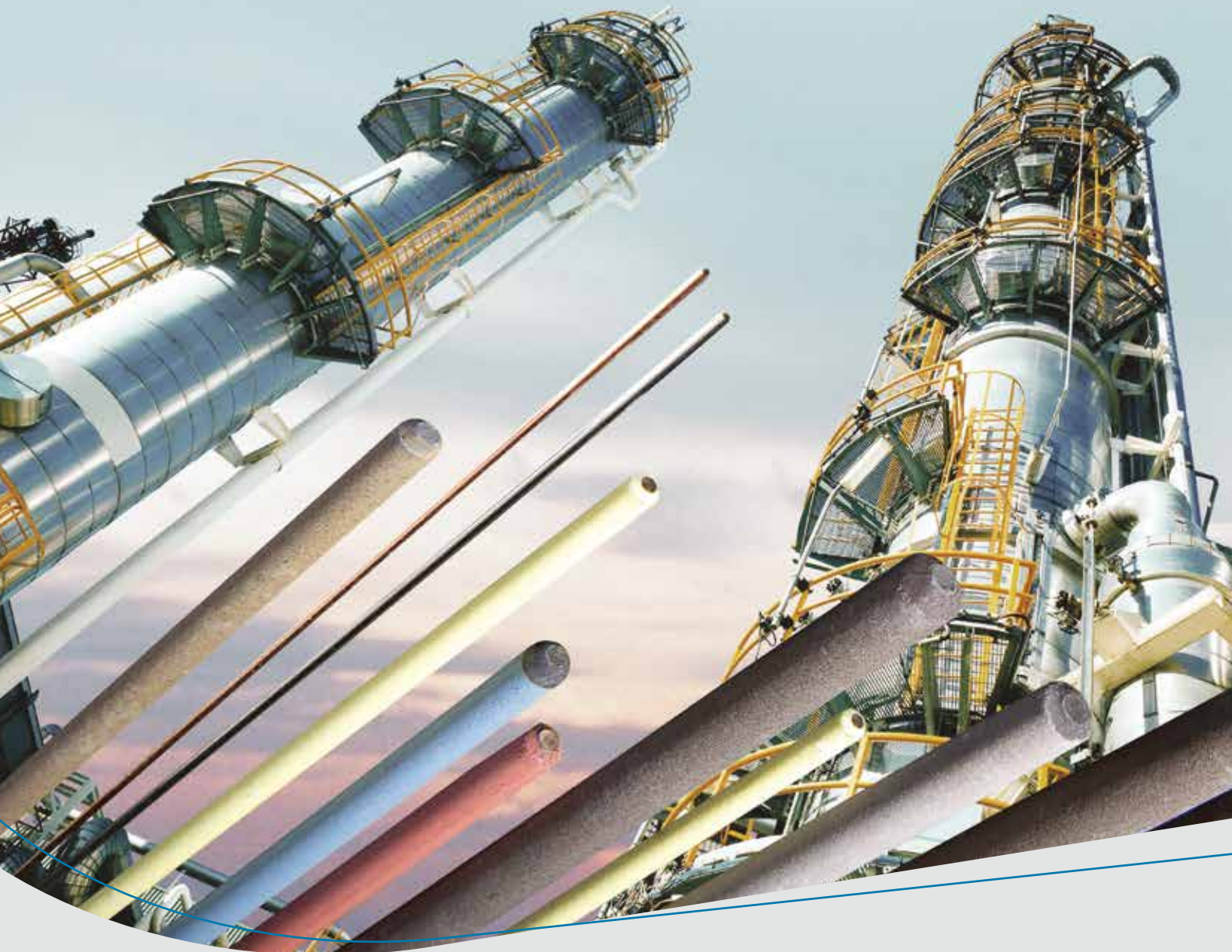




voestalpine Böhler Welding

Filler Metals for the Chemical Industry



	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN
		ASTM-UNS/ALLOY	EN			
Austenitic Stainless Steel	Austenitic	304L	1.4307- 1.4306	SMAW	Avesta 308L/MVR-3D	AWS A5.4:E308L-17 EN ISO 3581-A: E 19 9 L R
					Avesta 308L/MVR-4D	AWS A5.4:E308L-17 EN ISO 3581-A: E 19 9 L R
					Avesta 308L/MVR-PW AC/DC	AWS A5.4:E308L-17 EN ISO 3581-A: E 19 9 L R
					BÖHLER FOX EAS 2-A	AWS A5.4:E308L-17 EN ISO 3581-A: E 19 9 L R 3 2
					BÖHLER FOX EAS 2	AWS A5.4:E308L-15 EN ISO 3581-A: E 19 9 L B 2 2
				SAW Wire	Avesta 308L/SKR	AWS A5.9:ER308L EN ISO 14343 S 19 9 L
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC
					Avesta Flux 801	- EN ISO 14174: SA CS 2 Cr DC
				GTAW	Avesta 308L/MVR	AWS A5.9:ER308L EN ISO 14343-A: W 19 9 L
					BÖHLER EAS 2-IG	AWS A5.9:ER308L EN ISO 14343-A: W 19 9 L
				GMAW	Avesta 308L-Si/MVR-Si	AWS A5.9:ER308LSi EN ISO 14343-A: G 19 9 L Si
					BÖHLER EAS 2-IG (Si)	AWS A5.9:ER308LSi EN ISO 14343-A: G 19 9 L Si
					BÖHLER EAS 2-MC	AWS A5.9:EC308L EN ISO 17633-A: T 19 9 L MM 1
				FCAW	BÖHLER EAS 2-FD	AWS A5.22:E308LT0-4/1 EN ISO 17633-A: T 19 9 L R M (C) 3
					BÖHLER EAS 2 PW-FD	AWS A5.22:E308LT1-4/1 EN ISO 17633-A: T 19 9 L P M (C) 1
	316L	1.4404- 1.4432	SMAW	Avesta 316L/SKR-3D	AWS A5.4:E316L-17 EN ISO 3581-A:E 19 12 3 L R	
				Avesta 316L/SKR-4D	AWS A5.4:E316L-17 EN ISO 3581-A:E 19 12 3 L R	
				Avesta 316L/SKR-PW AC/DC	AWS A5.4:E316L-17 EN ISO 3581-A:E 19 12 3 L R	
				BÖHLER FOX EAS 4 M-A	AWS A5.4:E316L-17 EN ISO 3581-A:E 19 12 3 L R	
				BÖHLER FOX EAS 4 M	AWS A5.4:E316L-15 EN ISO 3581-A:E 19 12 3 L B 2 2	
			SAW Wire	Avesta 316L/SKR	AWS A5.9:ER316L EN ISO 14343-A:S 19 12 3 L	
			SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC	
				Avesta Flux 801	- EN ISO 14174: SA CS 2 Cr DC	
			GTAW	Avesta 316L/SKR	AWS A5.9:ER316L EN ISO 14343-A:W 19 12 3 L	
				BÖHLER EAS 4 M-IG	AWS A5.9:ER316L EN ISO 14343-A:W 19 12 3 L	
			GMAW	Avesta 316L-Si/SKR-Si	AWS A5.9:ER316LSi EN ISO 14343-A: G 19 12 3 L Si	
				BÖHLER EAS 4 M-IG (Si)	AWS A5.9:ER316LSi EN ISO 14343-A: G 19 12 3 L Si	
				BÖHLER EAS 4 M-MC	AWS A5.9:EC316L EN ISO 17633-A: T 19 12 3 L MM 1	
			FCAW	BÖHLER EAS 4 M-FD	AWS A5.22:E316LT0-4/1 EN ISO 17633-A: T 19 12 3 L R M (C) 3	

Joining 2/9

	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN			
		ASTM-UNS/ALLOY	EN						
Austenitic Stainless Steel	347 321		1.4550 1.4541	FCAW	BÖHLER EAS 4 PW-FD	AWS A5.22:E316LT1-4/1 EN ISO 17633-A: T 19 12 3 L P M(C) 1	347 Nb stabilized grade		
				SMAW	BÖHLER FOX SAS 2-A	AWS A5.4:E347-17 EN ISO 3581-A: E 19 9 Nb R 3 2			
					BÖHLER FOX SAS 2	AWS A5.4:E347-15 EN ISO 3581-A: E 19 9 Nb B 2 2			
				SAW Wire	Avesta 347/MVNB	AWS A5.9:ER347 EN ISO 14343 S 19 9 Nb			
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC			
				GTAW	BÖHLER SAS 2-IG	AWS A5.9:ER347 EN ISO 14343-A: W 19 9 Nb			
				GMAW	BÖHLER SAS 2-IG (Si)	AWS A5.9:ER347 EN ISO 14343-A: G 19 9 Nb Si			
				FCAW	BÖHLER SAS 2-FD	AWS A5.22:E347T0-4/1 EN ISO 17633-A: T 19 9 Nb R M(C) 3			
					BÖHLER SAS 2 PW-FD	AWS A5.22:E347T1-4/1 EN ISO 17633-A: T 19 9 Nb P M(C) 1			
				316Ti	1.4571	SMAW		BÖHLER FOX SAS 4-A	AWS A5.4:E318-17 EN ISO 3581-A: E 19 12 3 Nb R 3 2
								BÖHLER FOX SAS 4	AWS A5.4:E318-15 EN ISO 3581-A: E 19 12 3 Nb B 2 2
						SAW Wire		Thermanit A	AWS A5.9:ER318 EN ISO 14343-A: S 19 12 3 Nb
						SAW Flux		Marathon 431	- EN ISO 14174: SA FB 2 DC
						GTAW		BÖHLER SAS 4-IG	AWS A5.9:ER318 EN ISO 14343-A: W 19 12 3 Nb
	GMAW	BÖHLER SAS 4-IG (Si)	AWS A5.9:ER318 (mod.) EN ISO 14343-A: G 19 12 3 Nb Si						
	FCAW	BÖHLER SAS 4-FD	AWS A5.22:E318T0-4/1 EN ISO 17633-A: T 19 12 3 Nb R M(C) 3						
		BÖHLER SAS 4 PW-FD	AWS A5.22:E318T1-4/1 EN ISO 17633-A: T 19 12 3 Nb P M(C) 1						
	317L	1.4438	SMAW	Avesta 317L/SNR-3D	AWS A5.9:ER317L -				
				BÖHLER FOX ASN 5-A	AWS A5.4:E317L-17 mod. EN ISO 3581-A: E 18 16 5 N L R 3 2				
				BÖHLER FOX ASN 5	AWS A5.4:E317L-15 (mod.) EN ISO 3581-A: E 18 16 5 N L B 2 2				
			SAW Wire	Avesta 317L/SNR	AWS A5.9:ER317L EN ISO 14343-A: S 19 13 4 L				
			SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC				
				GTAW	BÖHLER ASN 5-IG	AWS A5.9:ER317L (mod.) EN ISO 14343-A: W Z18 16 5 N L			
			Avesta 317L/SNR		AWS A5.9:ER317L EN ISO 14343-A: W 19 13 4 L				
			GMAW	Avesta 317L/SNR	AWS A5.9:ER317L EN ISO 14343-A: G 19 13 4 L				
				BÖHLER ASN 5-IG (Si)	AWS A5.9:ER317L (mod.) EN ISO 14343-A: G Z18 16 5 N L Si				
			FCAW	BÖHLER E 317L-FD	AWS A5.22:E317LT0-4/1 EN ISO 17633-A: T Z19 13 4 L R M(C) 3				
				BÖHLER E 317L PW-FD	AWS A5.22:E317LT1-4/1 EN ISO 17633-A: T Z19 13 4 L P M(C) 1				

Joining 3/9

	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN
		ASTM-UNS/ALLOY	EN			
Austenitic Stainless Steel	Special Austenitic and Super Austenitic	904L	1.4539	SMAW	BÖHLER FOX CN 20/25 M	AWS A5.4:E385-15 (mod.) EN ISO 3581-A: E 20 25 5 Cu N L B 2 2
					Avesta 904L-3D	AWS A5.4:E385-17 EN ISO 3581-A: E 20 25 5 Cu N L R
					Avesta 904L-PW AC/DC	- EN ISO 3581-A: E 20 25 5 Cu N L R
					BÖHLER FOX CN 20/25 M-A	AWS A5.4:E385-17 (mod.) EN ISO 3581-A: E 20 25 5 Cu N L R 3 2
				SAW Wire	Avesta 904L	AWS A5.9:ER385 EN ISO 14343-A: S 20 25 5 Cu L
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC
				GTAW	BÖHLER CN 20/25 M-IG	AWS A5.9:ER385 (mod.) EN ISO 14343-A: W Z20 25 5 Cu N L
					Avesta 904L	AWS A5.9:ER385 EN ISO 14343-A: W 20 25 5 Cu L
				GMAW	BÖHLER CN 20/25 M-IG (SI)	AWS A5.9:ER385 (mod.) EN ISO 14343-A: G Z20 25 5 Cu N L
					Avesta 904L	AWS A5.9:ER385 EN ISO 14343-A: G 20 25 5 Cu L
				FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)
				N08028/28	1.4563	SMAW
	SAW Wire	Thermanit 625	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625 (NiCr22Mo9Nb)			
	SAW Flux	Marathon 444	- EN 760: SA FB 2 AC			
	GTAW	Thermanit 30/40 E	AWS A5.9:ER383 (mod.) EN ISO 18274: S Ni 8025 (NiFe30Cr29Mo)			
	GMAW	Thermanit 30/40 E	AWS A5.9:ER383 (mod.) EN ISO 18274: S Ni 8025 (NiFe30Cr29Mo)			
	FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)			
	S31254/254SMo™ N08926	1.4547 1.4529	SMAW	Avesta P12-R basic	AWS A5.11:ENiCrMo-12 EN ISO 14172: E Ni 6627 (NiCr22Mo9)	
				Thermanit NiMo C 24	AWS A5.11:ENiCrMo-13 EN ISO 14172: E Ni 6059 (NiCr23Mo16)	
			SAW Wire	Thermanit 625	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625 (NiCr22Mo9Nb)	
			SAW Flux	Marathon 444	- EN 760: SA FB 2 AC	
			SAW Wire	Avesta P16	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)	
			SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC	
			GTAW	Avesta P12	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625 (NiCr22Mo9Nb)	
				Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)	
			GMAW	Avesta P12	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625 (NiCr22Mo9Nb)	
				Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)	
			FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)	
			S34565 S31654/654SMo™	1.4565 1.4652	SMAW	Thermanit NiMo C 24

Joining 4/9

	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN				
		ASTM-UNS/ALLOY	EN							
Austenitic Stainless Steel				SAW Wire	Avesta P16	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)				
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC				
				GTAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)				
				GMAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)				
		NR20033/33 N08031/31	1.4591 1.4562	SMAW	Thermanit NiMo C 24	AWS A5.11:ENiCrMo-13 EN ISO 14172: E Ni 6059 (NiCr23Mo16)				
				GTAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)				
				GMAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)				
	Urea/Nitric Acid Special Grades	S30600	1.4361	SMAW	BÖHLER FOX EAS 2 Si	- EN ISO 3581-A: E Z19 14 Si B 2 2	Nitric Acid			
				GTAW	BÖHLER EASN 2 Si-IG	- EN ISO 14343-A: W Z19 13 Si N L				
		(724Mod.)316L UG	1.4435	SMAW	Thermanit 19/15 H	AWS A5.4:E316LMn-15 EN ISO 3581-A:E 20 16 3 Mn N L B 2 2	Urea			
				GTAW	Thermanit 19/15 H	AWS A5.9:ER316LMn EN ISO 14343-A: W 20 16 3 Mn N L				
				GMAW	Thermanit 19/15 H	AWS A5.9:ER316LMn EN ISO 14343-A: G 20 16 3 Mn N L				
		S31050/725 LN	1.4466	SMAW	Thermanit 25/22 H	- EN ISO 3581-A:EZ 25 22 2 L B 2 2	Urea and Nitric Acid			
				GTAW	Thermanit 25/22 H	AWS A5.9:ER310 (mod.) EN ISO 14343-A: W 25 22 2 N L				
GMAW	Thermanit 25/22 H			AWS A5.9:ER310 (mod.) EN ISO 14343-A: G 25 22 2 N L						
Duplex Stainless Steel	Lean Duplex	S32101/LDX 2101™	1.4162	SMAW	Avesta LDX 2101-3D	- EN ISO 3581-A: E 23 7 N L R				
					Avesta LDX 2101-4D	- EN ISO 3581-A: E 23 7 N L R				
				SAW Wire	Avesta LDX 2101	- EN ISO 14343-A: S 23 7 N L				
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC				
				GTAW	Avesta LDX 2101	- EN ISO 14343-A: W 23 7 N L				
				GMAW	Avesta LDX 2101	- EN ISO 14343-A: G 23 7 N L				
				FCAW	Avesta FCW-2D LDX 2101	- EN ISO 17633-A:T 23 7 N L R M(C) 3				
					Avesta FCW LDX 2101-PW	- EN ISO 17633-A:T 23 7 N L P M(C) 1				
				S32304/2304	1.4362	SMAW		Avesta 2304-3D	- EN ISO 3581-A: E 23 7 N L R	
								Avesta 2304-4D	- EN ISO 3581-A: E 23 7 N L R	
						SAW Wire		Avesta 2304	- EN ISO 14343-A: S 23 7 N L	
						SAW Flux		Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC	
	GTAW	Avesta 2304	- EN ISO 14343-A: W 23 7 N L							
	GMAW	Avesta 2304	- EN ISO 14343-A: G 23 7 N L							

Joining 5/9

	Alloy Group	Base Material Examples ASTM-UNS/ALLOY	EN	Welding Process	Product Name	Classification AWS/EN
Duplex Stainless Steel	Duplex	S32205/2205	1.4462	FCAW	Avesta FCW-2D 2304	- EN ISO 17633-A:T 23 7 N L R M(C) 3
					Avesta FCW 2304-PW	- EN ISO 17633-A:T 23 7 N L R M(C) 1
				SMAW	Avesta 2205-3D	AWS A5.4:E2209-17 EN ISO 3581-A:E 22 9 3 N L R
					Avesta 2205-4D	AWS A5.4:E2209-17 EN ISO 3581-A:E 22 9 3 N L R
					BÖHLER FOX CN 22/9 N-B	AWS A5.4:E2209-15 EN ISO 3581-A:E 22 9 3 N L B 2 2
				SAW Wire	Avesta 2205	AWS A5.9:ER2209 EN ISO 14343-A:S 22 9 3 N L
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC
				GTAW	Avesta 2205	AWS A5.9:ER2209 EN ISO 14343-A:W 22 9 3 N L
				GMAW	Avesta 2205	AWS A5.9:ER2209 EN ISO 14343-A:G 22 9 3 N L
	FCAW	Avesta FCW-2D 2205	AWS A5.22:E2209T0-4/1 EN 17633-A:T 22 9 3 N L R M(C) 3			
		Avesta FCW 2205-PW	AWS A5.22:E2209T1-4/1 EN 17633-A:T 22 9 3 N L P M(C) 1			
	Super-Duplex	S32750/2507 S32760/2507 CuW	1.4410 1.4501	SMAW	Avesta 2507/P100 rutile	AWS A5.4:E2594-17 EN ISO 3581-A:E 25 9 4 N L R
					Avesta 2507/P100-3D	AWS A5.4:E2594-17 EN ISO 3581-A:E 25 9 4 N L R
					Thermanit 25/09 CuT	AWS A5.4:E2595-15 EN ISO 3581-A:E 25 9 4 N L B 2 2
				SAW Wire	Avesta 2507/P100	AWS A5.9:ER2594 EN ISO 14343-A:S 25 9 4 N L
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC
				SAW Wire	Thermanit 25/09 CuT	AWS A5.9:ER2594 EN ISO 14343-A:S 25 9 4 N L
				SAW Flux	Marathon 431	- EN ISO 14174: SA FB 2 DC
				GTAW	Avesta 2507/P100	AWS A5.9:ER2594 EN ISO 14343-A:W 25 9 4 N L
Thermanit 25/09 CuT					AWS A5.9:ER2594 EN ISO 14343-A:W 25 9 4 N L	
GMAW				Avesta 2507/P100	AWS A5.9:ER2594 EN ISO 14343-A:G 25 9 4 N L	
	Thermanit 25/09 CuT	AWS A5.9:ER2594 EN ISO 14343-A:G 25 9 4 N L				
FCAW	Avesta FCW 2507/P100-PW	AWS A5.22:E2594T1-4/1 EN 17633-A:T 25 9 4 N L P M(C) 2				
Wear Resistant Stainless Steel	248SV	1.4418	SMAW	Avesta 248 SV rutile	-	
				Avesta 248 SV	-	
			SAW Wire	Avesta 248SV	- EN ISO 14343-A: S 16 5 1	
			SAW Flux	Avesta Flux 801	- EN ISO 14174: SA CS 2 Cr DC	
			GTAW	Avesta 248 SV	- EN ISO 14343-A: G 16 5 1	
GMAW	Avesta 248 SV	- EN ISO 14343-A: G 16 5 1				

Joining 6/9

	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN						
		ASTM-UNS/ALLOY	EN									
Wear Resistant Stainless Steel		410 NiMo	1.4313	SMAW	BÖHLER FOX CN 13/4	AWS A5.11:E410NiMo-15 EN ISO 3581-A: E 13 4 B 6 2						
			1.4407	SAW Wire	BÖHLER CN 13/4-UP	AWS A5.9:ER410NiMo (mod.) EN ISO 14343-A: S 13 4						
			1.4414	SAW Flux	BÖHLER BB 203	- EN ISO 14174: SA FB 2 DC						
				GTAW	BÖHLER CN 13/4-IG	AWS A5.9:ER410NiMo (mod.) EN ISO 14343-A: W 13 4						
				GMAW	BÖHLER CN 13/4-IG	AWS A5.9:ER410NiMo (mod.) EN ISO 14343-A: G 13 4						
Dissimilar Welds and/or Buffer Layers				SMAW	BÖHLER FOX CN 23/12-A	AWS A5.4:E309L-17 EN ISO 3581-A: E 23 12 L R 3 2	309L grade					
				SAW Wire	Avesta 309L	AWS A5.9 ER309L EN ISO 14343 S 23 12 L						
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC						
					Avesta Flux 801	- EN ISO 14174: SA CS 2 Cr DC						
				GTAW	BÖHLER CN 23/12-IG	AWS A5.9:ER309L EN ISO 14343-A: W 23 12 L						
				GMAW	BÖHLER CN 23/12-IG	AWS A5.9:ER309L EN ISO 14343-A: G 23 12 L						
					BÖHLER CN 23/12-MC	AWS A5.9:EC309L EN ISO 17633-A: T 23 12 L MM1						
				FCAW	BÖHLER CN 23/12-FD	AWS A5.22:E309LT0-4/1 EN ISO 17633-A: T 23 12 L R M (C) 3						
					BÖHLER CN 23/12 PW-FD	AWS A5.22:E309LT1-4/1 EN ISO 17633-A: T 23 12 L P M(C) 1						
									SMAW	Avesta P5-3D	AWS A5.4:E309LMo-17 EN ISO 3581-A: E 23 12 2 L R	309LMo grade
									SAW Wire	Avesta P5	AWS A5.9:ER309LMo (mod.) EN ISO 14343-A: S 23 12 2 L	
									SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC	
									GTAW	Avesta P5	AWS A5.9:ER309LMo (mod.) EN ISO 14343-A: W 23 12 2 L	
									GMAW	Avesta P5	AWS A5.9:ER309LMo (mod.) EN ISO 14343-A: G 23 12 2 L	
FCAW	Avesta FCW-2D P5	AWS A5.22:E309LMoT0-4/1 EN ISO 17633-A: T 23 12 2 L R M (C) 3										
	Avesta FCW P5-PW	AWS A5.22:E309LMo T1-4/1 EN ISO 17633-A: T 23 12 2 L P M(C) 1										
Difficult to be welded Steels				SMAW	BÖHLER FOX A 7 CN	AWS A5.4:E307-15 (mod.) EN ISO 3581-A: E 18 8 Mn B 2 2	307 mod. grade					
					BÖHLER FOX A 7-A	AWS A5.4:E307-16 (mod.) EN ISO 3581-A: E Z18 9 MnMo R 3 2						
				SAW Wire	Thermanit X	AWS A5.9:ER307 (mod.) EN ISO 14343-A: S 18 8 Mn						
				SAW Flux	Marathon 431	- EN ISO 14174: SA FB 2 DC						
				GTAW	BÖHLER A 7 CN-IG	AWS A5.9:ER307 (mod.) EN ISO 14343-A: W 18 8 Mn						
				GMAW	BÖHLER A 7 CN-IG	AWS A5.9:ER307mod EN ISO 14343-A: G 18 8 Mn						
BÖHLER A 7-MC	AWS A5.9:EC307 (mod.) EN ISO 17633-A: T 18 8 Mn MM1											

Joining 7/9

	Alloy Group	Base Material Examples ASTM-UNS/ALLOY EN		Welding Process	Product Name	Classification AWS/EN	
Difficult to be welded Steels				FCAW	BÖHLER A7 FD	AWS A5.22:E307T0-G EN ISO 17633-A: T 18 8 Mn R M(C) 3	307 mod. grade
					BÖHLER A7 PW-FD (LMN)	AWS A5.22:E307T1-G EN ISO 17633-A: T 18 8 Mn P M(C) 2	
				SMAW	Avesta P7 AC/DC	AWS A5.4:E312-17 (mod.) EN ISO 3581-A: E 29 9 R	312 grade
				SAW Wire	Avesta P7	- EN ISO 14343-A: S 29 9	
				SAW Flux	Avesta Flux 805	- EN ISO 14174: SA AF 2 Cr DC	
				GTAW	Avesta P7	AWS A5.9:ER312 EN ISO 14343-A: W 29 9	
GMAW	Avesta P7	AWS A5.9:ER312 EN ISO 14343-A: G 29 9					
Nickel - Base for Wet Corrosion	Ni alloys	N02200/200 N02201/201	2.4066 2.4068	SMAW	UTP 80 Ni	AWS A5.11:ENi-1 EN ISO 14172 : E Ni 2061 (NiTi3)	
				GTAW	UTP A 80 Ni	AWS A5.14:ERNi-1 EN ISO 18274 : S Ni 2061 (NiTi3)	
				GMAW	UTP A 80 Ni	AWS A5.14:ERNi-1 EN ISO 18274 : S Ni 2061 (NiTi3)	
	NiCrFe alloys	N06600/600 N06600/600L	2.4816 2.4817	SMAW	Thermanit Nicro 82	AWS A5.11 : E NiCrFe-3 (mod.) EN ISO 14172 : E Ni 6082 (NiCr20Mn3Nb)	
				SAW Wire	Thermanit Nicro 82	AWS A5.14:ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)	
				SAW Flux	Marathon 444	- EN 760: SA FB 2 AC	
				GTAW	Thermanit Nicro 82	AWS A5.14 : ER NiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)	
				GMAW	Thermanit Nicro 82	AWS A5.14 : ER NiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)	
				FCAW	BÖHLER NIBAS 70/20-FD	AWS A5.14:ENiCr3T0-4 EN ISO 14172: Typ Ni 6082 (NiCr20Mn3Nb)	
	NiFeCrMo-Cu alloys	N08020 / 20 N08825/825 N06985/G-3	2.4660 2.4858 2.4619	SMAW	Thermanit 625	AWS A5.11 : E NiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)	Filler Metal alloy 625 Matching Grade
				SAW Wire	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)	
				SAW Flux	Marathon 444	- EN 760: SA FB 2 AC	
	GTAW	Thermanit 625	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)				
	GMAW	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)				
	FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)				
	NiCrMo (Fe) alloys	N06625 / 625	2.4856	SMAW	Thermanit 625	AWS A5.11 : E NiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)	Also for High Temperature Applications
				SAW Wire	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)	
				SAW Flux	Marathon 444	- EN 760: SA FB 2 AC	
				GTAW	Thermanit 625	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)	

Joining 8/9

	Alloy Group	Base Material Examples		Welding Process	Product Name	Classification AWS/EN		
		ASTM-UNS/ALLOY	EN					
Nickel - Base for Wet Corrosion				GMAW	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)		
				FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)		
		N10276/ C-276	2.4819	SMAW	UTP 776 Kb	AWS A5.11:ENiCrMo-4 EN ISO 14172 : E Ni 6276 (NiCr15Mo15Fe6W4)		
		SAW Wire	UTP UP 776	AWS A5.14:ERNiCrMo-4 EN ISO 18274 : S Ni 6276 (NiCr15Mo-15Fe6W4)				
		SAW Flux	UTP UP FX 776/3	- EN 760 : S A FB 2 55 AC H5				
		GTAW	UTP A 776	AWS A5.14:ERNiCrMo-4 EN ISO 18274 : S Ni 6276 (NiCr15Mo-15Fe6W4)				
		GMAW	UTP A 776	AWS A5.14:ERNiCrMo-4 EN ISO 18274 : S Ni 6276 (NiCr15Mo-15Fe6W4)				
		N06022/22	2.4602	SMAW	UTP 722 Kb	AWS A5.11:ENiCrMo-10 EN ISO 14172 : E Ni 6022 (NiCr21Mo13W3)		
		GTAW	UTP A 722	AWS A5.14:ERNiCrMo-10 EN ISO 18274 : S Ni 6022 (NiCr21Mo13W3)				
		GMAW	UTP A 722	AWS A5.14:ERNiCrMo-10 EN ISO 18274 : S Ni 6022 (NiCr21Mo13W3)				
	N06059/59 N06455/C-4 N06200/C-2000™	2.4605 2.4610 2.4675	SMAW	Thermanit NiMo C 24	AWS A5.11:ENiCrMo-13 EN ISO 14172: E Ni 6059 (NiCr23Mo16)			
	GTAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)					
	GMAW	Thermanit NiMo C 24	AWS A5.14:ERNiCrMo-13 EN ISO 18274: S Ni 6059 (NiCr23Mo16)					
	NiMo alloys	N10665/B-2	2.4617	SMAW	UTP 703 Kb	AWS A5.11:ENiMo-7 EN ISO 14172 : ENi 1066 (NiMo28)		
	GTAW	UTP A 703	AWS A5.14:ERNiMo-7 EN ISO 18274 : S Ni 1066 (NiMo28)					
	GMAW	UTP A 703	AWS A5.14:ERNiMo-7 EN ISO 18274 : S Ni 1066 (NiMo28)					
	N10675/B-3	2.4600	SMAW	UTP 6202 Mo	AWS A5.11:ENiMo-11 EN ISO 14172 : E Ni 1069 (NiMo28Fe4Cr)			
	GTAW	UTP A 6202 Mo	AWS A5.14:ERNiMo-11 EN ISO 18274 : S Ni 1069 (NiMo28Fe4Cr)					
	GMAW	UTP A 6202 Mo	AWS A5.14:ERNiMo-11 EN ISO 18274 : S Ni 1069 (NiMo28Fe4Cr)					
	Heat Resistant Stainless Steel	310S 310	1.4845 1.4841	SMAW	BÖHLER FOX FFB-A	AWS A5.4:E310-16 EN ISO 3581-A: E 25 20 R 3 2		
GTAW				BÖHLER FFB-IG	AWS A5.9:ER310 (mod.) EN ISO 14343-A: W 25 20 Mn			
GMAW				BÖHLER FFB-IG	AWS A5.9:ER310 (mod.) EN ISO 14343-A: G 25 20 Mn			
S30415 S30815 S30900/309S		1.4818 1.4835 1.4828	SMAW	Avesta 253 MA-3D	- EN ISO 3581-A: E 21 10 R			
SAW Wire		Avesta 253 MA	- EN ISO 14343-A:S 21 10 N					
SAW Flux		Avesta Flux 801	- EN ISO 14174: SA CS 2 Cr DC					
GTAW		Avesta 253 MA	- EN ISO 14343-A:W 21 10 N					
GMAW		Avesta 253 MA	- EN ISO 14343-A:G 21 10 N					

Filler Metal alloy 59 Matching Grade

Joining 9/9

	Alloy Group	Base Material Examples ASTM-UNS/ALLOY EN	Welding Process	Product Name	Classification AWS/EN		
Heat Resistant Stainless Steel		N08810/800 H 1.4876 1.4958	SMAW	UTP 2133 Mn	- EN ISO 3581-A: EZ 21 33 B 4 2		
			GTAW	UTP A 2133 Mn	- EN ISO 14343: WZ 21 33 Mn Nb		
			GMAW	UTP A 2133 Mn	- EN ISO 14343: GZ 21 33 Mn Nb		
		N08330/DS S33228/AC66 1.4862 1.4877	SMAW	Thermanit 625	AWS A5.11 : E NiCrMo-3 EN ISO 14172 : E Ni 6625 (NiCr22Mo9Nb)		
			SAW Wire	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)		
			SAW Flux	Marathon 444	- EN 760: SA FB 2 AC		
			GTAW	Thermanit 625	AWS A5.14 : ER NiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)		
			GMAW	Thermanit 625	AWS A5.14:ERNiCrMo-3 EN ISO 18274 : S Ni 6625(NiCr22Mo9Nb)		
			FCAW	BÖHLER NIBAS 625 PW-FD	AWS A5.34:ENiCrMo3T1-4 EN ISO 14172: Typ Ni 6625 (NiCr22Mo9Nb)		
	Nickel - Base for High Temperature		N06600/600 H 2.4816	SMAW	Thermanit Nicro 82	AWS A5.11 : E NiCrFe-3 (mod.) EN ISO 14172 : E Ni 6082 (NiCr20Mn3Nb)	
SAW Wire				Thermanit Nicro 82	AWS A5.14:ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)		
SAW Flux				Marathon 444	- EN 760: SA FB 2 AC		
GTAW				Thermanit Nicro 82	AWS A5.14 : ER NiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)		
GMAW				Thermanit Nicro 82	AWS A5.14 : ER NiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)		
FCAW				BÖHLER NIBAS 70/20-FD	AWS A5.14:ENiCr3T0-4 EN ISO 14172: Typ Ni 6082 (NiCr20Mn3Nb)		
		N06617/617 24.663	SMAW	Thermanit 617	AWS A5.11 : ~ ENiCrCoMo-1 (mod.) EN ISO 14172 : ~ E Ni 6117~ (NiCr22Co-12Mo9)		
			GTAW	Thermanit 617	AWS A5.14 : ER NiCrCoMo-1 EN ISO 18274 : S Ni 6617 (NiCr22Co12Mo9)		
			GMAW	Thermanit 617	AWS A5.14 : ER NiCrCoMo-1 EN ISO 18274 : S Ni 6617 (NiCr22Co12Mo9)		
				N06601/601-601H N06025/602CA 2.4851 2.4633	SMAW	UTP 6225 Al	AWS A 5.11 : E NiCrFe-12 EN ISO 14172 : E Ni 6025 (NiCr25Fe10AlY)
					GTAW	UTP A 6225 Al	AWS A 5.14 : ER NiCrFe-12 EN ISO 18274 : S Ni 6025 (NiCr25Fe10AlY)
					GMAW	UTP A 6225 Al	AWS A 5.14 : ER NiCrFe-12 EN ISO 18274 : S Ni 6025 (NiCr25Fe10AlY)
Copper-Nickel /Nickel-Copper alloy	NiCu alloys	N04400/400 K-500 2.4360	SMAW	UTP 80 M	AWS A5.11 : E NiCu-7 EN ISO 14172 : E Ni 4060 (NiCu30Mn3Ti)		
			GTAW	UTP A 80 M	AWS A5.14 : ER NiCu-7 EN ISO 18274 : S Ni 4060 (NiCu30Mn3Ti)		
			GMAW	UTP A 80M	AWS A5.14 : ER NiCu-7 EN ISO 18274 : S Ni 4060 (NiCu30Mn3Ti)		
	CuNi alloys	C71500/CuNi 70-30 2.0872 2.0878 C70600/CuNi 90-10 2.0882	SMAW	UTP 387	AWS A5.6:ECuNi DIN 1733 : EL-CuNi30Mn		
			GTAW	UTP A 387	AWS A5.7:ERCuNi EN ISO 24373 : S Cu 7158 (CuNi30Mn1FeTi)		
			GMAW	UTP A 387	AWS A5.7:ERCuNi EN ISO 24373 : S Cu 7158 (CuNi30Mn1FeTi)		
Titanium alloys		R50400H ASTM gr.1-4	GTAW	BÖHLER ER Ti 2-IG	AWS A5.16:ERTi-2 -		

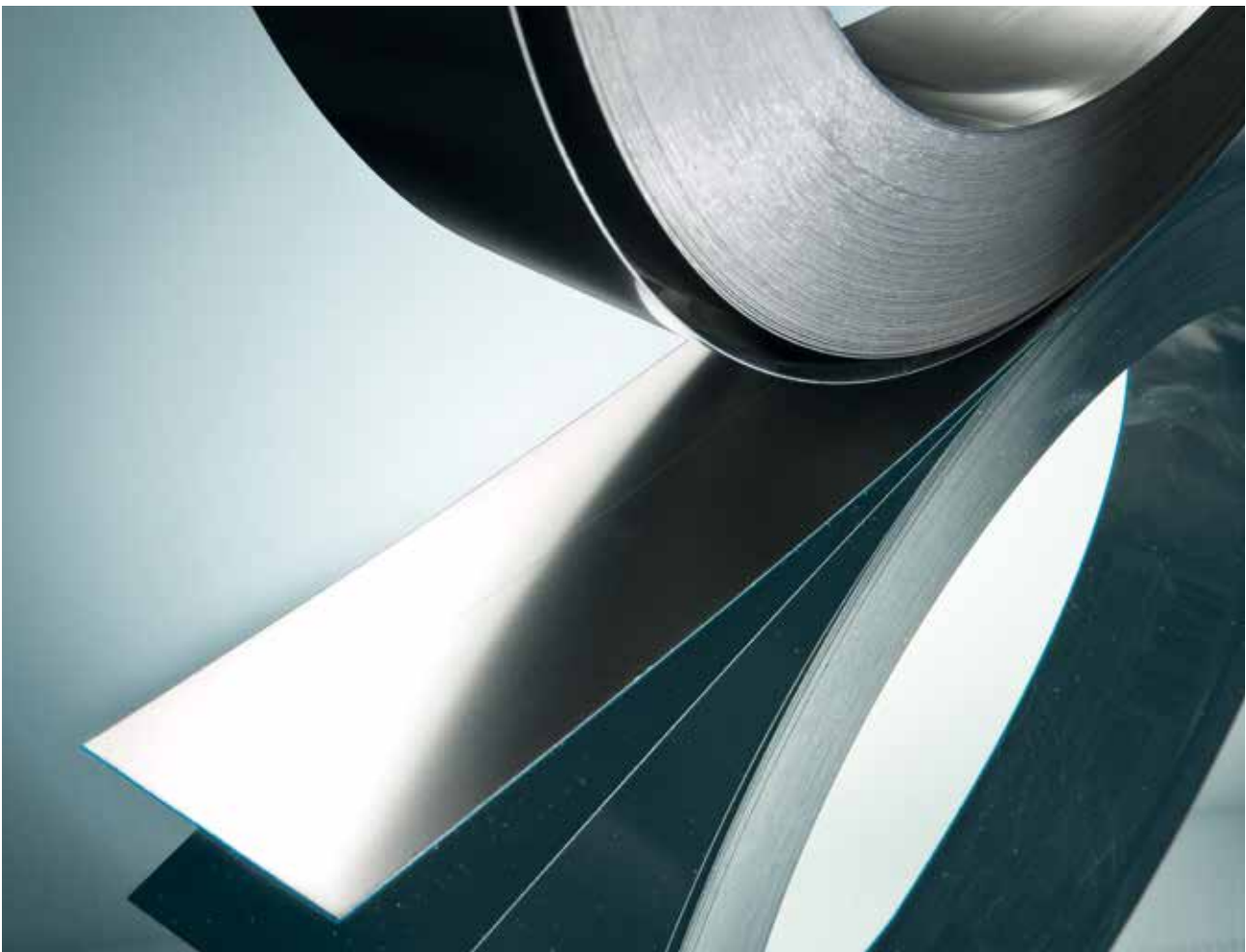


Strip Cladding 1/2

	Deposited Alloy	Welding Process	Layer	Strip	Flux
Stainless Steel	316L	SAW	1st Layer	SOUDOTAPE 309 L	RECORD INT 109
			2nd Layer	SOUDOTAPE 316 L	RECORD INT 109
		ESW	1st Layer	SOUDOTAPE 309 L	RECORD EST 122
			2nd Layer	SOUDOTAPE 316 L	RECORD EST 122
		ESW Single layer	Single Layer	SOUDOTAPE 21.13.3 L	RECORD EST 122
		ESW Single layer	Single Layer	SOUDOTAPE 316 L	RECORD EST 316-1
	ESW High Speed	1st Layer	SOUDOTAPE 309L	RECORD EST 136	
		2nd Layer	SOUDOTAPE 316L	RECORD EST 136	
	317L	SAW	1st Layer	SOUDOTAPE 21.13.3 L	RECORD INT 101 Mo
			2nd Layer	SOUDOTAPE 316 L	RECORD INT 101 Mo
		ESW	1st Layer	SOUDOTAPE 316 L	RECORD EST 317-2
			2nd Layer	SOUDOTAPE 316 L	RECORD EST 317-2
		ESW Single layer	Single Layer	SOUDOTAPE 21.13.3L	RECORD EST 317-1
	318	ESW	1st Layer	SOUDOTAPE 21.13.3 L	RECORD EST 130
			2nd Layer	SOUDOTAPE 21.11 LNb	RECORD EST 130
	347	SAW	1st Layer	SOUDOTAPE 309 L	RECORD INT 109
			2nd Layer	SOUDOTAPE 347	RECORD INT 109
		ESW	1st Layer	SOUDOTAPE 309 L	RECORD EST 122
			2nd Layer	SOUDOTAPE 347	RECORD EST 122
		ESW Single layer	Single Layer	SOUDOTAPE 21.11 LNb	RECORD EST 122
		ESW High Speed	Single Layer	SOUDOTAPE 24.12 LNb	RECORD EST 136
	ESW High Speed	1st Layer	SOUDOTAPE 309L	RECORD EST 136	
			2nd Layer	SOUDOTAPE 347	RECORD EST 136
	904L	SAW	1st Layer	SOUDOTAPE 20.25.5 LCu	RECORD INT 101
			2nd Layer	SOUDOTAPE 20.25.5 LCu	RECORD INT 101
		ESW	1st Layer	SOUDOTAPE 20.25.5 LCu	RECORD EST 122
			2nd Layer	SOUDOTAPE 20.25.5 LCu	RECORD EST 122
	ESW Single layer	Single Layer	SOUDOTAPE 20.25.5 LCu	RECORD EST 385-1	
S31254	ESW	1st Layer	SOUDOTAPE 254SMo	RECORD EST 122	
		2nd Layer	SOUDOTAPE 254SMo	RECORD EST 122	
Duplex 2205	SAW	1st Layer	SOUDOTAPE 22.6.3 L	RECORD INT 110	
		2nd Layer	SOUDOTAPE 22.6.3 L	RECORD INT 110	
		3rd Layer	SOUDOTAPE 22.6.3 L	RECORD INT 110	
	ESW	1st Layer	SOUDOTAPE 22.6.3 L	RECORD EST 122	
2nd Layer		SOUDOTAPE 22.6.3 L	RECORD EST 122		
	ESW Single layer	Single Layer	SOUDOTAPE 22.6.3 L	RECORD EST 4462-1	
Super Duplex 2507	ESW	1st Layer	SOUDOTAPE 22.6.3 L	RECORD EST 2584	
		2nd Layer	SOUDOTAPE 22.6.3 L	RECORD EST 2584	
310 Mod. S31050/725 LN	SAW	1st Layer	SOUDOTAPE 310 MM	RECORD 13 BLFT	
		2nd Layer	SOUDOTAPE 310 MM	RECORD 13 BLFT	
		3rd Layer	SOUDOTAPE 310 MM	RECORD 13 BLFT	
	ESW	1st Layer	SOUDOTAPE 310 MM	RECORD EST 122	
		2nd Layer	SOUDOTAPE 310 MM	RECORD EST 122	
	ESW High Speed	1st Layer	SOUDOTAPE 310 MM	RECORD EST 310 MM	
		2nd Layer	SOUDOTAPE 310 MM	RECORD EST 310 MM	
Nickel-Base	Alloy 200	SAW	1st Layer	SOUDOTAPE NiTi	RECORD NiT
			2nd Layer	SOUDOTAPE NiTi	RECORD NiT
			3rd Layer	SOUDOTAPE NiTi	RECORD NiT
		ESW	1st Layer	SOUDOTAPE NiTi	RECORD EST 200
			2nd Layer	SOUDOTAPE NiTi	RECORD EST 200
			3rd Layer	SOUDOTAPE NiTi	RECORD EST 200
	Alloy 600-600L	SAW	1st Layer	SOUDOTAPE NiCr3	RECORD NiCrT
			2nd Layer	SOUDOTAPE NiCr3	RECORD NiCrT
			3rd Layer	SOUDOTAPE NiCr3	RECORD NiCrT
		ESW	1st Layer	SOUDOTAPE NiCr3	RECORD EST 201
			2nd Layer	SOUDOTAPE NiCr3	RECORD EST 201
		ESW High Speed	1st Layer	SOUDOTAPE NiCr3	RECORD EST 236
		2nd Layer	SOUDOTAPE NiCr3	RECORD EST 236	
Alloy C-276	ESW	1st Layer	SOUDOTAPE NiCrMo59	RECORD EST 259	
		2nd Layer	SOUDOTAPE NiCrMo4	RECORD EST 259	

Strip Cladding 2/2

	Deposited Alloy	Welding Process	Layer	Strip	Flux
Nickel-Base	Alloy 59	ESW	1st Layer	SOUDOTAPE NiCrMo59	RECORD EST 259
			2nd Layer	SOUDOTAPE NiCrMo59	RECORD EST 259
	Alloy 825	ESW	1st Layer	SOUDOTAPE 825	RECORD EST 201
			2nd Layer	SOUDOTAPE 825	RECORD EST 201
		ESW Single layer	Single Layer	SOUDOTAPE 825	RECORD EST 138
	Alloy 625	SAW	1st Layer	SOUDOTAPE 625	RECORD NFT 201
			2nd Layer	SOUDOTAPE 625	RECORD NFT 201
		ESW	1st Layer	SOUDOTAPE 625	RECORD EST 201
			2nd Layer	SOUDOTAPE 625	RECORD EST 201
		ESW Single layer	Single Layer	SOUDOTAPE 625	RECORD EST 625-1
		ESW High Speed	1st Layer	SOUDOTAPE 625	RECORD EST 236
			2nd Layer	SOUDOTAPE 625	RECORD EST 236
	Alloy 400	SAW	1st Layer	SOUDOTAPE NiCu7	RECORD NiCuT
			2nd Layer	SOUDOTAPE NiCu7	RECORD NiCuT
	3rd Layer		SOUDOTAPE NiCu7	RECORD NiCuT	
	ESW	1st Layer	SOUDOTAPE NiCu7	RECORD EST 400	
2nd Layer		SOUDOTAPE NiCu7	RECORD EST 400		
Cu-Ni	SAW	1st Layer	SOUDOTAPE NiCu7	RECORD NiCuT	
		2nd Layer	SOUDOTAPE CuNi30	RECORD CuNi30T	
		3rd Layer	SOUDOTAPE CuNi30	RECORD CuNi30T	
Alloy C-4	ESW	1st Layer	SOUDOTAPE NiCrMo7	RECORD EST 259	
		2nd Layer	SOUDOTAPE NiCrMo7	RECORD EST 259	
		3rd Layer	SOUDOTAPE NiCrMo7	RECORD EST 259	
Alloy 22	ESW	1st Layer	SOUDOTAPE NiCrMo22	RECORD EST 259	
		2nd Layer	SOUDOTAPE NiCrMo22	RECORD EST 259	



Hardfacing

Product Name	Welding Process	Classification	Description
UTP DUR 400	SMAW	EN 14700 : E Z Fe1	Basic coated, high-efficiency welding stick electrode for crack and wear resistant surfacings. Recovery 200 %.
UTP DUR 600	SMAW	EN 14700 : E Fe8	Basic coated hardfacing stick electrode resisting impact and abrasion
UTP LEDURIT 61	SMAW	AWS A5.13 : ~ E FeCr-A 1 EN 14700 : EZ Fe14	Rutile-basic coated hardfacing stick electrode for high abrasion and medium impact Recovery 160 %
UTP LEDURIT 65	SMAW	EN 14700 : E Fe16	High-efficiency stick electrode without slag resisting extreme abrasion at elevated temperatures
UTP 673	SMAW	EN 14700 : E Fe8	Rutile coated stick electrode for wear resistant surfacings on cold and hot working tools
SK D8-G	FCAW - GAS SHIELDED		TUNGSTEN - CHROMIUM - VANADIUM alloy designed for the repairs and the hard surfacing of tools working at low and high temperature. The resistance to thermal shocks, mechanical stresses and adhesive wear is good up to temperatures not exceeding 500-550°C.
SK STELKAY 21-G	FCAW - GAS SHIELDED	AWS A5.21 : ERC CoCr-E DIN 8555 : MF 20-GF-300-CTZ	Cobalt base alloy providing excellent resistance to metal-to-metal wear, thermal shocks, oxidation in corrosive environments at high temperature. Can be used with shielding gas or with flux.
SK 402-O	FCAW - OPEN ARC	DIN 8555 : MF 8-GF-150/400-KPZ	Austenitic alloy type 18Cr8Ni7Mn designed for joining dissimilar metals and for buffer layer deposits prior to hardfacing.
SK 402-G	FCAW - GAS SHIELDED	DIN 8555 : MF 8-GF-150-KP	Austenitic alloy type 18Cr8Ni7Mn designed for joining dissimilar metals and for buffer layer deposits prior to hard surfacing.
SK 402-S	FCAW - SAW	DIN 8555 : UP 8-GF-150/400-KPZ	Austenitic alloy type 18Cr8Ni7Mn designed for joining dissimilar metals and for buffer layer deposits prior to hardfacing
SK 307-G	FCAW - GAS SHIELDED	DIN 8555 : MF 8-GF-150-KP	Rutile flux-cored stainless wire for gas shielded arc welding 18% Cr - 8% Ni - 7% Mn deposit. Good weldability with either CO ₂ or mixed gas. Weld metal has excellent crack resistance and works well in restrained conditions.
SK 519-G	FCAW - GAS SHIELDED	AWS A5.9:EC 385 EN 12073:T 20 25 5 Cu L M M 1	Stainless steel metal cored-wire for all positional gas shielded welding. Excellent edge blends, arc stability, penetration, weld bead aspect and minimum spatter. Improved welding speed and quality regarding solid wires of the same composition.

Finishing

Product Name	Application
AVESTA PICKLING GEL 122	This gel is universal and specifically intended for standard brush pickling of weld seams and smaller surfaces of all stainless steel grades.
AVESTA BLUEONE PICKLING PASTE 130	Avesta BlueOne™ Pickling Paste 130 is universal, suitable for brush pickling of welds and smaller surfaces of all stainless steel grades.
AVESTA REDONE PICKLING PASTE 140	Avesta RedOne™ Pickling Paste 140 is intended for powerful brush pickling of welds and smaller surfaces of high-alloy steel grades in tough applications.
AVESTA PICKLING SPRAY 204	Avesta Pickling Spray 204 is intended for tougher applications such as heavy hot rolled plates, high-alloyed steels such as 904L, duplex and super-austenitic, thicker weld oxides and pickling at lower temperatures.
AVESTA REDONE PICKLING SPRAY 240	Avesta RedOne™ Pickling Spray 240 is universal and suitable for spray pickling larger surfaces of all stainless steel grades.
AVESTA PICKLING BATH 302	The bath fluid is recommended for immersion pickling of small objects and for pickling surfaces that are time-consuming to brush or spray pickle. It can also be used for circulation pickling of pipe systems.
AVESTA CLEANER 401	Avesta Cleaner 401 is intended for a wide range of industrial cleaning applications, it offers a good general cleaning result on stainless steel surfaces.
AVESTA FINISHONE PASSIVATOR 630	Avesta FinishOne™ Passivator 630 is intended for a wide range of industrial passivating applications. It offers a good general passivating result on stainless steel surfaces.



voestalpine Böhler Welding

Böhler Welding know-how joins steel

Customers in over 120 countries join the expertise of voestalpine Böhler Welding (formerly the Böhler Welding Group). Focused on filler metals, voestalpine Böhler Welding offers extensive technical consultation and individual solutions for industrial welding and soldering applications. Customer proximity is guaranteed by 40 subsidiaries in 28 countries, with the support of 2,200 employees, and through more than 1,000 distribution partners worldwide.



Böhler Welding – More than 2,000 products for joint welding in all conventional arc welding processes are united in a product portfolio that is unique throughout the world. Creating lasting connections is the brand's philosophy in welding and between people.



UTP Maintenance – Decades of industry experience and application know-how in the areas of repair as well as wear and surface protection, combined with innovative and custom-tailored products, guarantee customers an increase in the productivity and protection of their components.



Fontargen Brazing – Through deep insight into processing methods and ways of application, Fontargen Brazing provides the best brazing and soldering solutions based on proven products with German technology. The expertise of this brand's application engineers has been formulated over many years of experience from countless application cases.

forwarded by:

Global Industry Segment Management
Chemical Industry

T. +39 02 39017 236
F. +39 02 39017 246
E. welding.chemical@voestalpine.com