

WIRES FOR TIG & MIG



GTAW/TIG BRAND	GMAW/MIG BRAND	WIRE CHEMICAL ANALYSIS (TYPICAL)															APPLICATION	
		C	Mn	Si	Cr	Ni	Mo	Cu	V	N	Nb	Al	Ti	Zr	Mg	W		Fe
TIGFIL 70SG	AUTOMIG 70SG	0.06	1.3	0.8														Suitable for welding Carbon steels, ASTM A-106 Gr B, etc.,
TIGFIL 70S2	AUTOMIG 70S2	0.05	1.2	0.6								0.1	0.1	0.1				Suitable for welding carbon and micro alloyed steel.
	AUTOMIG 70S-6	0.09	1.5	0.9														Wide applications in automotive industry, construction and mining equipment , railway wagons and coaches, etc.,
TIGFIL 70S2(Spl)	AUTOMIG 70S2(Spl)	0.05	1.2	0.6								0.1	0.1	0.1				Suitable for welding NACE pipes - type A 106 Gr B or equivalent, structurals impacts down to -51°C.Weldmetal with low S & P (0.015 max).
TIGFIL 80SG	AUTOMIG 80SG	0.1	1	0.7	1.2						0.5							Suitable for welding 1Cr 0.5Mo steels.
TIGFIL 80SB2	AUTOMIG 80SB2	0.09	0.6	0.6	1.4						0.5							Suitable for welding 1Cr 0.5Mo steels.
TIGFIL 80SB6	AUTOMIG 80SB6	0.05	0.4	0.4	5.4						0.6							For welding 5Cr 0.5Mo steels.
TIGFIL 80SB8	AUTOMIG 80SB8	0.04	0.6	0.4	9.5	0.3	1											For welding 9Cr 1Mo steels.
TIGFIL 90SD2	AUTOMIG 90S-D2	0.09	1.9	0.7		0.1	0.5											Mn-Mo alloyed weld metal for high strength steels.
TIGFIL 70S-A1	AUTOMIG 70S-A1	0.09	1.2	0.7			0.5											Suitable for welding C-Mo steels.
TIGFIL 90SG	AUTOMIG 90SG	0.06	1.1	0.7	2.8		0.5											Suitable for welding 2.25Cr 1 Mo steels.
TIGFIL 90SB3	AUTOMIG 90SB3	0.09	0.6	0.6	2.5		1.1											Suitable for welding 2Cr 1Mo steels.
TIGFIL 90SB9	AUTOMIG 90SB9	0.1	0.5	0.4	8.6	0.5	0.9	0.3	0.2	0.03	0.07							Suitable for welding P91 / T91 and equivalent steel.
TIGFIL 80SNi 1	AUTOMIG 80SNi	0.06	1.2	0.6		1												For welding of 1%Ni steel for temperatures down to -46°C.
TIGINOX 308	MIGINOX 308	0.05	1.6	0.4	20	10												For welding stainless steels AISI 301,302,304 and 308.
TIGINOX 308L	MIGINOX 308L	0.03	1.6	0.4	20	10												For welding stainless steels AISI 301,302,304 and 308.
TIGINOX 347	MIGINOX 347	0.04	1.5	0.4	20	10						0.5						For welding SS of similar composition stabilized with either Nb or Ti.
TIGINOX 316	MIGINOX 316	0.05	1.5	0.4	19	12	2.5											For welding of stainless steels AISI 316.
TIGINOX 316L	MIGINOX 316L	0.03	1.5	0.4	19	12	2.5											For welding of stainless steels AISI 316L and 316.
TIGINOX 309	MIGINOX 309	0.04	1.5	0.5	24	13												For welding of stainless steels AISI 309. Suitable for buttering 18/8 Cr-Ni steels. dissimilar joints between CS and SS.
TIGINOX 309L	MIGINOX 309L	0.03	1.5	0.5	24	13												For welding of SS AISI 309 and 309L. Suitable for buttering 18/8 Cr-Ni steels. dissimilar joints between CS and SS.
TIGINOX 309Mo	MIGINOX 309Mo	0.04	1.5	0.5	24	13	2.5											Suitable for surfacing ,joining CS to SS containing Mo.
TIGINOX 310	MIGINOX 310	0.1	1.5	0.5	26	21												Suitable for welding of SS type AISI 310 and for joining dissimilar steels.
TIGINOX 312	MIGINOX 312	0.1	1.55	0.5	30	9.5												For welding dissimilar metals such as CS to SS etc.Highly crack resistant weldmetal
TIGINOX 410	MIGINOX 410	0.08	0.4	0.4	13													For welding of stainless steels AISI 403,405,410 etc.
TIGINOX 430	MIGINOX 430	0.06	0.4	0.4	16													For welding of stainless steels AISI 430 and similar grades.
TIGINOX 385		0.02	1.8	0.4	21	25	4.8	1.6										For welding Alloy 20, 904L,HV9,2RK65 etc for sulphuric, phosphoric acid service
TIGINOX 2209		0.02	1.5	0.7	23	8.5	3	0.3			0.15							For welding duplex SS like 31803 etc.,
TIGINOX 2594		0.02	1.5	0.7	26	9.5	3.5	0.7			0.25						0.5	For welding super duplex SS where PRE > 40 is required.
TIGFIL 4043			0.03	5								Rem	0.1					For welding many similar and dissimilar alloys.
TIGFIL 5356			0.15	0.2	0.1							Rem	0.1		5			For welding 5083,5086,5456 material.
TIGFIL NiCr3		0.04	3	0.4	21	Rem												For welding Inconel 600,Inconel 800,similar and dissimilar combinations in SS,CS,etc.,
TIGFIL NiCrMo-3		0.04	0.3	0.4	22	Rem	9					3.9	0.1	0.1				For welding nickel-chromium-molybdenum alloy to itself, to steel, to other nickel-base alloys, and for cladding steel with nickel-chromium-molybdenum weld metal.
TIGFIL Ni-1		0.05	0.5	0.6		Rem						1	2.8					For welding wrought and cast forms of commercially pure nickel alloy to itself and to CS.
TIGFIL NiCu-7		0.04	2.5	1		65		Rem				1	2.2					For welding nickel-copper alloy to itself and to CS.



WELDERS TO THE NATION
ADOR WELDING LIMITED
 (Formerly Known as Advani Oerlikon Ltd.)

