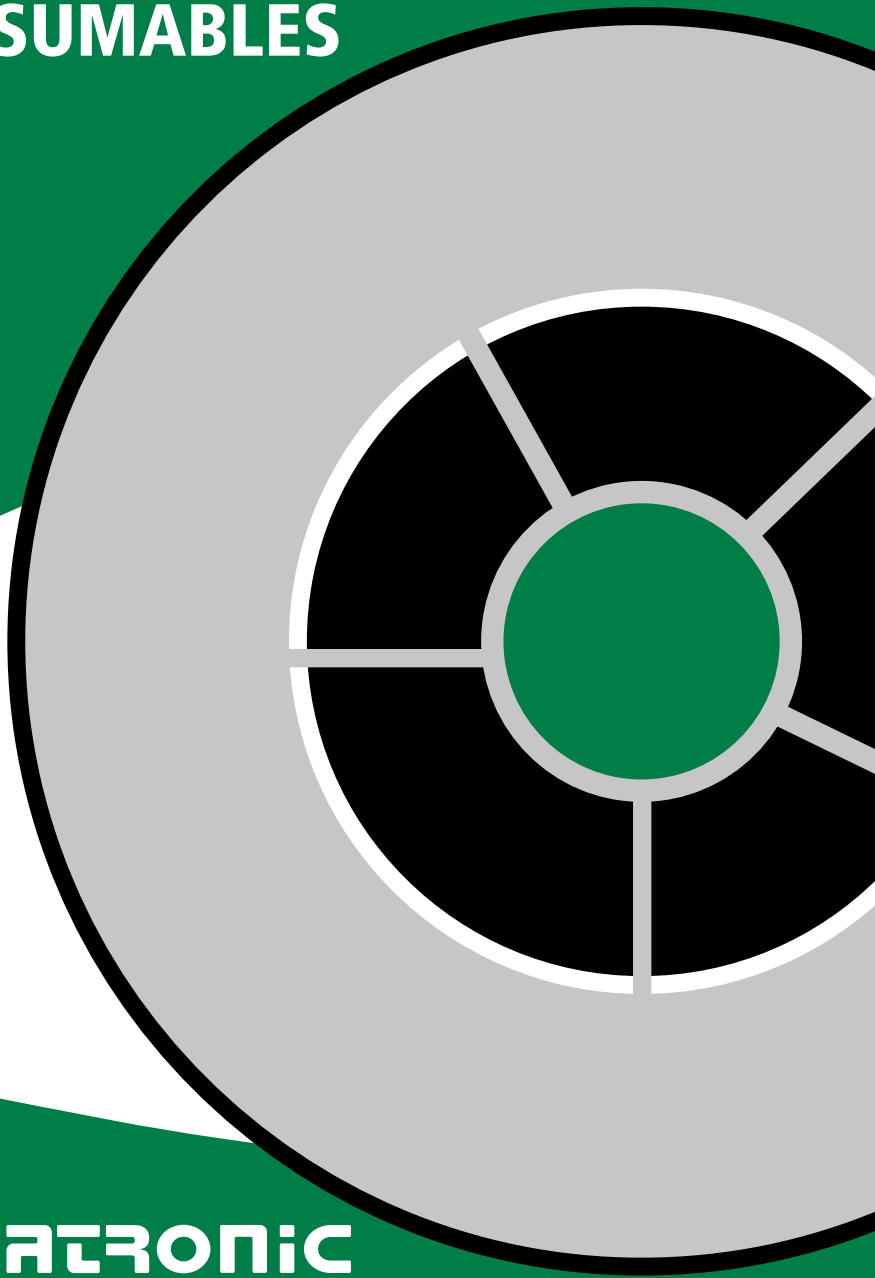


# MIGATRONIC CONSUMABLES



**MIGATRONIC**  
WELDING VALUE

# CONTENT

## MIG/MAG

### Solid wire - mild steel

SG2 Precision Layer Wire - Copper-free .....	6
SG2 Random wire - Copper-coated .....	6
SG2 Precision Layer Wire - Copper-coated .....	7
SG3 Precision Layer Wire - Copper-coated .....	7

### Solid wire - others

MIGAWIRE HTS for high-tensile steel .....	8
MIG 80S NI for fine-grained steel and high-tensile steel.....	8
MIGA SG CU for corten steel .....	8
MIGA SG1 Galva Wire for galvanised plates and workpieces for galvanising.....	9
MIGA HARD 600 for hardfacing.....	9

### Stainless steel

MIG 309 LSi .....	10
MIG 316 LSi .....	10

### Aluminium wire

ALU MIG AISi5 .....	11
ALU MIG AISi12 .....	11
ALU MIG AlMg 4.5Mn.....	11
ALU MIG AlMg 5 .....	12

### Wire for MIG brazing

MIGA MIG CuSi 3.....	12
MIGA MIG CuAl 8.....	12

### **Flux-cored wire - FCW**

MIGA FCW Innershield for mild steel.....	13
MIGA FCW115 for mild steel .....	13
MIGA FCW215 for mild steel .....	13
MIGA FCW217 for mild steel .....	14
MIGA FCW Hard 5CR for hardfacing.....	14

## **TIG**

### **Mild steel**

MIGA KV2 TIG for mild steel .....	15
-----------------------------------	----

### **Stainless steel**

TIG 309 LSi .....	15
TIG 316 LSi .....	16

### **Aluminium wire**

ALU TIG AlSi 5 .....	16
ALU TIG AlMg 4.5Mn .....	16
ALU TIG AlMg 5.....	17

### **Tungsten electrodes**

Tungsten electrode WP - Green .....	17
Tungsten electrode WL10 - Black.....	17
Tungsten electrode WL20 - Blue .....	18
Tungsten electrode WS2 - Super Blue.....	18
Tungsten electrode WL20 - pointed 20 degrees .....	18

## MMA

### Basic / Rutile-coated electrodes

MIGA R 100 rutile-coated electrode .....	19
MIGA B 120 basic electrode.....	19
MIGA NI nickel electrode.....	20
MIGA 600B for hardfacing.....	20
RB86 double-coated basic (rutile-basic).....	20

### Stainless electrodes

316L stainless electrode .....	21
--------------------------------	----

### Gouging

Gouging electrode DC .....	21
----------------------------	----

## Backing material

Aluminium tape for backing .....	22
Ceramic backing on tape .....	22
Magnet til ceramic backing .....	22

## Contact

If you have any questions relating to our consumable products, please do not hesitate to contact us by sending an e-mail to:

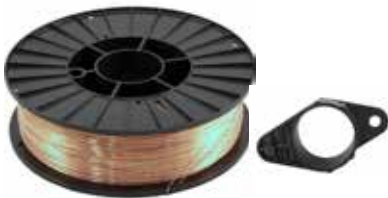
[Consumables@Migatronic.com](mailto:Consumables@Migatronic.com)

## CLASSIFICATION LEGEND

### EXAMPLE: G 42 2 M 3Si1

- G = Solid wire  
42 = Yield strength / Tensile strength  
2 = Temperature for minimum average impact energy  
M / C = Shielding gas  
M2 : Mixed gas without He  
M21: Mixed gas Ar+ >15 to 25% CO<sub>2</sub>  
C1 : Active gas 100 % CO<sub>2</sub>  
3Si1 = Chemical composition
- 

## SPOOL TYPES:

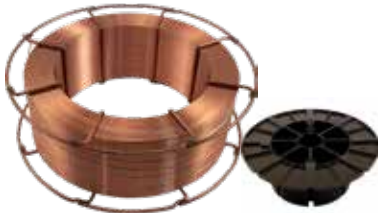


### D200 plastic spool

Use adapter 45050333 on machines prepared for 300mm spools.

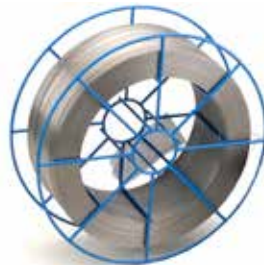


### D300 plastic spool



### K300 steel spool

Use adapter 81899017 on K300 spools.



### BS300 steel spool with hub

## MIG/MAG CONSUMABLES

### Solid wire - mild steel

#### SG2 Precision Layer Wire - Copper-free

<b>Classification according to</b>		<b>EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b>			
Copper-free solid wire for mild steel. PLW quality.					
<b>Quality</b>	<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>
SG2	BS300/15 kg		81840562		
SG2	BS300/15 kg			81840564	
SG2	BS300/15 kg				81840565

#### SG2 Random wire - Copper-coated

<b>Classification according to</b>		<b>EN ISO 14341-A: G 46 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b>			
Copper-coated solid wire in SG2 quality for mild steel. Random wire quality.					
<b>Quality</b>	<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>
SG2	D200/5 kg	81840611			
SG2	D300/15 kg	81840621			
<b>Classification according to</b>		<b>EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b>			
<b>Quality</b>	<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>
SG2	D200/5 kg		81840702		
SG2	D200/5 kg			81840704	
SG2	D200/5 kg				81840705

## Solid wire - mild steel

SG2 Precision Layer Wire - Copper-coated					
Classification according to		EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6			
Copper-coated solid wire in SG2 quality for mild steel. PLW quality.					
Quality	Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
SG2	BS300/15 kg		81840762		
SG2	BS300/15 kg			81840764	
SG2	BS300/15 kg				81840765
SG2	300 kg fustage			81840774	
SG2	300 kg fustage				81840775

SG3 Precision Layer Wire - Copper-coated					
Classification according to		EN ISO 14341-A: G 46 4 M21 4Si1 / G 42 3 C1 4Si1 AWS A5.18: ER 70S-6			
Copper-coated solid wire in SG3 quality for mild steel. PLW quality.					
Quality	Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
SG3	BS300/15 kg		81840962		
SG3	BS300/15 kg			81840964	
SG3	BS300/15 kg				81840965
SG3	300 kg fustage		81840972		
SG3	300 kg fustage			81840974	
SG3	300 kg fustage				81840975

## Solid wire - others

MIGAWIRE HTS - Precision Layer Wire				
Classification according to	EN ISO 16834-A: G 69 4 M Mn3Ni 1CrMo AWS A5.18: ER 100 S-G			
Solid wire for welding of high-tensile steel with tensile strength up to 755N/mm <sup>2</sup> . Applicable for cranes, pressure-carrying equipment and similar statically and dynamically influenced structures. PLW quality.				
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
D300/15 kg		81841408		
D300/15 kg			81841410	
D300/15 kg				81841412

MIG 80S NI				
Classification according to	EN ISO 14341-A: G 46 5 M21 3Ni1 AWS A5.28: ER 100 S-G			
Manganese-nickel-alloy wire for welding of fine-grained steel to low-temperature steel and high-tensile steel.				
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
D300/15 kg		81843000		

MIGA SG CU - Precision Layer Wire				
Classification according to	EN ISO 16834-A: G Mn3Ni1CU AWS A5.28: ER 80 S-G EN ISO 14341-A: G504M21Z			
Solid wire for welding of corten steel, which is a corrosion-slow steel type. Copper-coating ensures fine current transfer. PLW quality.				
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
D300/15 kg		81843208		
D300/15 kg			81843210	



## Solid wire - others

MIGA SG1 Galva Wire - Precision Layer Wire				
Classification according to	EN ISO 14341-A: G 422M21Z AWS A5.18: ER 70 S-G			
Solid wire in SG1 quality for welding of workpieces for subsequent galvanising. Also applicable for welding of galvanised, alu-coated or primed surfaces. PLW quality.				
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
D200/5 kg	81845106			
D200/5 kg		81845108		
D300/15 kg		81845008		
K300/15 kg			81845010	

MIGA HARD 600 - Precision Layer Wire				
Classification according to	EN ISO 14700: S FE8 AWS A5.14: MSG 6-6Z-60			
Solid wire for hardfacing. Applicable for rebuilding surfaces of heavily worn construction equipment shovels and the like. PLW quality.				
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm
D300/15 kg			81845310	
D300/15 kg				81845312



## Stainless steel

MIG 309 LSi					
<b>Classification according to</b>	<b>EN ISO 14343-A: G 23 12 LSi AWS A5.9: ER 309L (Si)</b>				
Applicable for welding of joints between mild steel and stainless steel. Also applicable for welding on unalloyed steel if you want an 18 Cr/8Ni steel surface. Recommended for buffer coating.					
<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
BS300/15 kg		81841708			
BS300/15 kg			81841710		
BS300/15 kg				81841712	

MIG 316 LSi					
<b>Classification according to</b>	<b>EN ISO 14343-A: G 19 123 LSi AWS A5.9: ER 316L (Si)</b>				
Applicable for welding of acid-proof low-carbon austenitic stainless steel. High silicon content provides fine flow properties. Operating temperature ranging from -196°C to 350°C.					
<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
D200/5 kg		81841805			
BS300/15 kg		81843808			
D200/5 kg			81841803		
BS300/15 kg			81843810		
BS300/15 kg				81843812	

## Aluminium wire

ALU MIG AlSi5					
<b>Classification according to</b>	<b>EN ISO 18273: S AL 4043 AWS A5.10: ER 4043</b>				
Aluminium wire with 5% silicon is the most common AlSi wire. Provides a nice surface. Ideal for the auto business and welding of common structures. Not seawater-proof and not suitable for workpieces which are subsequently anodised.					
<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
D300/6 kg			81846110		
D300/6 kg				81846112	

ALU MIG AlSi12					
<b>Classification according to</b>	<b>EN ISO 18273: S AL 4047 AWS A5.10: ER 4047</b>				
Aluminium wire with 12% silicon is softer than AlSi5 and light-fluid. Not seawater-proof and not suitable for workpieces which are subsequently anodised.					
<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
D300/6 kg				81846212	

ALU MIG AlMg 4.5MN					
<b>Classification according to</b>	<b>EN ISO 18273: S AL 5183 AWS A5.10: ER 5183</b>				
Aluminium wire with 4.5% magnesium plus manganese. Seawater-proof. Allows subsequent anodising of workpieces. Typically used for ship-building.					
<b>Spool type</b>	<b>0.6 mm</b>	<b>0.8 mm</b>	<b>1.0 mm</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
D300/6 kg			81846610		
D300/6 kg				81846612	

## Aluminium wire

ALU MIG AlMg 5					
Classification according to		EN ISO 18273: S AL 5356 AWS A5.10: ER 5356			
Aluminium wire with 5% magnesium is the most common and versatile filler material for aluminium. Seawater-proof. Allows subsequent anodising of workpieces.					
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm	1.6 mm
D200/2 kg		81846700			
D200/2 kg			81846701		
D200/2 kg				81846702	
D300/5 kg		81846708			
D300/6 kg			81846710		
D300/6 kg				81846712	
80 kg drum				81846725	
80 kg drum					81846732

## Wire for MIG brazing

MIGA MIG CuSi 3wire for MIG brazing					
Classification according to		EN ISO 18273: S CU 6560/SUSi3MN1 AWS A5.7: ER CuCi A			
Copper-silicon wire for MIG brazing. Typically used in the auto business for joining high-tensile steel or coated workpieces.					
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm	1.6 mm
D300/15 kg		81846808			
D200/5 kg		81846809			
D300/15 kg			81846810		
D200/5 kg			81846811		

MIGA MIG CuAl 8 wire for MIG brazing					
Classification according to		EN ISO 18273: S CU 6100/CUAL7 AWS A5.7: ER CuAl-A-1			
Copper-aluminium wire for MIG brazing. Typically used in the auto business for joining aluminium or coated workpieces.					
Spool type	0.6 mm	0.8 mm	1.0 mm	1.2 mm	1.6 mm
D200/5 kg		81890055			
D200/5 kg			81890056		

## Flux-cored wire - FCW

MIGA FCW Innershield for mild steel			
Classification according to		EN ISO 17632-A: T 46 Z Y N 1 AWS A5.20: E 71-T11	
Self-protective seamless cored wire for all welding positions. For unalloyed and low-alloy steel.			
Spool type	0.9 mm	1.0 mm	1.2 mm
D200/5 kg	81841104		
D200/5 kg			81841109
K300/16 kg			81841110

MIGA FCW115 for mild steel			
Classification according to		EN ISO 17632-A: T 46 6 MM1H5 AWS A5.18: E 70C-6 MH4	
Copper-coated seamless metal-cored wire. For single-pass and multi-pass welding of carbon-manganese steel and fine-grained steel.			
Spool type	0.9 mm	1.0 mm	1.2 mm
D200/5 kg			81841211
K300/16 kg			81841215

MIGA FCW215 for mild steel			
Classification according to		EN ISO 17632-A: T 46 2 PM1H5 AWS A5.20: E 71T-1 MH4	
Seamless rutile flux-cored wire for welding of carbon steel and carbon-manganese steel. Applicable for all welding positions.			
Spool type	0.9 mm	1.0 mm	1.2 mm
D200/5 kg		81841242	
D200/5 kg			81841220
K300/16 kg		81841222	
K300/16 kg			81841225

## Flux-cored wire - FCW

MIGA FCW217 for mild steel			
Classification according to		EN ISO 17632-A: T 50 6 1NiPM1H5 AWS A5.29: E 81T1-Ni1	
Seamless rutile flux-cored wire for single-pass and multi-pass welding of low-temperature steel.			
Spool type	0.9 mm	1.0 mm	1.2 mm
K300/16 kg			81841235

MIGA FCW Hard 5CR for hardfacing			
Classification according to		EN 14700: T FE 8 DIN 8555	
Chromium-molybdenum-alloy metal-cored wire for hardfacing. HRC 57-62.			
Spool type	0.9 mm	1.0 mm	1.2 mm
K300/16 kg			81841413

## TIG CONSUMABLES

### Mild steel

#### MIGA KV2 TIG for mild steel

<b>Classification according to</b>		<b>EN ISO 636-A: W MoSi AWS A5.28: ER 805-D2</b>	
TIG wire for welding of 0.5% molybdenum steel and pressure-carrying equipment. Prevents cold cracks in the welding metal. Applicable for boilers, pressure tanks, pipings if operating temperature <550°C.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81850116	1.6 mm	1000 mm	5 kg
81850120	2.0 mm	1000 mm	5 kg
81850124	2.4 mm	1000 mm	5 kg
81850132	3.2 mm	1000 mm	5 kg

### Stainless steel

#### TIG 309 LSi

<b>Classification according to</b>		<b>EN ISO 14343-A: W 23 12 LSi AWS A5.9: ER 309LSi</b>	
Applicable for welding of joints between mild steel and stainless steel. Also applicable for welding on unalloyed steel if you want an 18 Cr/8Ni steel surface. Recommended for buffer coating.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81851712	1.2 mm	1000 mm	5 kg
81851716	1.6 mm	1000 mm	5 kg
81851720	2.0 mm	1000 mm	5 kg
81851724	2.4 mm	1000 mm	5 kg
81851732	3.2 mm	1000 mm	5 kg

### TIG 316 LSi

<b>Classification according to</b>		<b>EN ISO 14343-A: W 19 12 3 L Si AWS A5.9: ER 316LSi</b>	
Applicable for welding of acid-proof low-carbon austenitic stainless steel. High silicon content provides fine flow properties. Operating temperature ranging from -196°C to 350°C.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81853810	1.0 mm	1000 mm	5 kg
81853812	1.2 mm	1000 mm	5 kg
81853816	1.6 mm	1000 mm	5 kg
81853820	2.0 mm	1000 mm	5 kg
81853824	2.4 mm	1000 mm	5 kg
81853832	3.2 mm	1000 mm	5 kg
81853840	4.0 mm	1000 mm	5 kg

## Aluminium wire

### ALU TIG AISi 5

<b>Classification according to</b>		<b>EN ISO 18273: S AL 40 43A AWS A5.10: ER 4043</b>	
Aluminium wire containing 5% silicon provides a nice surface. Suitable for standard structures. Not seawater-proof and not suitable for workpieces which are subsequently anodised.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81856124	2.4 mm	1000 mm	10 kg
81856132	3.2 mm	1000 mm	10 kg

### ALU TIG AlMg 4.5Mn

<b>Classification according to</b>		<b>EN ISO 18273: S AL 5183 AWS A5.10: ER 5183</b>	
Aluminium wire containing 4.5% magnesium plus manganese. Seawater-proof. Allows subsequent anodising of workpieces. Typically used for ship-building.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81856616	1.6 mm	1000 mm	10 kg
81856624	2.4 mm	1000 mm	10 kg
81856632	3.2 mm	1000 mm	10 kg
81856640	4.0 mm	1000 mm	10 kg



## ALU TIG AlMg 5

<b>Classification according to</b>	<b>EN ISO 18273: S AL 5356</b> <b>AWS A5.10: ER 5356</b>		
Aluminium wire containing 5% magnesium. The most common and allround filler material for aluminium. Seawater-proof. Allows subsequent anodising of workpieces.			
<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
81856716	1.6 mm	1000 mm	10 kg
81856720	2.0 mm	1000 mm	10 kg
81856724	2.4 mm	1000 mm	10 kg
81856732	3.2 mm	1000 mm	10 kg

## Tungsten electrodes

### Tungsten Electrode WP - Green

#### Classification according to EN ISO 6848: WP

Unalloyed tungsten electrode. Applicable for AC/DC welding of aluminium and magnesium.

<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
80360022	1.6 mm	175 mm	10 pcs.
80360024	2.4 mm	175 mm	10 pcs.
80360026	3.2 mm	175 mm	10 pcs.

### Tungsten Electrode WL10 - Black

#### Classification according to EN ISO 6848: WLA10

Tungsten electrode containing 1% lanthanum oxide. Applicable for DC welding of mild steel and stainless steel and AC/DC welding of aluminium.

<b>Art. no.</b>	<b>Diameter</b>	<b>Length</b>	<b>Packing</b>
80360042	1.6 mm	175 mm	10 pcs.
80360043	2.4 mm	175 mm	10 pcs.
80360044	3.2 mm	175 mm	10 pcs.

### Tungsten Electrode WL20 - Blue

#### Classification according to EN ISO 6848: WLA20

Tungsten electrode containing 2% lanthanum oxide. Applicable for DC welding of mild steel and stainless steel and AC/DC welding of aluminium.

Art. no.	Diameter	Length	Packing
80360092	1.6 mm	175 mm	10 pcs.
80360094	2.4 mm	175 mm	10 pcs.
80360095	3.2 mm	175 mm	10 pcs.

### Tungsten Electrode WS2 - Super Blue

#### Classification according to EN ISO 6848: WG

Migatronic top-quality allround tungsten electrode. Applicable for DC and AC/DC welding of all materials. Fine ignition properties and stable arc provide pure welding and long service life.

Art. no.	Diameter	Length	Packing
80361371	1.0 mm	175 mm	10 pcs.
80361372	1.6 mm	175 mm	10 pcs.
80361373	2.0 mm	175 mm	10 pcs.
80361374	2.4 mm	175 mm	10 pcs.
80361376	3.2 mm	175 mm	10 pcs.
80361377	4.0 mm	175 mm	10 pcs.
80361378	4.8 mm	175 mm	10 pcs.

### Tungsten Electrode WL20 - Blue - Pointed 20 degrees

#### Classification according to EN ISO 6848: WLA20

Tungsten electrode for plasma welding.

Art. no.	Diameter	Length	Packing
80361396	4.8 mm	91 mm	1 pcs.
80361397	4.8 mm	111 mm	1 pcs.

## MMA CONSUMABLES

### Basic / Rutile-coated electrodes

MIGA R 100 Rutile-coated electrode				
<b>Classification according to</b>		EN ISO 2560-A: E 42 0 RC 11 AWS A5.1: E6013		
Rutile-coated electrode with rapid-hardening slag, which makes it ideal for all welding positions. Allround electrode applicable for welding in mild steel. Fine ignition properties.				
Art. no.	Diameter	Length	Packing	Welding positions
81331025	2.5 mm	350 mm	5 kg	All
81331032	3.2 mm	350 mm	5 kg	All
81331040	4.0 mm	350 mm	5 kg	All
81351025	2.5 mm	350 mm	Blister with 14 pcs.	All
81351032	3.2 mm	350 mm	Blister with 9 pcs.	All

MIGA B 120 Basic electrode				
<b>Classification according to</b>		EN ISO 2560-A: E 42 4 B 4 2 H5 AWS A5.1: E7018-1H4		
Basic high-yield electrode with good impact strength down to -50°C and low hydrogen content. Applicable for mechanically weight-carrying joints and other complicated structures.				
Art. no.	Diameter	Length	Packing	Welding positions
81431325	2.5 mm	350 mm	5 kg	All but vertical downwards (PG)
81431332	3.2 mm	350 mm	5 kg	All but vertical downwards (PG)
81431432	3.2 mm	450 mm	6.7 kg	All but vertical downwards (PG)
81451325	2.5 mm	350 mm	Blister with 14 pcs.	All but vertical downwards (PG)
81451332	3.2 mm	350 mm	Blister with 8 pcs.	All but vertical downwards (PG)

## Basic / Rutile-coated electrodes

MIGA NI Nickel electrode				
<b>Classification according to</b>		ENiFE-CL AWS A5.11: E Ni C1		
Graphited nickel-alloyed electrode. Applicable for repair and maintenance in cast iron, such as pump casings, bedplates, engine blocks. Subsequent finishing is possible.				
Art. no.	Diameter	Length	Packing	Welding positions
81351125	2.5 mm	300 mm	Blister with 11 pcs.	All
81351132	3.25 mm	350 mm	Blister with 9 pcs.	All

MIGA 600B Hardfacing				
<b>Classification according to</b>		EN ISO 14700: E FE 4 AWS A5.11: DIN 8585-83		
Basic electrode for hardfacing. Applicable for rebuilding surfaces of heavily worn construction equipment shovels and the like.				
Art. no.	Diameter	Length	Packing	Welding positions
81351232	3.25 mm	450 mm	Blister with 8 pcs.	Flat (PA) and horizontal FW (PB)

RB86				
<b>Classification according to</b>		EN ISO 2560-A: E 42 2 B 1 2 H10 AWS A5.11: E 7016		
Double-coated basic-rutile electrode for carbon and carbon-manganese steel with tensile strength up to 510MPa. Applicable for maintenance and dirty work-pieces.				
Art. no.	Diameter	Length	Packing	Welding positions
81430325	2.5 mm	350 mm	2 kg	All but vertical downwards (PG)
81430332	3.2 mm	350 mm	2 kg	All but vertical downwards (PG)

## Stainless electrodes

316L Stainless electrode				
Classification according to		EN ISO 3581-A: E 19 12 3 LR AWS A5.4: E 316L-16		
Rutile electrode with low carbon content. Applicable for welding of austenitic stainless steel with application temperature up to 400°C. Acid-proof welding metal with good corrosion-resistance.				
Art. no.	Diameter	Length	Packing	Welding positions
81351320	2.0 mm	350 mm	Blister with 12 pcs.	All
81351325	2.5 mm	350 mm	Blister with 10 pcs.	All
81351332	3.2 mm	350 mm	Blister with 8 pcs.	All

## Gouging

Gouging electrode DC			
Gouging electrodes for cutting.			
Art. no.	Diameter	Length	Packing
81899005	5.0 mm	305 mm	50 pcs.
81899006	6.0 mm	305 mm	50 pcs.
81899008	8.0 mm	305 mm	50 pcs.
81899010	9.5 mm	305 mm	50 pcs.
81899013	12.7 mm	305 mm	50 pcs.

## BACKING MATERIAL

### Aluminium tape for backing

Aluminium tape for fixation of ceramic backing.

Art. no.	Packing
81790102	1 roll, thickness: 100 $\mu$

### Ceramic backing on tape

Ceramic backing ensures high-quality root passes with an even weld profile. Applicable for thick materials as support for root passes.

Art. no.	Packing	
81791005	60	Ceramic backing on tape 026-2410 U 6T 600
81791073	60	Ceramic backing sloping 600 mm on aluminium tape
81791077	60	Ceramic backing 1C42-CEX600 mm on aluminium tape
81791090	60	Ceramic backing 1B93A25/600 mm on aluminium tape
81792007	120	Ceramic backing $\varnothing$ 7x600 mm on aluminium tape
81792009	100	Ceramic backing $\varnothing$ 9x600 mm on aluminium tape
81792012	90	Ceramic backing $\varnothing$ 12x600 mm on aluminium tape
81792015	70	Ceramic backing $\varnothing$ 15x500 mm on aluminium tape

### Magnet for ceramic backing

Magnet for fixation of ceramic backing.

Art. no.	
81792102	Magnet for ceramic backing



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