170nl/min air flow.

The same system provides alarms which are visual, audible and vibrate for blocked filters and low battery condition. The battery life is normally more than 11 hours on low setting and 9 hours on high setting, but the condition of the filter can affect this.

The welding helmet has a multi adjustable head band with enhanced support to spread the load evenly on the welder's head.

The unit sits comfortably at the base of the back supported by a belt and shoulder straps.

# GLASS FILTER LENSES

DESIGNED FOR USE WITH WELDING HELMETS TO PROTECT THE USERS EYES.  
SHOULD ALWAYS BE USED IN CONJUNCTION WITH A CLEAR COVER LENS.



## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 108mm x 50mm  
(4¼" x 2")

STOCK CODE	SHADE
LS0850	8
LS0950	9
LS1050	10
LS1150	11
LS1250	12
LS1350	13

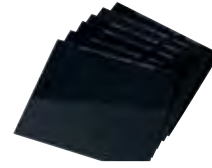


## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 108mm x 82mm  
(4¼" x 3¼")

STOCK CODE	SHADE
LS0882	8
LS0982	9
LS1082	10
LS1182	11
LS1282	12
LS1382	13



## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 133mm x 114mm  
(5¼" x 4½")

STOCK CODE	SHADE
LS0813	8
LS0913	9
LS1013	10
LS1113	11
LS1213	12
LS1313	13



## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 108mm x 55mm  
(4¼" x 2⅛")

STOCK CODE	SHADE
LS0855	8
LS0955	9
LS1055	10
LS1155	11
LS1255	12
LS1355	13



## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 110mm x 60mm  
(4⅓" x 2⅓")

STOCK CODE	SHADE
LS0860	8
LS0960	9
LS1060	10
LS1160	11
LS1260	12
LS1360	13



## STANDARD

- BS EN 169:2002
- BS EN 166:2002

Size 110mm x 90mm  
(4⅓" x 3½")

STOCK CODE	SHADE
LS0890	8
LS0990	9
LS1090	10
LS1190	11
LS1290	12
LS1390	13

# CLEAR COVER LENSES

DESIGNED FOR USE WITH WELDING HELMETS TO PROTECT THE FILTER LENS FROM SPATTER.



## CLEAR CR39 COVER LENS

STOCK CODE	SIZE
LCR3950	108 x 50mm (4¼ x 2")
LCR3982	108 x 82mm (4¼ x 3¼")
LCR3933	133 x 114mm (5¼ x 4½")

### STANDARD

- BS EN 166:2002 1S

## CLEAR GLASS COVER LENS

STOCK CODE	SIZE
LC0050	108 x 50mm (4¼ x 2")
LC0082	108 x 82mm (4¼ x 3¼")
LC1055	110 x 55mm
LC0133	133 x 114mm (5½ x 4¼")
LC1060	110 x 60mm
LC1090	110 x 90mm

### STANDARD

- BS EN 166:2002 1

## DIOPTER LENS

STOCK CODE	MAGNIFICATION
LD1050	1.0
LD1550	1.5
LD2050	2.0
LD2550	2.5
LD3050	3.0

### STANDARD

- BS EN 166:2002 1F

## CLEAR POLYCARBONATE COVER LENS

STOCK CODE	SIZE
LP0047	103mm x 47mm
LP0050	108 x 50mm (4¼ x 2")
LP0060	110 x 60mm
LP0082	108 x 82mm (4¼ x 3¼")
LP0133	114 x 133mm (4¼ x 5¼")

### STANDARD

- BS EN 166:2002

# RESPIRATORY PROTECTION

## FFP3 FACE MASK WITH VALVE, FOR SINGLE USE



**STANDARD ODOUR FILTER**  
**P3130V – WHITE MASK**

### FEATURES

30 Times Protection Factor, FFP3 Face Mask Respiratory Protection from Parweld. Face Mask comes with easy flow exhalation valve, integrated face seal, formable nose bridge and twin adjustable head straps.

Protects against hazardous/poisonous particles, dust, solid and liquid aerosols, mist and smoke, as well as carcinogenic and radioactive substances, enzymes and microorganisms (viruses, bacteria, fungi) up to 20 times the limit value, e.g. when grinding and processing wood, when working on a small scale with asbestos, when welding, when handling bacteria, viruses, mould, spores and radioactive particles. Dolomite tested to give minimal breathing resistance in the dustiest of environments.

Available with a Standard Odour Filter (P3130V – White Mask) or an Activated Carbon Odour Filter (P3132V – Grey Mask).



**ACTIVATED CARBON ODOUR FILTER**  
**P3132V – GREY MASK**

### TECHNICAL DATA

Mask Protection	FFP3
Protection Factor	30
Protection Area	Face, Mouth, Nose
Protection Type	Respiratory Protection
Particle Protection	Carcinogenic Substances, Dust, Enzymes and Microorganisms (Viruses, Bacteria, Fungi) up to 20 times the limit value, Hazardous/Poisonous Particles, Liquid Aerosols, Mist, Radioactive Substances, Smoke, Solid Aerosols
Protection Efficiency	High
Mask Structure	Moulded, Preformed Nose Bridge
Mask Features	Integrated Face Seal, Formable Nose Bridge, Twin Adjustable Head Straps, Easy Flow Exhalation Valve, Active Carbon Odour Filter (P3132V Only)
Respirator Type	Face Mask
Respiratory Testing	Dolomite Tested
Set Size	Single Piece
Standards	Conforms to BS EN 149:2001



Parweld offers an extensive MMA range, exceeding industry standard expectations at a competitive price.

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# CABLE PLUGS AND SOCKETS

- Designed to Connect Cables to the Power Source.
- Push and Twist Design.
- Foolproof Locking System.
- EN60974-12.

## TWIST LOCK PANEL MOUNTED PLUG



STOCK CODE	CABLE SIZE	MAX AMPS	PANEL CUT OUT	OUTER DIAMETER
PP10-25	10-25mm <sup>2</sup>	200A	20mm	32mm
PP35-50	35-50mm <sup>2</sup>	315A	30mm	42mm
PP50-70	50-70mm <sup>2</sup>	400A	30mm	42mm
PP70-95	70-95mm <sup>2</sup>	500A	30mm	42mm

## TWIST LOCK PANEL MOUNTED SOCKET



STOCK CODE	CABLE SIZE	MAX AMPS	PANEL CUT OUT	OUTER DIAMETER
PS10-25	10-25mm <sup>2</sup>	200A	20mm	32mm
PS35-50	35-50mm <sup>2</sup>	315A	30mm	42mm
PS50-70	50-70mm <sup>2</sup>	400A	30mm	42mm
PS70-95	70-95mm <sup>2</sup>	500A	30mm	42mm

## TWIST LOCK CABLE PLUG



STOCK CODE	CABLE SIZE	LENGTH	MAX AMPS
CP10-25	10-25mm <sup>2</sup>	65mm	150A
CP35-50	35-50mm <sup>2</sup>	105mm	315A
CP50-70	50-70mm <sup>2</sup>	110mm	400A
CP70-95	70-95mm <sup>2</sup>	110mm	500A

## TWIST LOCK CABLE SOCKET



STOCK CODE	CABLE SIZE	LENGTH	MAX AMPS
CS10-25	10-25mm <sup>2</sup>	65mm	200A
CS35-50	35-50mm <sup>2</sup>	105mm	315A
CS50-70	50-70mm <sup>2</sup>	110mm	400A
CS70-95	70-95mm <sup>2</sup>	110mm	500A

# EARTH CLAMPS

• CE BS 638-5, • EN60974-12

## 200A CROCODILE EARTH CLAMP



STOCK CODE	CABLE SIZE	MAX AMPS	DUTY CYCLE
661200	25mm <sup>2</sup>	200A	35%

## 400A CROCODILE EARTH CLAMP



STOCK CODE	CABLE SIZE	MAX AMPS	DUTY CYCLE
661400	70mm <sup>2</sup>	400A	35%

## 400A CAST STEEL SCREW TYPE EARTH CLAMP



STOCK CODE	CABLE SIZE	MAX AMPS	DUTY CYCLE
662400	95mm <sup>2</sup>	400A	35%

## 600A CAST BRASS SCREW TYPE EARTH CLAMP



STOCK CODE	CABLE SIZE	MAX AMPS	DUTY CYCLE
662600	95mm <sup>2</sup>	600A	35%

## 700A ALL BRASS SCREW TYPE EARTH CLAMP



STOCK CODE	CABLE SIZE	MAX AMPS	DUTY CYCLE
662700	95mm <sup>2</sup>	700A	35%

# MAGNETIC EARTH CLAMPS

## 400A MAGNETIC EARTH CLAMP



STOCK CODE	MAX AMPS
665500	400A

## 600A MAGNETIC EARTH CLAMP



STOCK CODE	MAX AMPS
666500	600A

## 600A MAGNETIC ROTATING EARTH CLAMP



STOCK CODE	MAX AMPS
664500	600A



# ELECTRODE HOLDERS

• CE EN 60974-11

## 400A ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
655400-2	50mm <sup>2</sup>	400A	5mm <sup>2</sup>	35%

## 600A ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
655600-2	70mm <sup>2</sup>	600A	6.3mm <sup>2</sup>	35%

## OPTIMUM ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
653300-1	35mm <sup>2</sup>	300A	4mm	35%
653400-1	50mm <sup>2</sup>	400A	5mm	35%

## 400A MUREX® ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
656400	50mm <sup>2</sup>	400A	5mm <sup>2</sup>	35%

## 200A CROCODILE ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
653200	25mm <sup>2</sup>	200A	3.2mm <sup>2</sup>	35%

## 400A CROCODILE ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
653400	50mm <sup>2</sup>	400A	8mm	35%

## 600A CROCODILE ELECTRODE HOLDER



STOCK CODE	CABLE SIZE	MAX AMPS	MAX ELECTRODE	DUTY CYCLE
653600	75mm <sup>2</sup>	600A	10mm	35%



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# CABLE KITS

• CE EN 60974-12

## EARTH CABLE CLAMP KIT



STOCK CODE	SIZE	AMPS	TWIST LOCK (mm <sup>2</sup> )
CKC203	3m	200A	10-25
CKC203I	3m	200A	35-50
CKC204	4m	200A	10-25
CKC205	5m	200A	10-25
CKC403	3m	400A	35-50
CKC404	4m	400A	35-50
CKC405	5m	400A	35-50

### FEATURES

- Single Insulated PVC Welding Cable
- Twist lock Plug
- Crocodile Clamp

## ELECTRODE HOLDER CABLE KIT



STOCK CODE	SIZE	AMPS	TWIST LOCK (mm <sup>2</sup> )
CKE203	3m	200A	10-25
CKE203I	3m	200A	35-50
CKE204	4m	200A	10-25
CKE205	5m	200A	10-25
CKE403	3m	400A	35-50
CKE404	4m	400A	35-50
CKE405	5m	400A	35-50

### FEATURES

- Single Insulated PVC Welding Cable
- Twist lock Plug
- Crocodile Electrode Holder

Twist lock trademark is the property of its respective owner, and usage is for reference only. These products are not endorsed by the original manufacturer.

# CHIPPING HAMMERS



## SPRING HANDLE CHIPPING



STOCK CODE	LENGTH	WEIGHT
671001	265mm	290gms

## STEEL HANDLE CHIPPING



STOCK CODE	LENGTH	WEIGHT
672001	295mm	380gms

## LARGE WOODEN HANDLE



STOCK CODE	LENGTH	WEIGHT
673001	285mm	550gms



# WIRE BRUSHES

## STAINLESS STEEL WIRE BRUSH

16 deep stainless steel, wooden handle, used to clean stainless steel.



STOCK CODE	DESCRIPTION
SS4W	4 Rows Wide

## MILD STEEL WIRE BRUSH

16 deep steel, wooden handle, used to clean mild steel, carbon steel bristles.



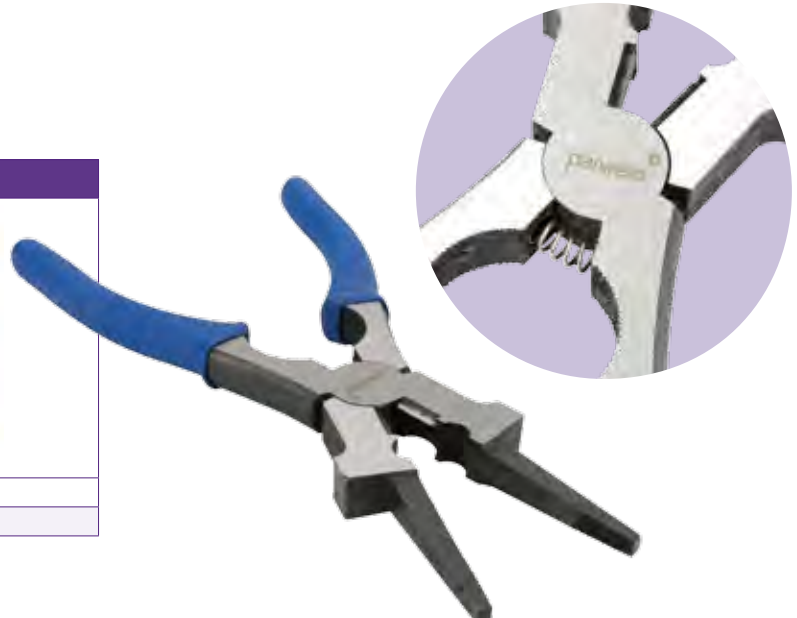
STOCK CODE	DESCRIPTION
MS3W	3 Rows Wide
MS4W	4 Rows Wide

# MIG PLIERS

## EVERYDAY MULTI-PURPOSE MIG PLIERS



STOCK CODE	NOZZLE DIAMETER
E808000	12-15mm





# AIR ARC GOUGING



## 1000A AIR ARC GOUGING TORCH

STOCK CODE	MAX AMPS
GTK4000	1000A

- 1000A Gouging torch
- 360° Swivel head assembly
- Natural 15° head angle
- Suits 4.0mm to 9.5mm round carbons
- Suits 9.5mm – 15.9mm flat carbons
- 2.1m Long reinforced rubber cable
- Rugged construction with ergo grip handle
- Air pressure 80 PSI



## AIR ARC GOUGING CARBONS



STOCK CODE	SIZE
AGC 5/32 x 12"	4mm (5/32")
AGC 3/16 x 12"	5mm (3/16")
AGC 1/4 x 12"	6mm (1/4")
AGC 5/16 x 12"	8mm (5/16")
AGC 3/8 x 12"	10mm (3/8")
AGC 1/2 x 12"	13mm (1/2")

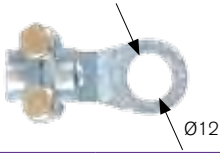
## AIR ARC JOINTED CARBONS



STOCK CODE	SIZE
AGCJ 5/16 x 17"	8mm (5/16")
AGCJ 1/2 x 17"	13mm (1/2")
AGCJ 5/8 x 17"	16mm (5/8")

# CABLE CONNECTORS & FITTINGS

## CABLE LUGS



### REUSABLE

STOCK CODE	DESCRIPTION
691025	25mm <sup>2</sup> 200A
691035	35mm <sup>2</sup> 300A
691050	50mm <sup>2</sup> 400A
691070	70mm <sup>2</sup> 600A

### HAMMER TYPE

STOCK CODE	DESCRIPTION
692050	50/70mm <sup>2</sup> 400A
692070	75/95mm <sup>2</sup> 600A

## COPPER CRIMP LUGS



STOCK CODE	SIZE	BOLT
CT25-10	16-25mm	10mm
CT50-12	35-50mm	12mm
CT50-16	35-50mm	16mm
CT70-12	50-70mm	12mm
CT70-16	50-70mm	16mm

# SIROCCO

## EVERYDAY GAS REGULATORS

High Quality Gas Welding  
and Cutting Equipment.



# ANTI-SPATTER



## WATER BASED ANTI-SPATTER



STOCK CODE	SIZE
WR1030	300ml

## GALVANISING SPRAY



STOCK CODE	SIZE
WR5040	400ml

## NDT DEVELOPER SPRAY



STOCK CODE	SIZE
WR7020	400ml

## NDT DYE PENETRANT SPRAY



STOCK CODE	SIZE
WR7030	400ml

## NDT CLEANER SPRAY



STOCK CODE	SIZE
WR7010	400ml

## NDT KIT SYSTEM



STOCK CODE	SIZE
WR7040	400ml

**INCLUDES:**  
Cleaner, Developer and Dye Penetrant Spray.

## PROTECT PRE-WELD ANTI-SPATTER

### FEATURES

- HIGH HEAT RESISTANCE
- SILICON FREE
- HIGHLY CONCENTRATED FORMULA



STOCK CODE	SIZE
WR4075	750ml
WR4005	5kg
WR4025	25kg

# ANTI-SPATTER

## BULK WATER BASED ANTI-SPATTER FLUID



STOCK CODE	SIZE
WR3025	25kg/25l
WR3005	5kg/5l

### FEATURES

- Silicone-free Water-soluble anti-spatter.
- Prevents sticking of spatter to workpieces, jigs, fixtures, MIG nozzles, etc.
- Health and Non-toxic, Environment-friendly.
- Effective on difficult applications such as stainless steel, galvanised steel and aluminium.
- Compatible with painting and galvanising.

## TIP DIP



STOCK CODE	SIZE
WR6050	500ml

### FEATURES

- Parweld Tip Dip provides effective protection from spatter to welding torch nozzles and tips.
- Can be applied to fixtures to provide long term protection from spatter.

# WELDING TORCH HOLDERS

## MTH MIG TORCH HOLDER



STOCK CODE	DESCRIPTION
MTH	MIG torch holder with magnetic base. Handy holder to store your MIG torch and have it within reach whilst welding. Sturdy magnetic base. Prevents damage to the MIG torch.

## TTH TIG TORCH HOLDER

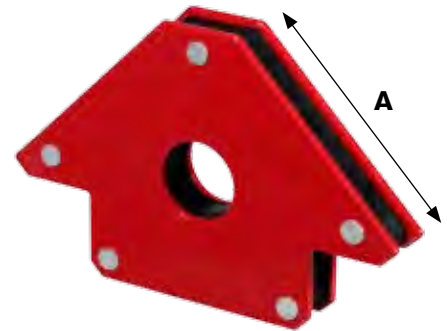


STOCK CODE	DESCRIPTION
TTH	TIG torch holder with magnetic base. Handy holder to store your TIG torch and have it within reach whilst welding. Sturdy magnetic base. Prevents damage to the TIG torch.

## WORK HOLDING MAGNETS



ALLOWS JOINT SETTING AT 90° AND 45°  
INTERNAL OR EXTERNAL CORNERS



ITEM 1 - 808913	ITEM 2 - 808912	ITEM 3 - 808911	ITEM 4 - 808910
A = 140mm, MAX 43KG	A = 110mm, MAX 36KG	A = 85mm, MAX 20KG	A = 64mm, MAX 12KG

# FILLER METALS

Parweld offers a large variety of welding filler metals, wires and tungsten's that will fit your needs.

<b>MMA ELECTRODES</b> .....	<b>379</b>
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308L TIG Wire.....	388
309L TIG Wire.....	388
312 TIG Wire.....	389
316L TIG Wire.....	389
347 TIG Wire.....	390



# FILLER METALS

<b>MILD STEEL TIG WIRE</b> .....	<b>390</b>	<b>MILD STEEL WIRE</b> .....	<b>401</b>
ER70S-2 - A15 .....	390	SG2 (ER70S-6) .....	401
ER70S-6 - A18 .....	391	<b>LOW ALLOY MIG WIRE</b> .....	<b>402</b>
<b>LOW ALLOY TIG WIRE</b> .....	<b>391</b>	ER110S-G - FK1 .....	402
ER70S-A1 - A30 .....	391	ER120S-G - FK1000 .....	402
ER80S-B2 - A32 .....	392	<b>WEATHERING STEEL WIRE</b> .....	<b>403</b>
ER80S-D2 - A31 .....	392	ER80S-G - CORTEN .....	403
ER80S-Ni1 .....	393	<b>HARD FACING MIG WIRE</b> .....	<b>403</b>
ER80S-Ni2 .....	393	ERFe3 - HF600 Solid .....	403
ER90S-B3 - A33 .....	394	<b>CORED WIRE</b> .....	<b>404</b>
ER110S-G - FK1 .....	394	Flux Cored Gasless Wire .....	404
ER100S-G - FK2 .....	395	E71T-1M Rutile Flux Cored Wire (FCW 12) .....	404
<b>WEATHERING STEEL TIG WIRE</b> .....	<b>395</b>	<b>METAL CORED WIRE</b> .....	<b>405</b>
ER80S-G - CORTEN .....	395	E70C-6M H4 Metal Cored Wire (FCW 21) .....	405
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4043 Aluminium Wire .....	396	2% Thoriated Tungsten Electrodes .....	406
5356 Aluminium Wire .....	397	Pure Tungsten Electrodes .....	406
5556 Aluminium Wire .....	397	1% Lanthanated Tungsten Electrodes .....	406
<b>STAINLESS STEEL WIRE</b> .....	<b>398</b>	2% Lanthanated Tungsten Electrodes .....	406
307Si Wire .....	398	Gold Tungsten Electrodes (Lanthanum 1.5%) .....	407
308LSi Wire .....	398	Zirconiated Tungsten Electrodes .....	407
309LSi Wire .....	399	2% Ceriated Tungsten Electrodes .....	407
310 Wire .....	399	3 Element Tungsten Electrodes .....	407
312 Wire .....	400		
316LSi Wire .....	400		
347 Wire .....	401		

# MMA ELECTRODES

## E6010 Mild Steel Cellulosic Pipe Electrodes (ESC 60)



STOCK CODE	SIZE	CHEMICAL COMPOSITION		
11400HZTM2	2.50 x 350 mm - 8.0 kg	C	Mn	Si
11400NZTM2	3.25 x 350 mm - 8.0 kg	Min		
		Max 0.12	0.6	0.2

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield Strength (N/mm <sup>2</sup> )	470 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	530 N/mm <sup>2</sup>
Elongation A5 (%)	25%
Charpy V-Notch Properties (J)	-30°C → 40J / -20°C → 60J

### WELDING POSITIONS



### CURRENT TYPE

- DC+ / DC- Root Pass

### KEY FEATURES

- Medium coated, cellulosic electrode, especially designed for welding of pipes and plates in all positions at low welding currents. Due to its high penetration, particularly suitable for root pass and fill passes in vertical down direction. Used in pipe-line construction, shipbuilding, storage vessels and assembly works. DCEN (-) is ideal in root passes and DCEP (+) is recommended for fill and cap passes in vertical down position.

### STANDARDS

- AWS/ASME SFA 5.1 E6010
- EN ISO 2560 A E 42 2 C 21

## E6012 General Purpose Mild Steel Electrodes (ESR 12)



STOCK CODE	SIZE	CHEMICAL COMPOSITION		
11107HREM2	2.50 x 350 mm - 5.0 kg	C	Mn	Si
11107NREM2	3.25 x 350 mm - 5.0 kg	Min		
11107QREM2	4.00 x 350 mm - 5.0 kg	Max 0.10	0.75	0.35

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield Strength (N/mm <sup>2</sup> )	470 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	540 N/mm <sup>2</sup>
Elongation A5 (%)	26%
Charpy V-Notch Properties (J)	0°C → ≥47J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC-

### KEY FEATURES

- Especially suitable for welding in sheets thinner than 5 mm, galvanized sheets and tubes, primer painted, painted and slightly rusty steels and in production of tanks and boilers, tube installations. Very easily operated in positional welding, including vertically-down. Good gap-bridging even at wide root openings. Smooth arc, well suited for tack-welding due to its easy arc striking and re-striking properties. Possible to use equally well both with AC and DC. Welds are smooth and blending into base metal without undercutting.

### STANDARDS

- AWS/ASME SFA 5.1 E6012
- EN ISO 2560 A E38 0 RC 11



# MMA ELECTRODES

## E6013 General Purpose Mild Steel Electrodes (ESR 11)



STOCK CODE	SIZE	CHEMICAL COMPOSITION												
11100EPEM2	2.00 x 350mm 1.0 kg	<table border="1"> <thead> <tr> <th></th> <th>C</th> <th>Mn</th> <th>Si</th> </tr> </thead> <tbody> <tr> <td>Min</td> <td></td> <td></td> <td></td> </tr> <tr> <td>Max</td> <td>0.10</td> <td>0.45</td> <td>0.70</td> </tr> </tbody> </table>		C	Mn	Si	Min				Max	0.10	0.45	0.70
	C		Mn	Si										
Min														
Max	0.10		0.45	0.70										
11100HPEM2	2.50 x 350mm 1.0 kg													
11100HREM2	2.50 x 350mm 5.0 kg													
11100NPEM2	3.25 x 350mm 1.0 kg													
11100NREM2	3.25 x 350mm 5.0 kg													
11100QREM2	4.00 x 350mm 5.0 kg													

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	480 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	550 N/mm <sup>2</sup>
Elongation A5 (%)	25%
Charpy V-Notch Properties (J)	0°C → 55J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC-

### KEY FEATURES

- Especially suitable for welding in sheets thinner than 5 mm, galvanized sheets and tubes, primer painted, painted and slightly rusty steels and in production of tanks and boilers, tube installations. Very easily operated in positional welding, including vertically-down. Good gap-bridging. Smooth arc, well suited for tack-welding due to its easy arc striking and re-striking properties. Possible to use equally well both with AC and DC. Welds are smooth, slightly concave and blending into base metal without undercutting. Slag is self-releasing.

### STANDARDS

- AWS/ASME SFA 5.1 E6013
- EN ISO 2560 A E 38 0 RC 11

## E6013 Mild Steel MMA Electrodes



STOCK CODE	SIZE
E6013-25	2.5 x 350 mm - 5.0 kg
E6013-252	2.5 x 350 mm - 2.5 kg
E6013-32	3.2 x 350 mm - 5.0 kg
E6013-322	3.2 x 350 mm - 2.5 kg
E6013-40	4.0 x 400 mm - 5.0 kg

CHEMICAL COMPOSITION							
	C	Mn	Si	Cr	Ni	Mo	Cu
Min							
Max	0.20	1.20	1.00	0.20	0.30	0.30	0.08

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	443 N/mm <sup>2</sup>
Tensile strength Rm	516 N/mm <sup>2</sup>
Elongation A5	30%
Impact Energy iso-V	80J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- General Purpose electrode good ignition weld properties notably in downhand.

### STANDARDS

- AWS A5:1.5

# MMA ELECTRODES

## E7016 H8 Low Hydrogen Electrodes (ESB 44) Vac Pac



STOCK CODE	SIZE	CHEMICAL COMPOSITION		
11202HKEM2	2.50 x 350mm - 2.5 kg			
11202PKEM2	3.25 x 450mm - 2.5 kg			
11202SKEM2	4.00 x 450mm - 2.5 kg			
11202QKEM2	5.00 x 450mm - 2.5 kg			
		<b>Min</b>		
		<b>Max</b>	0.06	1.00 0.65

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	450 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	550 N/mm <sup>2</sup>
Elongation A5 (%)	25%
Charpy V-Notch Properties (J)	-20°C → 70J / -30°C → 55J

WELDING POSITIONS	CURRENT TYPE
	• AC/DC+

**KEY FEATURES**

- Suitable for fabrication and repair welding of dynamically loaded steel constructions, machines and agricultural equipments, workshop and maintenance welding. Smooth and clean welds, blending into base metal without undercuts. Excellent gap bridging properties. The double covering of this electrode produces a stable, concentrated and directed arc, thus being ideally suited for root pass and positional welding and is suited for AC welding. Welds are of X-ray quality.

STANDARDS	
• AWS/ASME SFA 5.1	E7016 H8
• EN ISO 2560 A	E 38 2 B 12 H10

## E7018-1H4R Low Hydrogen Electrodes (ESB 52) Vac Pac



STOCK CODE	SIZE	CHEMICAL COMPOSITION		
11206HJEM2	2.50 x 350mm - 2.5 kg			
11206PJEM2	3.25 x 450mm - 2.5 kg			
11206SJEM2	4.00 x 450mm - 2.5 kg			
11206VJEM2	5.00 x 450mm - 2.5 kg			
		<b>Min</b>		
		<b>Max</b>	0.07	1.20 0.4

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	460 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	550 N/mm <sup>2</sup>
Elongation A5 (%)	28%
Charpy V-Notch Properties (J)	-46°C → 110 / -50°C → 100

WELDING POSITIONS	CURRENT TYPE
	• DC+

**KEY FEATURES**

- Suitable for welding of steel constructions, bridge, dam, thermal power plants, petrochemical industry, shipbuilding, high strength pipe-lines, pressure vessels, tanks, which are dynamically loaded and require high mechanical properties. The weld metal has a very low hydrogen content and is resistant to ageing. Produces tough and crack-free welded joints, also suite for welding steels having a carbon content of up to 0.6 % and rail joints. Good operating characteristic, also in root pass and positional welding. Very good gap bridging properties. Welds are of X-ray quality.

STANDARDS	
• AWS/ASME SFA 5.1	E7018-1 H4R
• EN ISO 2560 A	E 42 5 B 42 H5

# MMA ELECTRODES

## E7024 Mild Steel High Recovery Iron Powder Electrode (ESH 180R)



STOCK CODE	SIZE	CHEMICAL COMPOSITION		
11121PSEM2	3.25 x 450mm - 6.5 kg			
11121SSEM2	4.00 x 450mm - 6.5 kg			
11121VSEM2	5.00 x 450mm - 6.5 kg			
		<b>C</b>	<b>Mn</b>	<b>Si</b>
		<b>Min</b>		
		<b>Max</b>	0.07	0.80 0.55

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	480 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	550 N/mm <sup>2</sup>
Elongation A5 (%)	25%
Charpy V-Notch Properties (J)	20°C → 50J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC-

### KEY FEATURES

- Heavy coated, rutile type high-efficiency electrode having a weld metal recovery of approx. 180 %. It is suited to produce long fillet welds and economically filling-up large weld sections especially in shipbuilding. Suitable to use in pre-painted plates. Relatively low current intensities and short burn-off times. Easy arc striking and restriking.

### STANDARDS

- AWS/ASME SFA 5.1 E7024
- EN ISO 2560 A E 38 A RR 73

## E307-26 High Efficiency for Dissimilar Steels (EIS 307) Vac Pac



STOCK CODE	SIZE
13002HJEM2	2.50 x 350mm - 2.0 kg
13002NJEM2	3.25 x 350mm - 2.0 kg

CHEMICAL COMPOSITION					
	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>
<b>Min</b>					
<b>Max</b>	0.07	6.50	1.00	19.50	9.50

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	440 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	610 N/mm <sup>2</sup>
Elongation A5 (%)	40%
Charpy V-Notch Properties (J)	20°C → 70J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- High efficiency (160 %) electrode for joining dissimilar steels and depositing claddings on ferritic steels. The weld metal consists of austenitic Cr-Ni-Mn steel with possible small amounts of delta ferrite. The weld metal is highly crack resistant and therefore suited for joining difficult to weld steels and depositing stress relaxing buffer layers on crack sensitive base metal prior to hardfacing deposits. Weld metal work hardens by impact and pressure. Suitable for armour plates, rail, cross-overs, crane wheels, idlers, which are subjected to dynamically loading, pressure, impact and abrasion. It is non-scaling up to +850°C and highest operating temperature for dissimilar steel joints is +300°C. In the case of higher temperatures, use ENI 422 electrodes. High current carrying capacity due to its low alloy steel core wire and used with DCEP (DC+).

### STANDARDS

- AWS/ASME SFA 5.4 E307-26
- EN ISO 3581 A E 18 8 Mn R 53

# MMA ELECTRODES

## E308L-16 Rutile Electrode for Austenitic Stainless Steel (EI 308L) Vac Pac



STOCK CODE	SIZE
13003GJEM2	2.50 x 300mm - 1.75 kg
13003NJEM2	3.25 x 350mm - 2.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Ni
Min					
Max	0.02	0.9	0.7	19.50	10.00

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield Strength (N/mm <sup>2</sup> )	440 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	570 N/mm <sup>2</sup>
Elongation A5 (%)	42%
Charpy V-Notch Properties (J)	20°C → 70J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Rutile coated electrode for welding austenitic stainless Cr-Ni steels or cast steels, having an extra low carbon content, as well as stainless or heat resisting chromium steels or cast steels. Suitable for welding stainless steel tanks, valves, pipes and linings in chemical, food, beverage, pharmaceutical industries. For operating temperatures of up to +350°C, non-scaling up to +800°C. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

### STANDARDS

- AWS/ASME SFA 5.4 E308L-16
- EN ISO 3581 A E 19 9 L R 12

## E309L Rutile Electrode for Dissimilar Steels (EI 309L) Vac Pac



STOCK CODE	SIZE
13008GJEM2	2.50 x 300mm 1.75 kg
13008NJEM2	3.25 x 350mm 2 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Ni
Min					
Max	0.03	1.10	0.9	23	12.50

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield Strength (N/mm <sup>2</sup> )	450 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	570 N/mm <sup>2</sup>
Elongation A5 (%)	40%
Charpy V-Notch Properties (J)	20°C → 60J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Electrode for joining dissimilar steels (austenitic steels to ferritic steels) and for austenitic claddings on ferritic steels. Weld metal consists of austenite with approx. 15% delta-ferrite. Claddings on unalloyed and low alloy steels are already corrosion resistant in the first layer. Higher operating temperature for joints between dissimilar steels is +300°C. In case of higher temperatures use ENI 422 electrodes. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easy slag removal, easy arc striking and restriking.

### STANDARDS

- AWS/ASME SFA 5.4 E309L-16
- EN ISO 3581 A E 23 12 L R 12

# MMA ELECTRODES

## E312-16 Rutile Electrodes for Dissimilar and Cladding Applications (E1 312) Vac Pac



STOCK CODE	SIZE
13015GJEM2	2.50 x 300mm - 1.75 kg
13015MJEM2	3.25 x 300mm - 1.75 kg

CHEMICAL COMPOSITION					
	C	Mn	Si	Cr	Ni
Min					
Max	0.10	1.00	0.60	29.50	9.00

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	660 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	760 N/mm <sup>2</sup>
Elongation A5 (%)	20%
Charpy V-Notch Properties (J)	20°C → 50J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Rutile type stainless steel electrode for joining dissimilar steels and depositing claddings on ferritic steels. The ferritic-austenitic Cr-Ni weld metal contains approximately 50% of delta-ferrite and is non-scaling up to +1100°C. It features high resistance to cracking and is therefore suited for joining difficult to weld steels and depositing stress-relaxing buffer layers on crack sensitive base metals. Especially used in crack repair and build-up of tool and die steels, rebuilding of worn or cracked gear teeth, buffer layer on cutting blades. Suitable for welding galvanized steel plates. Possible to use equally well both AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joints faces, finely rippled bead surface, easy slag removal.

### STANDARDS

- AWS/ASME SFA 5.4 E312-16
- EN ISO 3581 A E 29 9 R 12

## E316L-16 Rutile Electrode for Austenitic Stainless Steel (E1 316L) Vac Pac



STOCK CODE	SIZE
13017DJEM2	2.00 x 300mm - 1.75 kg
13017GJEM2	2.50 x 300mm - 1.75 kg
13017NJEM2	3.25 x 350mm - 2.0 kg
13017QJEM2	4.00 x 350mm - 2.0 kg

CHEMICAL COMPOSITION						
	C	Mn	Si	Cr	Ni	Mo
Min						
Max	0.03	0.90	0.80	19.00	12.00	2.80

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield Strength (N/mm <sup>2</sup> )	460 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	560 N/mm <sup>2</sup>
Elongation A5 (%)	40%
Charpy V-Notch Properties (J)	20°C → 70J

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Rutile type stainless steel electrode for welding austenitic stainless Cr-Ni-Mo steels or cast steels, having an extra low carbon content. For operating temperatures of up to +400°C. Especially suitable for welding of stainless steel chemical tanks and pipes in chemical, textile, paint, paper industries. Possible to use equally well both with AC and DC. Easy arc striking and re-striking. Fine metal droplet transfer, good fusion of joint faces, finely rippled bead surface, easily removable slag.

### STANDARDS

- AWS/ASME SFA 5.4 E316L-16
- EN ISO 3581 A E 19 12 3 L R 32

# MMA ELECTRODES

## ENiFe-CI Nickel Iron Core electrode for Cast Iron (ENI 416) Vac Pac



STOCK CODE	SIZE
16003GJEM2	2.50 x 300mm - 1.75 kg
16003MJEM2	3.25 x 300mm - 1.75 kg

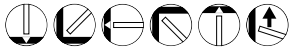
### CHEMICAL COMPOSITION

	C	Si	Mn	Ni	Al	Fe
Max	0.45	1.60	0.65	52.00	0.80	44.50

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

As welded ~210

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Electrode having a nickel-iron core wire for welding cast iron with or without preheating. The weld metal features a low coefficient of thermal expansion and as a result, little shrinkage. It has higher strength properties than pure nickel weld metal and is therefore preferably used for welding nodular cast iron, white and black heart malleable cast iron, as well as austenitic nodular cast iron or joining these metals to components made of steel, copper or nickel materials. Easy arc striking and restriking, stable arc, smooth bead. Weld metal is machinable. Weld short beads.

### STANDARDS

- AWS/ASME SFA 5.15 ENiFe CI
- EN ISO 1071 E C NiFe CI3

## ENi-CI Nickel Core Electrode for Grey Cast Iron (ENI 412) Vac Pac



STOCK CODE	SIZE
16002GJEM2	2.50 x 300mm - 1.75 kg
16002MJEM2	3.25 x 300mm - 1.75 kg
16002RJEM2	4.00 x 400mm - 2.25 kg

### CHEMICAL COMPOSITION

	C	Si	Mn	Ni	Ti	Ni	Fe
Min							
Max	0.80	0.80	0.20	97.00	0.35	0.10	0.75

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

As welded ~175

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- Electrode having a nickel core wire, for welding on grey cast iron with and without preheating. Suitable for welding joints as well as for surfacing of worn cast iron parts. Suitable to use in repair of machine frames, machine housings, machine parts and bearing blocks. The electrode has a very soft, regular fusion, and a quiet and steady arc. It is well suited for positional welding. Very little dilution with the parent metal takes place, resulting in good machinability of the transition area. Weld short beads, about 30 to 50 mm long. In order to reduce weld residual stresses, hammer-peen welds slightly before cooling. Preferably this is used with DCEN but it is possible to use with AC.

### STANDARDS

- AWS/ASME SFA 5.15 ENi-CI
- EN ISO 1071 E C Ni-CI 3

# MMA ELECTRODES

## E Fe8 Hardfacing Electrode (EH 360B)



STOCK CODE	SIZE
18006NREM2	3.25 x 350mm - 5.0kg
18006SSEM2	4.00 x 450mm - 6.5kg
18006VSEM2	5.00 x 450mm - 6.5kg

### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Mo	V	Fe
Min							
Max	0.5	0.6	0.8	8	0.5	0.65	Rest

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

As welded	59 HRC
Wear Index	62.34 (SiO <sub>2</sub> )

### WELDING POSITIONS



### CURRENT TYPE

- AC/DC+

### KEY FEATURES

- Thick basic-covered electrode for depositing tough and wear resisting overlays on structural members subjected to severe wear. It is particularly resistant to high meta-to-metal wear, moderate impact and abrasion. The weld metal has sufficient red hardness up to +600°C. It can be machined only by grinding. Suitable hardfacing applications where wear resistance at higher temperatures is a prime concern, as in hot cut offs, dies for pressure castings, rolls, crushers excavator parts, bucket edges and bucket teeth, drilling bits, coal planes, conveyor screws. Multi-layers deposits will be free of cracks, even without depositing intermediate buffer layers. Only in case of very crack sensitive base metals, a tough buffer layer, made with ESB 40 or EI 307B electrodes, is required. Preferred to use with DC, electrode in positive (+) pole and also possible to use with AC.

### STANDARDS

- EN 14700 E Fe8
- DIN 8555 E 6-UM-60-GPT

# ALUMINIUM TIG WIRE

## 4043 Aluminium TIG Wire 5% Silicon

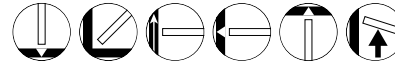


STOCK CODE	SIZE
XP25308	1.6 mm x 2.5 kg
XP25310	2.4 mm x 2.5 kg
XP25312	3.2 mm x 2.5 kg

### CHEMICAL COMPOSITION

	Mn	Si	Zn	Mg	Cu	Ti	Be	Fe
Min		4.5						
Max	0.05	5.5	0.10	0.05	0.3	0.20	.0008	0.8

### WELDING POSITIONS



### CURRENT TYPE

- AC

### KEY FEATURES

- General Purpose TIG wire suitable for welding AlMgSi and AISi alloys.
- 5% Silicon.

### SHIELDING GAS

- Pure Argon

### STANDARDS

- EN ISO 18273 S Al 4043 (AlSi5)
- AWS A5.10 ER4043

# ALUMINIUM TIG WIRE

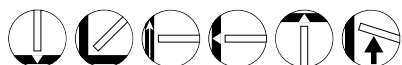
## 5356 Aluminium TIG Wire 5% Magnesium



STOCK CODE	SIZE
XP25316	1.6 mm x 2.5 kg
XP25320	2.4 mm x 2.5 kg
XP25322	3.2 mm x 2.5 kg

CHEMICAL COMPOSITION									
	Mn	Si	Cr	Zn	Mg	Cu	Ti	Be	Fe
<b>Min</b>	0.05		0.05		4.5		0.06		
<b>Max</b>	0.20	0.25	0.20	0.10	5.5	0.10	0.20	.0003	0.40

### WELDING POSITIONS



### CURRENT TYPE

- AC

### KEY FEATURES

- General Purpose TIG Wire suitable for welding AlMgSi and AlSi Alloys.
- 5% Magnesium.

### STANDARDS

- EN ISO 18273 S Al 5356 (AlMg5Cr(A))
- AWS A5.10 ER5356

### SHIELDING GAS

- Pure Argon

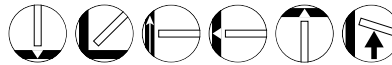
## 5556 Aluminium TIG Wire 5.3% Magnesium



STOCK CODE	SIZE
XP25326	1.6 mm x 2.5 kg
XP25328	2.5 mm x 2.5 kg
XP25330	3.2 mm x 2.5 kg

CHEMICAL COMPOSITION									
	Mn	Si	Cr	Zn	Mg	Cu	Ti	Be	Fe
<b>Min</b>	0.05		0.05		4.5		0.06		
<b>Max</b>	0.20	0.25	0.20	0.10	5.5	0.10	0.20	.0003	0.40

### WELDING POSITIONS



### CURRENT TYPE

- AC

### KEY FEATURES

- General purpose TIG Wire suitable for welding AlMgSi and AlSi Alloys
- 5.3% Magnesium

### STANDARDS

- EN ISO 18273 S Al 5556 (AlMg5Mn1Ti)
- AWS A5.10 ER5556

### SHIELDING GAS

- Pure Argon



# STAINLESS STEEL TIG WIRE

## 308L TIG Wire



STOCK CODE	SIZE
XP30310	1.0 mm x 5.0 kg
XP30312	1.2 mm x 5.0 kg
XP30314	1.6 mm x 5.0 kg
XP30318	2.4 mm x 5.0 kg
XP30320	3.2 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min	1.00					19.0	9.00		
Max	0.03	2.50	0.65	0.02	0.03	21.0	11.0	0.50	0.50

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	205 MPa
Yield strength Rp 1.0	240 MPa
Tensile strength Rm	510 MPa
Elongation A5	25%

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### SHIELDING GAS

- Pure Argon

### KEY FEATURES

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

### STANDARDS

- EN ISO 14343-A W 19 9 L
- AWS A5.9 ER 308L

## 309L TIG Wire



STOCK CODE	SIZE
XP30330	1.6 mm x 5.0 kg
XP30332	2.4 mm x 5.0 kg
XP30334	3.2 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	1.00	0.30				23.00	12.00						
Max	.023	2.00	0.50	.015	.020	24.00	14.00	0.30	0.20	0.20	.090	.050	.003

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	440 N/mm <sup>2</sup>
Tensile strength Rm	600 N/mm <sup>2</sup>
Elongation A5	40%
Impact Energy iso-V	160 J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- Suitable for joining steels to themselves, to carbon or low alloy steels.
- Can be used at temperatures of up to 371°C.
- Reduced carbon levels offer increased resistance to inter-granular corrosion.

### STANDARDS

- EN ISO 14343-A W 23 12 L
- AWS A5.9 ER 309L

# STAINLESS STEEL TIG WIRE

## 312 TIG Wire



STOCK CODE	SIZE
XP30352	1.6 mm x 5.0 kg
XP30354	2.4 mm x 5.0 kg
XP30356	3.2 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
Min		1				28	8		
Max	0.15	2.50	1.00	0.02	0.03	32	12	0.30	0.30

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength	610 MPa
Tensile strength	770 MPa
Elongation	20%
Impact energy	50 J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- Suitable for welding difficult-to-weld steels such as armour plate, austenitic Mn steel, high carbon steel and Cr/Ni steels.
- Applications should be limited to 420°C.

### STANDARDS

- EN ISO 14343-A W 29 9
- AWS A5.9 ER 312

## 316L TIG Wire



STOCK CODE	SIZE
XP30362	0.8 mm x 5.0 kg
XP30364	1.0 mm x 5.0 kg
XP30366	1.2 mm x 5.0 kg
XP30368	1.6 mm x 5.0 kg
XP30370	2.0 mm x 5.0 kg
XP30372	2.4 mm x 5.0 kg
XP30374	3.2 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min		1.50	0.30			18.0	12.0	25.0					
Max	.020	2.00	0.60	.015	.025	19.2	13.0	3.00	0.30	0.20	.060	.050	.002

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	450 N/mm <sup>2</sup>
Yield strength Rp 1.0	505 N/mm <sup>2</sup>
Tensile strength Rm	620 N/mm <sup>2</sup>
Elongation A5	35%
Reduction of area z	64%
Impact Energy iso-V	222 J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- Suitable for the nuclear industry and contains low Silicon levels. Chemical, Petrochem, Food and Beverage Applications.

### SHIELDING GAS

- Pure Argon

### STANDARDS

- EN ISO 14343-A W 19 12 3 L
- AWS A5.9 ER 316L

# STAINLESS STEEL TIG WIRE

## 347 TIG Wire



STOCK CODE	SIZE
XP30382	1.6 mm x 5.0 kg
XP30384	2.4 mm x 5.0 kg
XP30386	3.2 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	.020	1.20	0.30			19.0	9.00					12xC	
Max	.060	1.80	0.60	.015	.025	20.0	10.0	0.30	0.30	0.30	.060	.850	.003

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	450 N/mm <sup>2</sup>
Tensile strength Rm	600 N/mm <sup>2</sup>
Elongation A5	30%
Impact Energy iso-V	70 J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- 347 Niobium stabilized stainless steel used for the welding of types 347 and 321 stainless and stainless clad steels.
- The addition reduces inter-granular corrosion in severe operating conditions.

### STANDARDS

- EN ISO 14343-A W 19 9 NB
- AWS A5.9 ER 347

### SHIELDING GAS

- Pure Argon

# MILD STEEL TIG WIRE

## ER70S-2 - A15



STOCK CODE	SIZE
XP10300	1.0 mm x 5.0 kg
XP10303	1.2 mm x 5.0 kg
XP10306	1.6 mm x 5.0 kg
XP10309	2.0 mm x 5.0 kg
XP10312	2.4 mm x 5.0 kg
XP10315	3.2 mm x 5.0 kg

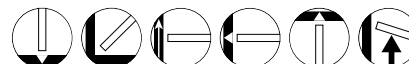
### CHEMICAL COMPOSITION

	C	Mn	Si	Zr	Al	Ti
%	0.03	1.20	0.55	0.07	0.10	0.10

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2	≥460MPa
Tensile Strength Rm	≥530MPa
Elongation 4d/5d	≥22/20%
Impact Energy iso-V	≥47J and -30°C: ≥27J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW rod for welding standard CMn structural steels.
- Typical applications would include shipbuilding, pressure vessels and construction.

### SHIELDING GAS

- Pure Argon

### STANDARDS

- EN ISO 636-A: W 46 2 2Ti
- AWS A5.18: ER70S-2

# MILD STEEL TIG WIRE

ER70S-6 - A18



STOCK CODE	SIZE
XP10324	1.0 mm x 5.0 kg
XP10327	1.2 mm x 5.0 kg
XP10330	1.6 mm x 5.0 kg
XP10336	2.4 mm x 5.0 kg
XP10339	3.2 mm x 5.0 kg

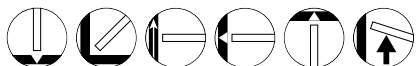
## CHEMICAL COMPOSITION

	C	Mn	Si		
%	0.09	1.47	0.87		

## MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2	≥460MPa
Tensile strength Rm	≥530MPa
Elongation 4d/5d	≥22/20%
Impact Energy iso-V	-50°C: ≥47J

## WELDING POSITIONS



## KEY FEATURES

- TIG/GTAW rod for welding standard CMn structural steels.
- Typical applications would include shipbuilding, pressure vessels and construction.

## STANDARDS

- EN ISO 636-A: W 46 5 3Si1
- AWS A5.18: ER70S-6

# LOW ALLOY TIG WIRE

ER70S-A1 - A30



STOCK CODE	SIZE
XP15300	1.0 mm x 5.0 kg
XP15302	1.2 mm x 5.0 kg
XP15304	1.6 mm x 5.0 kg
XP15306	2.4 mm x 5.0 kg
XP15308	3.2 mm x 5.0 kg

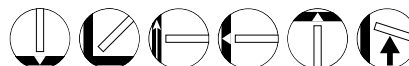
## CHEMICAL COMPOSITION

	C	Mn	Si	Mo	
%	0.10	1.15	0.60	0.5	

## MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥460MPa
Tensile strength Rm	≥530MPa
Elongation 4d/5d	≥19/20%

## WELDING POSITIONS



## KEY FEATURES

- TIG/GTAWRod for 0.5% Mo steels. These steels are commonly used at service temperatures up to 500°C and for some sub-zero structural applications.
- The 0.5% alloying improves creep performance compared to CMn steels and sees the alloy being used for boiler, pressure vessel and piping construction.
- The good general mechanical properties also ensures use in general structural engineering applications.

## STANDARDS

- EN ISO 636-A: W 46 4 2Mo
- EN ISO 21952-A: W MoSi
- AWS A5.28: ER70S-A1

## CURRENT TYPE

- DC-

## SHIELDING GAS

- Pure Argon

## CURRENT TYPE

- DC-

## SHIELDING GAS

- Pure Argon

# LOW ALLOY TIG WIRE

## ER80S-B2 - A32



STOCK CODE	SIZE
XP15324	1.0 mm x 5.0 kg
XP15326	1.2 mm x 5.0 kg
XP15328	1.6 mm x 5.0 kg
XP15330	2.4 mm x 5.0 kg
XP15332	3.0 mm x 5.0 kg

### CURRENT TYPE

- DC-

### SHIELDING GAS

- Pure Argon

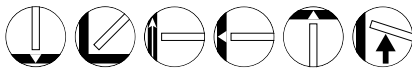
### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Mo
%	0.09	0.55	0.55	1.35	0.50

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥470MPa
Tensile strength Rm	≥550MPa
Elongation 4d/5d	≥19%

### WELDING POSITIONS



### KEY FEATURES

- TIG/GTAW rod for high temperature creep resistant 1.25%Cr-0.5%Mo ferritic steel.
- These steels are used for creep resisting applications up to ~550°C.
- Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.
- The wire has low levels of tramp elements (eg. Sn, As, Sb & P) providing a low Bruscato (X) Factor for temper embrittlement resistant applications.

### STANDARDS

- EN ISO 21952-B: W55 1CM
- A5.28: ER80S-B2

## ER80S-D2 - A31



STOCK CODE	SIZE
XP15312	1.0 mm x 5.0 kg
XP15314	1.2 mm x 5.0 kg
XP15316	1.6 mm x 5.0 kg
XP15318	2.4 mm x 5.0 kg
XP15320	3.2 mm x 5.0 kg

### CURRENT TYPE

- DC-

### SHIELDING GAS

- Pure Argon

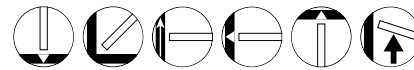
### CHEMICAL COMPOSITION

	C	Mn	Si	Mo
%	0.09	1.95	0.70	0.50

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥540MPa
Tensile strength Rm	≥620MPa
Elongation 4d/5d	≥17%
Impact Energy iso-V	-30°C: ≥27J

### WELDING POSITIONS



### KEY FEATURES

- TIG/GTAW rod for welding of high strength steels, used predominantly after stress relieving.
- Predominantly used for welding high strength steels, providing a good combination of strength and toughness.
- May find used for joining creep resistance steels up to ~500°C but the WSG Mo wire would be the more usual choice.

### STANDARDS

- EN ISO 636-B: W 57A 3 4M31
- AWS A5.28: ER80S-D2 / ER90S-D2

# LOW ALLOY TIG WIRE

## ER80S-Ni1



STOCK CODE	SIZE
XP15374	1.6 mm x 5.0 kg
XP15376	2.4 mm x 5.0 kg
XP15378	3.2 mm x 5.0 kg

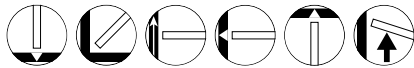
### CHEMICAL COMPOSITION

	C	Mn	Si	Ni
%	0.09	1.05	0.50	0.90

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥470MPa
Tensile strength Rm	≥550MPa
Elongation 4d/5d	≥24/20%
Impact Energy iso-V	-60°C: ≥47J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW rod for steels where impact properties are required at -50°C.
- Applications include structural, oil & gas and offshore steelwork.

### STANDARDS

- EN ISO 636-A: W 46 6 3Ni1
- AWS A5.28: ER80S-Ni1

### SHIELDING GAS

- Pure Argon

## ER80S-Ni2



STOCK CODE	SIZE
XP15382	1.6 mm x 5.0 kg
XP15384	2.4 mm x 5.0 kg
XP15386	3.2 mm x 5.0 kg

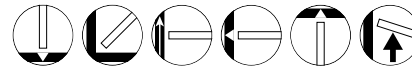
### CHEMICAL COMPOSITION

	C	Mn	Si	Ni
%	0.09	1.10	0.52	2.45

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥470MPa
Tensile strength Rm	≥550MPa
Elongation 4d/5d	≥24/20%
Impact Energy iso-V	-90°C: ≥47J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW rod for steels where impact properties are required at -75°C.
- Applications include structural, oil & gas and offshore steelwork.

### STANDARDS

- EN ISO 636-A: W 42 9 2Ni2
- AWS A5.28: ER80S-Ni2

### SHIELDING GAS

- Pure Argon

# LOW ALLOY TIG WIRE

## ER90S-B3 - A33



STOCK CODE	SIZE
XP15340	1.6 mm x 5.0 kg
XP15342	2.4 mm x 5.0 kg
XP15344	3.2 mm x 5.0 kg

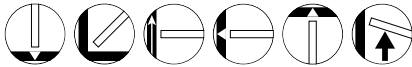
### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Mo
%	0.09	0.55	0.55	2.50	1.05

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥540MPa
Tensile strength Rm	≥620MPa
Elongation 4d/5d	≥17%

### WELDING POSITIONS



### KEY FEATURES

- TIG/GTAW rod for high temperature creep resistant 2.25%Cr-1%Mo ferritic steel.
- These steels are used for creep resisting applications up to 600°C.
- Typical applications in power generation plant include steam piping, turbines and boilers; the alloy also finds applications in the chemical and petro-chemical industries.
- The wire has low levels of tramp elements (eg. Sn, As, Sb & P) providing a low Brucato (X) Factor for temper embrittlement resistant applications.

### STANDARDS

- EN ISO 21952-B: W62 2C1M
- AWS A5.28: ER90S-B3

## ER110S-G - FK1



STOCK CODE	SIZE
XP15358	1.6 mm x 5.0 kg
XP15360	2.4 mm x 5.0 kg
XP15362	3.2 mm x 5.0 kg

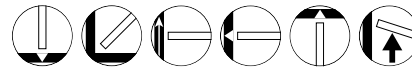
### CHEMICAL COMPOSITION

	C	Mn	Si	V	Cr	Ni	Mo
%	0.09	1.57	0.52	0.09	0.30	1.40	0.25

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥690MPa
Tensile strength Rm	≥790MPa
Elongation 4d/5d	≥17%
Impact Energy iso-V	-40°C: ≥47J

### WELDING POSITIONS



### KEY FEATURES

- TIG/GTAW wire for welding high strength low alloy steels.
- Used for many structural and construction applications including: pipelines, tankers and containers.
- Welding procedure, including preheat temperature, interpass temperature and PWHT, will be dependant on the base material being welded and any applicable design codes.

### STANDARDS

- EN ISO 16834-A: W 69 4 Mn3Ni1CrMo
- AWS A5.28: ER110S-G

### CURRENT TYPE

- DC-

### SHIELDING GAS

- Pure Argon

### CURRENT TYPE

- DC-

### SHIELDING GAS

- Pure Argon

# LOW ALLOY TIG WIRE

## ER100S-G - FK2



STOCK CODE	SIZE
XP15350	1.6 mm x 5.0 kg
XP15352	2.4 mm x 5.0 kg
XP15354	3.2 mm x 5.0 kg

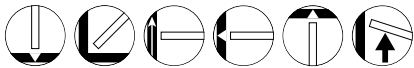
### CHEMICAL COMPOSITION

	C	Mn	Si	Ni	Mo	Ti
%	0.08	1.77	0.57	1.00	0.38	0.14

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥690MPa
Tensile strength Rm	≥760MPa
Elongation 4d/5d	≥17%
Impact Energy iso-V	-50°C: ≥47J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW wire for welding high strength low alloy steels.
- Used for many structural and construction applications including: pipelines, tankers and containers.
- Welding procedure, including preheat temperature, interpress temperature and PWHT, will be dependant on the base material being welded and any applicable design codes.

### STANDARDS

- EN ISO 16834-A: W 69 5 ZMn3Ni1Mo
- AWS A5.28: ER100S-G

# WEATHERING STEEL TIG WIRE

## ER80S-G - CORTEN



STOCK CODE	SIZE
XP15390	1.6 mm x 5.0 kg
XP15392	2.4 mm x 5.0 kg
XP15394	3.2 mm x 5.0 kg

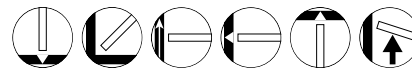
### CHEMICAL COMPOSITION

	C	Mn	Si	Cu	Ni
%	0.08	1.40	0.80	0.40	0.80

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

0.2% Proof Stress Rp 0.2%	≥450MPa
Tensile strength Rm	≥550MPa
Elongation 4d/5d	≥22/20%
Impact Energy iso-V	-40°C: ≥47J

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW rod for weathering steels.
- Weathering steels, with controlled additions of Cu, provide improved corrosion resistance compared to CMn steels.
- The improved resistance to atmospheric corrosion means these steels find use for architectural applications and also for welding CMn steels to prevent preferential corrosion of the weld.

### STANDARDS

- EN ISO 636-A: W 42 4 Z
- AWS A5.28: ER80S-G



# HARDFACING TIG WIRE

## HF6-G



STOCK CODE	SIZE
XP20300	1.6 mm x 5.0 kg
XP20303	2.4 mm x 5.0 kg
XP20306	3.2 mm x 5.0 kg

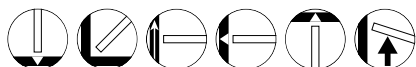
### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Mo	V	W
%	1.00	0.30	0.30	4.00	8.30	1.90	1.80

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Hardness	630-740HV
	590-690HB
	57-62HRC

### WELDING POSITIONS



### CURRENT TYPE

- DC-

### KEY FEATURES

- TIG/GTAW wire for the surfacing, repair or production of new high speed tools. Exhibits excellent wear resistance and resistance to softening at elevated temperatures. Weld deposits can only be ground. Typical applications will include: cutting tools, gouges, broaches, turning tools, drills.
- Similar high speed tool steels. Surfacing wide range of mild, CMn, low alloy, engineering steels.

### STANDARDS

- EN ISO 14700: SFe4
- AWS A5.21: ERFe6

# ALUMINIUM WIRE

## 4043 Aluminium Wire



STOCK CODE	SIZE
XP25218	0.8 mm x 2.0 kg
XP25221	1.0 mm x 2.0 kg
XP25224	1.2 mm x 2.0 kg
XP25209	0.8 mm x 0.5 kg
XP25212	1.0 mm x 0.5 kg
XP25215	1.2 mm x 0.5 kg
XP25227	0.8 mm x 7.0 kg
XP25230	1.0 mm x 7.0 kg
XP25233	1.2 mm x 7.0 kg

### CHEMICAL COMPOSITION

	Mn	Si	Mg	Mo	Cu	Ti	Be	Fe	Zn
Min	4.5								
Max	0.05	6.0	0.05	0.15	0.30	0.20	.0003	0.80	0.10

### WELDING POSITIONS



### CURRENT TYPE

- DC+

### KEY FEATURES

- 5% Silicon Aluminium Wire for General Purpose welding.

### SHIELDING GAS

- Pure Argon

### STANDARDS

- EN ISO 18273 S AI 4043 (AISI5)
- AWS A5.10 ER4043

# ALUMINIUM WIRE

## 5356 Aluminium Wire



STOCK CODE	SIZE
XP25236	0.8 mm x 0.5 kg
XP25239	1.0 mm x 0.5 kg
XP25248	1.0 mm x 2.0 kg
XP25242	1.2 mm x 0.5 kg
XP25251	1.2 mm x 2.0 kg
XP25254	0.8 mm x 7.0 kg
XP25257	1.0 mm x 7.0 kg
XP25260	1.2 mm x 7.0 kg

### CHEMICAL COMPOSITION

	Mg	Mn	Si	Zn	Fe	Cu	Ti	Cr	Be
Min	4.5	0.05					0.06	0.05	
Max	5.5	0.20	0.25	0.10	0.4	0.10	0.20	0.20	0.0003

### WELDING POSITIONS



### KEY FEATURES

- 5% Magnesium Aluminium Wire for General Purpose welding.

### STANDARDS

- EN ISO 18273 S Al 5356 (AlMg5Cr(A))
- AWS A5.10 ER5356

### CURRENT TYPE

- DC+

### SHIELDING GAS

- Pure Argon

## 5556 Aluminium Wire



STOCK CODE	SIZE
XP25278	1.2 mm x 7.0 kg

### CHEMICAL COMPOSITION

	Mg	Zn	Cr	Cu	Fe	Mn	Si	Be	Ti
Min	5.0	0.0	0.05	0.10	0.0	0.6	0.0	0	0.05
Max	5.5	0.20	0.20	0.10	0.40	1.0	0.25	0.0003	0.20

### WELDING POSITIONS



### CURRENT TYPE

- DC+

### KEY FEATURES

- 5.3% Magnesium.  
Produces a higher strength weld than standard 5% Mg 5356 alloy.

### STANDARDS

- EN ISO 18273 S Al 5556 (AlMg5Mn1Ti)
- AWS A5.10 ER5556

### SHIELDING GAS

- Pure Argon

# STAINLESS STEEL WIRE

## 307Si Wire



STOCK CODE	SIZE
XP30200	0.8 mm x 15kg
XP30202	1.0 mm x 15 kg
XP30204	1.2mm x 15kg

CHEMICAL COMPOSITION					
	C	Mn	Si	Cr	Ni
Min	4.5	0.65	17.0	7.0	
Max	.20	7.5	1.0	20.0	10.0

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	>350 N/mm <sup>2</sup>
Tensile strength Rm	560 N/mm <sup>2</sup>
Elongation A5	>45%
Impact energy ISO-V	>100J

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

**KEY FEATURES**

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

**SHIELDING GAS**

- M12, M13

**STANDARDS**

- EN ISO 14343-A                      G 18 8 Mn
- AWS A5.9                                ER 307Si

## 308LSi Wire



STOCK CODE	SIZE
XP30216	0.8 mm x 15 kg
XP30218	1.0 mm x 15 kg
XP30220	1.2 mm x 15 kg

CHEMICAL COMPOSITION													
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	1.50	0.65				19.5	10.0	1.50					
Max	.023	2.40	1.00	.015	.025	20.5	11.0	1.50	0.30	0.20	.060	.050	.003

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	390 N/mm <sup>2</sup>
Yield strength Rp 1.0	415 N/mm <sup>2</sup>
Tensile strength Rm	570 N/mm <sup>2</sup>
Elongation A5	35%
Reduction of area Z	40%
Impact energy ISO-V	140J

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

**KEY FEATURES**

- Suitable for welding 18/8 (304, 308, 308L) austenitic stainless steels.
- Provides superior corrosion and crack resistance.

**SHIELDING GAS**

- M12, M13

**STANDARDS**

- EN ISO 14343-A                      G 19 9 LSi
- AWS A5.9                                ER 308LSi

# STAINLESS STEEL WIRE

## 309LSi Wire



STOCK CODE	SIZE
XP30226	0.8 mm x 15 kg
XP30228	1.0 mm x 15 kg
XP30230	1.2 mm x 15 kg

CHEMICAL COMPOSITION													
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	1.50	0.65	.005			23.0	13.0						
Max	.020	2.00	1.00	.015	.020	24.0	14.0	0.30	0.20	0.20	.060	.050	.003

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	460 N/mm <sup>2</sup>
Yield strength Rp 1.0	610 N/mm <sup>2</sup>
Tensile strength Rm	570 N/mm <sup>2</sup>
Elongation A5	35%
Reduction of area Z	52%
Impact energy ISO-V	117J (102J)

**WELDING POSITIONS**

**KEY FEATURES**

- Suitable for joining material of similar composition and also dissimilar stainless steels.
- Contains higher Chromium and Nickel. High Silicon levels improve weld pool fluidity.

**STANDARDS**

- EN ISO 14343-A G 23 12 L Si
- AWS A5.9 ER 309LSi

**CURRENT TYPE**

- DC+

**SHIELDING GAS**

- M12, M13

## 310 Wire



STOCK CODE	SIZE
XP30236	0.8 mm x 15 kg
XP30238	1.0 mm x 15 kg
XP30240	1.2 mm x 15 kg

CHEMICAL COMPOSITION													
	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	.080	1.50	0.30			25.5	20.5						
Max	.120	2.00	0.60	.015	.015	26.5	21.0	0.30	0.20	0.20	.060	.050	.003

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	390 N/mm <sup>2</sup>
Yield strength Rp 1.0	590 N/mm <sup>2</sup>
Tensile strength Rm	630 N/mm <sup>2</sup>
Elongation A5	45%
Impact energy ISO-V	175J

**WELDING POSITIONS**

**KEY FEATURES**

- Suitable for heat-resistant austenitic steels with high 25% Cr / 20% Ni contents.
- Provides a weld deposit that is fully austenitic and therefore requires minimal heat input during welding.

**STANDARDS**

- EN ISO 14343-A G 25 20
- AWS A5.9 ER 310

**CURRENT TYPE**

- DC+

**SHIELDING GAS**

- M12, M13

# STAINLESS STEEL WIRE

## 312 Wire



STOCK CODE	SIZE
XP30244	0.8 mm x 15 kg
XP30246	1.0 mm x 15 kg
XP30248	1.2 mm x 15 kg

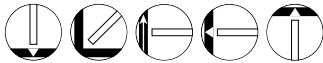
### CHEMICAL COMPOSITION

	C	Mn	Si	Cr	Ni	Mo
Min	1.0	0.30	28.0	8.0		
Max	.15	2.5	0.65	32.0	21.0	10.5

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	550 N/mm <sup>2</sup>
Tensile strength Rm	750 N/mm <sup>2</sup>
Elongation A5	25%
Impact energy ISO-V	>80

### WELDING POSITIONS



### KEY FEATURES

- Suitable for welding difficult-to-weld steels such as armour plate, austenitic Mn steel, high carbon steel and Cr/Ni steels.
- Applications should be limited to 420°C.

### STANDARDS

- EN ISO 14343-A G 29 9
- AWS A5.9 ER 312

### CURRENT TYPE

- DC+

### SHIELDING GAS

- M12, M13

## 316LSi Wire



STOCK CODE	SIZE
XP30260	0.8 mm x 15 kg
XP30262	1.0 mm x 15 kg
XP30264	1.2 mm x 15 kg
XP30252	0.8 mm x 5.0 kg
XP30254	1.0 mm x 5.0 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
Min	1.50	0.65	.005			18.0	11.0	2.50					
Max	.030	2.00	1.00	.015	.030	20.0	14.0	3.00	0.30	0.30	.060	.050	.003

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	450 N/mm <sup>2</sup>
Yield strength Rp 1.0	490 N/mm <sup>2</sup>
Tensile strength Rm	630 N/mm <sup>2</sup>
Elongation A5	33%
Reduction of area Z	46%
Impact energy ISO-V	152J

### WELDING POSITIONS



### KEY FEATURES

- Suitable for joining and cladding 316L joints and overlays.
- Contains considerable ferrite for high crack resistance.

### STANDARDS

- EN ISO 14343-A G 19 12 3 L
- AWS A5.9 ER 316LSi

### CURRENT TYPE

- DC+

### SHIELDING GAS

- M12, M13

# STAINLESS STEEL WIRE

## 347 Wire



STOCK CODE	SIZE
XP30268	0.8 mm x 15 kg
XP30270	1.0 mm x 15 kg
XP30272	1.2 mm x 15 kg

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co	N	Nb	B
<b>Min</b>	.020	1.20	0.30			19.0	9.00					12xC	
<b>Max</b>	.060	1.80	0.60	.015	.025	20.0	10.0	0.30	0.30	0.30	.060	.850	.003

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	350 N/mm <sup>2</sup>
Tensile strength Rm	550 N/mm <sup>2</sup>
Elongation A5	25%
Impact energy ISO-V	50J

### WELDING POSITIONS



### KEY FEATURES

- S347 Niobium stabilized stainless steel wire used for the welding of types 347 and 321 stainless and stainless clad steels.
- The addition reduces inter-granular corrosion in severe operating conditions.

### STANDARDS

- EN ISO 14343-A G 19 9 Nb
- AWS A5.9 ER 347

### CURRENT TYPE

- DC+

### SHIELDING GAS

- M12, M13

# MILD STEEL WIRE

## SG2 (ER70S-6)



STOCK CODE	SIZE
XP10224	0.8 mm x 15 kg
XP10227	1.0 mm x 15 kg
XP10230	1.2 mm x 15 kg
XP10209	0.6 mm x 5.0 kg
XP10212	0.8 mm x 5.0 kg
XP10215	1.0 mm x 5.0 kg
XP10200	0.6 mm x 0.7 kg
XP10203	0.8 mm x 0.7 kg
XP10239	1.0 mm x 250 kg <i>Bulk Pk</i>
XP10242	1.2 mm x 250 kg <i>Bulk Pk</i>

### CHEMICAL COMPOSITION

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Co
<b>Min</b>	0.06	1.40	0.80							
<b>Max</b>	0.15	1.85	1.15	.025	.025	.017	0.15	0.15	0.5	0.30

### MECHANICAL PROPERTIES (ALL WELD MATERIAL)

Yield strength Rp 0.2	485 N/mm <sup>2</sup>
Tensile strength Rm	575 N/mm <sup>2</sup>
Elongation A5	27.5%
Impact energy ISO-V	91 J

### WELDING POSITIONS



### KEY FEATURES

- Manufactured to BS2901.

### STANDARDS

- AWS A5.18 ER 70S-6

### CURRENT TYPE

- DC+

# LOW ALLOY MIG WIRE

## ER110S-G - FK1



STOCK CODE	SIZE
XP15266	1.0 mm x 15 kg
XP15269	1.2 mm x 15 kg

CHEMICAL COMPOSITION							
	C	Mn	Si	Mo	Ni	Cr	V
%	0.09	1.57	0.52	0.25	1.40	0.30	0.09

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
0.2% Proof Stress Rp 0.2%	≥690MPa
Tensile strength Rm	≥770MPa
Elongation 4d/5d	≥17%
Impact Energy iso-V	-40°C: ≥47J

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

- KEY FEATURES**
- MIG/GMAW wire for welding high strength low alloy steels.
  - Used for many structural and construction applications including: pipelines, tankers and containers. Most applications utilising the FK1 MIG/GMAW wire are left in the as-welded condition; the wire is not recommended for applications that require PWHT.

**STANDARDS**

• EN ISO 16834-A:	G 69 4 M21 Mn3Ni1CrMo
• A5.28:	ER110S-G

## ER120S-G - FK1000



STOCK CODE	SIZE
XP15275	1.0 mm x 15 kg
XP15278	1.2 mm x 15 kg

CHEMICAL COMPOSITION							
	C	Mn	Si	Ni	Cr	Mo	Ti
%	0.09	1.80	0.80	2.20	0.31	0.55	0.06

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
0.2% Proof Stress Rp 0.2%	≥890MPa
Tensile strength Rm	≥940MPa
Elongation 4d/5d	≥15%
Impact Energy iso-V	-60°C: ≥47J

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

**SHIELDING GAS**

- Mixed Gas

- KEY FEATURES**
- MIG/GMAW wire for welding high strength low alloy steels. Used for welding high strength steels in many high stress, critical applications; also exhibiting excellent toughness down to -60°C. Typical applications can be found in the mining, shipbuilding, automotive and pressure vessel industries.
  - Most applications utilising the FK1000 MIG/GMAW wire are left in the as-welded condition; the wire is not recommended for applications that require PWHT.
  - For high strength fine-grained structural steels up to yield strength 890MPa (129ksi).

**STANDARDS**

• EN ISO 16834-A:	G 89 6 M21 Mn4Ni2CrMo
• A5.28:	ER120S-G

# WEATHERING STEEL WIRE

ER80S-G - CORTEN



STOCK CODE	SIZE
XP15227	0.8 mm x 15 kg
XP15230	1.0 mm x 15 kg
XP15233	1.2 mm x 15 kg

CHEMICAL COMPOSITION					
	C	Mn	Si	Ni	Cu
%	0.08	1.40	0.80	0.80	0.40

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
0.2% Proof Stress Rp 0.2%	≥450MPa
Tensile strength Rm	≥550MPa
Elongation 4d/5d	≥22%
Impact Energy iso-V	-20°C: ≥47J

**WELDING POSITIONS**

- KEY FEATURES**
- MIG/GMAW wire for weathering steels. Weathering steels, with controlled additions of Cu, provide improved corrosion resistance compared to CMn steels.
  - The improved resistance to atmospheric corrosion means these steels find use for architectural applications and also for welding CMn steels to prevent preferential corrosion of the weld.

**STANDARDS**

• EN ISO 14341-A:	G 42 2 M21 Z
• A5.28:	ER80S-G

**CURRENT TYPE**

- DC+

**SHIELDING GAS**

- Mixed Gas

# HARD FACING MIG WIRE

ERFe3 - HF600 Solid



STOCK CODE	SIZE
XP20200	1.0 mm x 15 kg
XP20203	1.2 mm x 15 kg

CHEMICAL COMPOSITION				
	C	Mn	Si	Cr
%	0.45	0.40	3.00	9.30

**WELDING POSITIONS**

- KEY FEATURES**
- MIG/GMAW wire for hardfacing applications.
  - The wire is predominantly used for applications requiring good abrasion resistance such as mixers, crushers and earth moving equipment but deposits will withstand moderate impact.
  - With final deposit hardness being nominally 60HRC the weld metal can only be ground.
  - If very thick build-ups are required it is suggested that lower hardness wires (eg. ED-A 35) be used as a buffer layer.

**STANDARDS**

• EN ISO 14700:	S Fe8
• AWS A5.21:	ERFe3

**CURRENT TYPE**

- DC+

**SHIELDING GAS**

- Mixed Gas



# CORED WIRE

## Flux Cored Gasless Wire



STOCK CODE	SIZE
XP10400	0.8 mm x 0.45 kg
XP10406	0.8 mm x 5.0 kg
XP10403	0.9 mm x 0.45 kg
XP10409	0.9 mm x 5.0 kg

CHEMICAL COMPOSITION						
	Mn	Si	S	P	Al	
%	1.75	0.60	0.03	0.03	1.8	

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Yield strength Rp 0.2	420 N/mm <sup>2</sup>
Tensile strength Rm	560 N/mm <sup>2</sup>
Elongation A5	27.5%



- KEY FEATURES**
- Use without gas with electrode negative.

- STANDARDS**
- E71T-GS
  - AWS A5.20

# CORED WIRE



## E71T-1M Rutile Flux Cored Wire (FCW 12)

STOCK CODE	SIZE
31002EIAM2	1.2 mm x 15 kg

CHEMICAL COMPOSITION			
	C	Mn	Si
%	0.05	1.45	0.45

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Protection Gas	M21
Yield Strength (N/mm <sup>2</sup> )	480 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	550 N/mm <sup>2</sup>
Elongation A5 (%)	28%
Charpy V-Notch Properties (J)	-20°C → 100



- KEY FEATURES**
- Rutile type flux cored wire, especially designed for welding in steel construction, piping, machine fabrication and shipbuilding by using mix shielding gas. Owing to it's easily controllable weld pool and fast freezing slag particularly suited for welding in all position. Good gapbridging property, low spatter loss, easy slag removal even in narrow grooves. Finely ripped porefree welds blending into base metal without undercut.

- STANDARDS**
- AWS/ASME SFA 5.20 E71T-1M
  - EN ISO 17632 A T46 2 P M 1

- CURRENT TYPE**
- DC+

# METAL CORED WIRE

## E70C-6M H4 Metal Cored Wire (FCW 21)



STOCK CODE	SIZE
31021EHAM2	1.20 mm x 15 kg

CHEMICAL COMPOSITION			
	C	Mn	Si
%	0.06	1.60	0.60

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
Protection Gas	M21
Yield Strength (N/mm <sup>2</sup> )	500 N/mm <sup>2</sup>
Tensile Strength (N/mm <sup>2</sup> )	580 N/mm <sup>2</sup>
Elongation A5 (%)	24%
Charpy V-Notch Properties (J)	-20°C → 100J / -40°C → 60J

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

**KEY FEATURES**

- Slagless metal powder cored electrode with outstanding welding properties in the short-arc and spray arc range. Weld metal has very high toughness and charpy impact resistance, so it is suitable and reliable to use down to -40°C. Almost spatter-free when welding in the spray-arc range with mixed gas. Good restriking, even with cold wire tip, thus being suitable for robot application. Characteristic features high deposition rate and welding speed, good side wall fusion, finely rippled welds, without undercutting into the base metal, not even on contaminated or corroded metal surfaces. Little formation of silicates on weld surface, so that multi-pass welds can be made without cleaning. Due to its easily controllable weld pool in the short-arc range, FCW 21 is well-suited for root-and positional welding and gap bridging.

**STANDARDS**

- AWS/ASME SFA 5.18 E70C6M H4
- EN ISO 17632 A T46 4 M M 2 H5

# GAS WELDING WIRE

## CCMS



STOCK CODE	SIZE
XP10600	1.6 mm x 5.0 kg
XP10603	2.4 mm x 5.0 kg
XP10606	3.2 mm x 5.0 kg

CHEMICAL COMPOSITION			
	C	Mn	Si
%	0.08	0.50	0.10

MECHANICAL PROPERTIES (ALL WELD MATERIAL)	
0.2% Proof Stress Rp 0.2%	≥260MPa
Tensile strength Rm	≥360MPa
Elongation 4d/5d	≥20%

**WELDING POSITIONS**

**CURRENT TYPE**

- DC+

**KEY FEATURES**

- Suitable for joining tubes and plates. Highly fluid weld metal.

**STANDARDS**

- EN ISO 20378: I
- AWS A5.2: R45



# TUNGSTEN ELECTRODES

## ■ 2% Thoriated Tungsten Electrodes

- Composition: 98% Tungsten, 2% Thorium.
- Application: DC Welding on Carbon Steel, Stainless Steel, Nickel and Titanium.
- Specialty: AC Welding on thin gauge Aluminum and material less than 1.5mm.
- Note: Thorium is radioactive; Always follow the manufacturer's warnings, instructions, and Material Safety Data Sheet (MSDS).

### ■ 2% THORIATED TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.0MM 2%	1.0mm x 150mm
1.2MM 2%	1.2mm x 150mm
1.6MM 2%	1.6mm x 150mm
2.0MM 2%	2.0mm x 150mm
2.4MM 2%	2.4mm x 150mm
3.2MM 2%	3.2mm x 150mm
4.0MM 2%	4.0mm x 150mm
4.8MM 2%	4.8mm x 150mm
6.4MM 2%	6.4mm x 150mm

### ■ 2% THORIATED TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.0MM 2%/175	1.0mm x 175mm
1.2MM 2%/175	1.2mm x 175mm
1.6MM 2%/175	1.6mm x 175mm
2.0MM 2%/175	2.0mm x 175mm
2.4MM 2%/175	2.4mm x 175mm
3.2MM 2%/175	3.2mm x 175mm
4.0MM 2%/175	4.0mm x 175mm
4.8MM 2%/175	4.8mm x 175mm
6.4MM 2%/175	6.4mm x 175mm

## ■ Pure Tungsten Electrodes

- Composition: 99.9% Tungsten.
- Application: AC Welding on Carbon Steel, Stainless Steel, Nickel and Titanium.
- Specialty: A low cost solution for AC welding.
- Note: Not suitable for DC welding and shorter life with AC welding.

### ■ PURE TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.6MM P	1.6mm x 150mm
2.0MM P	2.0mm x 150mm
2.4MM P	2.4mm x 150mm
3.2MM P	3.2mm x 150mm

### ■ PURE TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.6MM P/175	1.6mm x 175mm
2.0MM P/175	2.0mm x 175mm
2.4MM P/175	2.4mm x 175mm
3.2MM P/175	3.2mm x 175mm

## ■ 1% Lanthanated Tungsten Electrodes

- Composition: 99% Tungsten, 1% Lanthanum.
- Application: DC Welding on Carbon Steel, Stainless Steel, Nickel and Titanium.
- Specialty: Maintains a point well and can be used with AC.

### ■ 1% LANTHANUM TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.6MM L	1.6mm x 150mm
2.0MM L	2.0mm x 150mm
2.4MM L	2.4mm x 150mm

### ■ 1% LANTHANUM TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.6MM L/175	1.6mm x 175mm
2.0MM L/175	2.0mm x 175mm
2.4MM L/175	2.4mm x 175mm

## ■ 2% Lanthanated Tungsten Electrodes

- Composition: 98% Tungsten, 2% Lanthanum.
- Application: DC Welding on Carbon Steel, Stainless Steel, Nickel and Titanium.
- Specialty: Easy Ignition Low Power consumption both AC and DC Welding.

### ■ LANTHANUM TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.6MM L2	1.6mm x 150mm
2.4MM L2	2.4mm x 150mm

### ■ LANTHANUM TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.6MM L2/175	1.6mm x 175mm
2.4MM L2/175	2.4mm x 175mm



# TUNGSTEN ELECTRODES

## ■ Gold Tungsten Electrodes (Lanthanum 1.5%)

- Composition: 98.5% Tungsten, 1.5% Lanthanum.
- Application: DC Welding on Carbon Steel, Stainless Steel, Nickel and Titanium.
- Specialty: Excellent arc striking. Can replace 2% Thoriated without changing welding parameters.
- Note: Can be used for AC welding with a pointed tip on square wave and has a high current capacity.

### ■ GOLD TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.6MM G	1.6mm x 150mm
2.0MM G	2.0mm x 150mm
2.4MM G	2.4mm x 150mm
3.2MM G	3.2mm x 150mm

### ■ GOLD TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.6MM G/175	1.6mm x 175mm
2.0MM G/175	2.0mm x 175mm
2.4MM G/175	2.4mm x 175mm
3.2MM G/175	3.2mm x 175mm

## □ Zirconiated Tungsten Electrodes

- Composition: 99.2% Tungsten, 0.8% Zirconium.
- Application: AC Welding on Aluminum and Magnesium alloys.
- Specialty: A very stable arc whilst maintaining a balled tip.
- Note: Not recommended for DC Welding.

### ■ 0.8% ZIRCONIATED TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.0MM Z	1.0mm x 150mm
1.6MM Z	1.6mm x 150mm
2.0MM Z	2.0mm x 150mm
2.4MM Z	2.4mm x 150mm
3.2MM Z	3.2mm x 150mm
4.0MM Z	4.0mm x 150mm
4.8MM Z	4.8mm x 150mm

### ■ 0.8% ZIRCONIATED TUNGSTEN ELECTRODES 175MM

STOCK CODE	SIZE
1.0MM Z/175	1.0mm x 175mm
1.6MM Z/175	1.6mm x 175mm
2.0MM Z/175	2.0mm x 175mm
2.4MM Z/175	2.4mm x 175mm
3.2MM Z/175	3.2mm x 175mm
4.0MM Z/175	4.0mm x 175mm
4.8MM Z/175	4.8mm x 175mm

## ■ 2% Ceriated Tungsten Electrodes

- Composition: 98% Tungsten, 2% Cerium.
- Application: DC Welding.
- Specialty: DC welding at low current settings but can be used fully in AC processes, Orbital tube and pipe fabricating applications, thin sheet metal work and intricate welding.
- Note: Not recommended for High Amperage welding.

### ■ 2% CERIATED TUNGSTEN ELECTRODES 150MM

STOCK CODE	SIZE
1.6MM C	1.6mm x 150mm
2.0MM C	2.0mm x 150mm
2.4MM C	2.4mm x 150mm
3.2MM C	3.2mm x 150mm
4.0MM C	4.0mm x 150mm
4.8MM C	4.8mm x 150mm

### ■ 2% CERIATED TUNGSTEN ELECTRODES 175MM

STOCK CODE	DESCRIPTION
1.6MM C/175	1.6mm x 175mm
2.0MM C/175	2.0mm x 175mm
2.4MM C/175	2.4mm x 175mm
3.2MM C/175	3.2mm x 175mm
4.0MM C/175	4.0mm x 175mm
4.8MM C/175	4.8mm x 175mm

## ■ 3 Element Tungsten Electrodes

- Composition: 98.34% Tungsten, 1.5% Lanthanum, 0.08% Zirconium, 0.08% Yttrium.
- Application: AC and DC welding applications.
- Specialty: Repeated arc striking whilst maintaining a point.
- Note: Alternative for Thoriated and Zirconiated Tungsten's Electrodes.

### ■ 3 ELEMENT TUNGSTEN ELECTRODES 150MM

STOCK CODE	DESCRIPTION
1.0MM 3	1.0mm x 150mm
1.6MM 3	1.6mm x 150mm
2.0MM 3	2.0mm x 150mm
2.4MM 3	2.4mm x 150mm
3.2MM 3	3.2mm x 150mm

### ■ 3 ELEMENT TUNGSTEN ELECTRODES 175MM

STOCK CODE	DESCRIPTION
1.0MM 3/175	1.0mm x 175mm
1.6MM 3/175	1.6mm x 175mm
2.0MM 3/175	2.0mm x 175mm
2.4MM 3/175	2.4mm x 175mm
3.2MM 3/175	3.2mm x 175mm

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