

# Tabela doboru materiałów dodatkowych OERLIKON dla stali niestopowych i niskostopowych

Oznaczenie stali wg. EN					
S185-S275 S275J(0-R) S(1-2) P235-P275 P235-P275GH P275T(1-2) L210-L290 GP240R	S185-S420 S355J(R-2) G(1-3)S P235-P275T(1-2) P235-P355GH P355N L210-L360NB GP240R-280	S275-S460 S355J(R-2) G(1-3)S P310GH P460NH S460N(L-H) L360(N-M)H GE300 E335	12Ni14 14Ni16 13MnNi6-3 G12Ni14 S255N(H-L-L1) S460N(H-L-L1) 20MnMoNi5-5		S235J(0-2)W S335J(0-2)W S335K2W
Oznaczenie stali wg. AISI/ASTM					
A131 Gr A/B/D A36 A53 A106 Gr A/B/C A135 Gr A/B A366 A285 Gr A/B/C A500 Gr A/B/C A283 Gr A/B/C/D	A131 Gr AH32- EH40 A253 A283 Gr A/B/C/D A214 A242 Gr 1-5 A516 Gr 55 A299 Gr A/B A285 Gr A/B/C A515 Gr 60-70 A570 Gr 30-45	A516 Gr 65 A572 Gr 55-65 A633 Gr E A612 A618 Gr 1 A537 Gr 1	A633 Gr E A572 Gr 65 A203 Gr D A333a A334 Gr 3 A350 Gr LF3 A537 Gr 2 A302 Gr A-D A225 Gr. C		Cor-Ten Patinax-F Patinax-37
API5L:X42-46	API5L:X42-56	API5L:X42-65			
<b>Elektrody MMA</b>	OVERCORD / OVERCORDE	SUPERCITO	TENACITO 38R	TENACITO 70B	TENCORD Kb
<b>Pręty TIG</b>	CARBOROD	CARBOROD	CARBOROD Ni1/Ni2	CARBOROD NiMo1	CARBOROD NiCu
<b>Druty lite GMA</b>	CARBOFIL 1	CARBOFIL 1	CARBOFIL Ni1/Ni2	CARBOFIL NiMo1	CARBOFIL NiCu
<b>Druty rdzeniowe FCW</b>	FLUXOFIL M8	FLUXOFIL M8	CITOFILUX R82	CITOFILUX R550	FLUXOFIL 18HD
<b>Kombinacje SAW</b>	OP119 & OE-S1	OP181 & OE-S2	OP121TT & OE-SD3 / OE-SD31Ni1/4Mo	OP121TT & OE-SD3 1Ni1/4Mo	OP192 & OE-S2NiCu

# Tabela doboru materiałów dodatkowych OERLIKON dla stali pracujących w podwyższonych temperaturach

Oznaczenie stali wg. EN						
P295GH P355 GH 16Mo3 17Mo3 14Mo6 P265 GH	13CrMo4-5 13CrMoSi5-5 G17CrMo5-5 16CrMo4-4 22CrMo4-4 22CrMo5-4 25CrMo4 15CrMo5	10CrMo9-10 12CrMo9-10 10CrSiMoV7 17CrMoV10	12CrMoV9-10	12CrMo19-5 X12CrMo5	X12CrMo9-1 X12CrMoVNb9-1 GX12CrMoVNb9-1	
Oznaczenie stali wg. AISI/ASTM						
A41 GrB-F A515 A662 Gr B A250 Gr T1 A217 Gr WC1 A161 Gr T1 A335 Gr P1 A182 Gr F1 A204 Gr A-C A369 Gr FP1	A387 Gr 11/12 A213 Gr T12/13 A335 Gr P12/11 A336 Gr F12/11 A182 Gr F11/12 A356 Gr 6 A193 Gr B7	A213 Gr T22 A335 Gr P22 A182 Gr F22 A199 Gr T22 A200 Gr T22 A336 Gr F22 A387 Gr 22 A217 Gr WC9	SA336 F22V SA541 Gr 22V	A182 Gr F5 A335 Gr T5 A200 Gr T5 A213 Gr T5 A213 Gr T92 A335 Gr P92 A335 Gr P5 A336 Gr F5 A357 A369 Gr FP5 A473 TP501/2	A199 Gr T91 A200 Gr T91 A213 Gr T91 A335 Gr P91 A336 Gr F91 SA182 F91 SA213 Gr T91 SA369 Gr FP91 SA387 Gr91	
Temperatura pracy						
	500 °C	550 °C	600 °C	600 °C	650 °C	650 °C
<b>Elektrody MMA</b>	MOLYCORD Kb	CROMOCORD Kb	CROMOCORD 2STC / CROMO E225	CROMO E225V	CROMOCORD 5	CROMOCORD 9M / CROMOCORD 91
<b>Pręty TIG</b>	CARBOROD Mo	CARBOROD CrMo1	CARBOROD CrMo2		CARBOROD CrMo5	
<b>Druty lite GMA</b>	CARBOFIL Mo	CARBOFIL CrMo1	CARBOFIL CrMo2		CARBOFIL CrMo5	CARBOFIL KV7M (*)
<b>Druty rdzeniowe FCW</b>	FLUXOFIL 35	FLUXOFIL 36	FLUXOFIL 37			
<b>Kombinacje SAW</b>	OP121TT & OE-S2Mo	OP121TTW & OE-S2CrMo1	OP CROMO F537 & OE-S1CrMo2	OP CROMO F537 & OE-CROMO S225V	OP CROMO F537 & OE-S1CrMo5	OP76 & OE-KV7M (*)

  

Oznaczenie stali wg. EN						
X10CrMoWVNb9-2	X6CrNi18-11 X6CrNi 18-10 X10CrNi18-8 X4CrNi18-10 X5CrNi19-10 X3CrNiN18-11	X10NiCrAlTi 32-20 X15NiCrAlTi31-20 NiCr15Fe	NiCr23Fe NiCr22Mo9Nb NiCr21Mo X2NiCrMoCu25-20 X2CrNiMoCuN20-18-6 X1NiCrMoCuN 25-20-6	X8CrNi25-21 X15CrNiSi20-12 X15CrNiSi25-21 X12CrNi25-21 GX15 CrNi25-20		
Oznaczenie stali wg. AISI/ASTM						
A387 Gr 92 A812 F92 A369 FP92F	A352 Gr CF8 A296 Gr CF8	B163 Gr N06 B167 Gr 600	B163 Gr N08 B407 Gr 810			
	AISI: TP304H; TP304					AISI: TP310; TP314
Temperatura pracy						
	650 °C	700 °C	800 °C	1000 °C	1200 °C	
<b>Elektrody MMA</b>	CROMOCORD 92	SUPRANOX 308H (*)	SUPRANEL SR	SUPRANEL 625	SUPRANOX 310	
<b>Pręty TIG</b>		INERTROD 308H (*)	NIROD 600	NIROD 625	INERTROD 310	
<b>Druty lite GMA</b>		INERTFIL 308H (*)	NIFIL 600	NIFIL 625	INERTFIL 310	
<b>Druty rdzeniowe FCW</b>		FLUXINOX 308H (*)	FLUXINOX 625	FLUXINOX 625	FLUXINOX 310 PF	
<b>Kombinacje SAW</b>			OP76 & NIFIL 600	OP76 & NIFIL 625		

# Tabela doboru materiałów dodatkowych OERLIKON dla stali wysokostopowych i żaroodpornych



Oznaczenie stali wg. EN					
X6Cr13	X2CrNiN 18-10	X4CrNiMo17-12-2	X6CrNiTi18-10	GX5CrNiMoNb19-10	
X7Cr14	X2CrNiN 18-7	X2CrNiMoN17-11-2	X6CrNiNb18-10	X5CrNiMoTi17-12-2	
X6CrAl13	X10CrNi18-8	X2CrNiMo18-12-3		X6CrNiMoNb17-12-2	
X12Cr13	X4CrNi18-10	X2CrNiMo17-13-3		X10CrNiMoNb18-12	
GX8CrNi13	X5CrNi18-10	X2CrNiMo18-14-3		X10CrNiMoTi18-12	
X6Cr17G-X5Cr-NiMo13-4		X4CrNiMo17-13-3			
G-X4CrNi- Mo13-4					
X4CrNi13-4					
X3CrNiMo13-4					
Oznaczenie stali wg. AISI/ASTM					
	304, 304L 302	316L	347 321	316Ti	
Nr. Werkstoff					
1.4000	1.4311	1.4401	1.4541	1.4581	
1.4001	1.4318	1.4406	1.4550	1.4571	
1.4001	1.4310	1.4428		1.4580	
1.4006	1.4301	1.4429		1.4583	
1.4008	1.4308	1.4435		1.4573	
1.4016		1.4436			
1.4407					
1.4414					
1.4313					
1.4413					
<b>Elektrody MMA</b>	BASINOX 410NiMoS(*)	SUPRANOX 308L	SUPRANOX 316L	SUPRANOX 347L	SUPRANOX 318
<b>Pręty TIG</b>	INERTROD 410NiMo(*)	INERTROD 308LSi	INERTROD 316LSi	INERTROD 347Si	INERTROD 318Si
<b>Druty lite GMA</b>	INERTFIL 410NiMo(*)	INERTFIL 308LSi	INERTFIL 316LSi	INERTFIL 347Si	INERTFIL 318Si
<b>Druty rdzeniowe FCW</b>		FLUXINOX 308L PF	FLUXINOX 316L PF	FLUXINOX 347L PF	FLUXINOX 318 PF
<b>Kombinacje SAW</b>		OP 33 & OE-308L	OP 33 & OE-316L	OP 33 & OE-347	OP 33 & OE-318

  

Oznaczenie stali wg. EN					
X2CrNiMoN22-5-3	GX25CrNiSi18-9	X2CrNiMoN25-7-4	X1NiCrMoCu25-20-5	X8CrNi25-21	
X2CrNiN23-4	GX40CrNiSi22-9	X4CrNiMoN27-5-2	X2CrNiMoN17-13-5	X15CrNiSi20-12	
	X15CrNiSi20-12	GX6CrNiMo24-8-2	X1CrNiMoCuN25-25-5	X15CrNiSi25-21	
	GX25CrNiSi20-14	GX40CrNiMo27-5	X7NiCrMoCuNb25-20	X12CrNi25-21	
	X7CrNi23-14	GX3CrNiMoN26-6-3	X2NiCrMoCuN20-18	GX15 CrNi25-20	
		GX3CrNiMoN26-7-4	X2NiCrMoCuN25-20	X8CrNiAlTi20-20	
		GX8CrNi26-7	X4NiCrMoCuNb20-18-2		
		GX3CrNiMoCuN26-6-3	X5NiCrMoCuTi20-18		
		X6CrMo17-1	X7CrNiMoCuNb18-18		
			X5NiCrMoCuNb22-18		
Oznaczenie stali wg. AISI/ASTM					
	TP309	A182 F53 Zeron 100	904L	310	
Nr. Werkstoff					
1.4462	1.4825	1.4410	1.4539	1.4845	
1.4362	1.4826	1.4460	1.4439	1.4828	
	1.4828	1.4463	1.4537	1.4841	
	1.4832	1.4464	1.4500	1.4845	
	1.4833	1.4468	1.4531	1.4840	
		1.4469	1.4536	1.4847	
		1.4347	1.4505		
		1.4515	1.4506		
		1.4513	1.4585		
			1.4586		
<b>Elektrody MMA</b>	SUPRANOX E 22 9 3 N	BASINOX 22 12 H (*)	BASINOX EB 25 10 4N (*)	SUPRANOX 904L (*)	SUPRANOX 310
<b>Pręty TIG</b>	INERTROD 22 9 3	INERTROD 22 12 (*)	INERTROD 25 10 4	INERTROD 904L (*)	INERTROD 310
<b>Druty lite GMA</b>	INERTFIL 22 9 3	INERTFIL 22 12 (*)	INERTFIL 25 10 4	INERTFIL 904L (*)	INERTFIL 310
<b>Druty rdzeniowe FCW</b>	FLUXINOX 22 9 3L PF	FLUXINOX 309H PF (*)			FLUXINOX 310 PF
<b>Kombinacje SAW</b>	OP 76/OP F500 & OE-S 22 09	OP 76/OE-22 12 (*)	OP 76 & OE-S 25 10		