STICK ELECTRODES

SELECTION DIAGRAM

STEEL

- Rutile* (6013)
  - MetalWork (Ironworks, Maintenance, Sheet Metal Workshop...)
  - Omnia®46
    - Basic 7018
      - Basic7018
        - Conarc® 49
      - Limarosta®304L
      - Linox308L
      - Arosta®304L
    - Pantafix®
    - Supra®

- Basic** (7018)
  - Boiler Making (Structural steel, Piping, Transportation...)
  - Limarosta®309S
  - Arosta®309S
  - Linox 309L

- Limarosta®312
  - Steels difficult to weld

STAINLESS STEEL

- 304/308
  - Linox308L
  - Arosta®304L
  - Limarosta®304L

- 316
  - Linox316L
  - Arosta®316L
  - Limarosta®316L

HARDFACING

- «Impact»
  - Metal to metal
    - Wearshield®MM
    - RepTec® CAST 1

- «Abrasion»
  - Metal to earth
    - Wearshield®ME
    - RepTec® CAST 31
    - Welding of cast iron

- Basic 7018

- 304/308

- 316

* No mechanical and impact properties required
** Special mechanical and impact properties required (KCV)
**STICK ELECTRODES**

**SELECTION TABLE**

### STEEL

#### Rutile Electrodes

<table>
<thead>
<tr>
<th>Standards</th>
<th>Painted or rusty materials</th>
<th>Positional welding</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>OMNIA® 46</td>
<td></td>
<td></td>
<td></td>
<td>Ø1.6 Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>250 - 350</td>
<td>Linc Pack / Cardboard</td>
</tr>
<tr>
<td>PANTAFIX®</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard</td>
</tr>
<tr>
<td>SUPRA®</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard</td>
</tr>
</tbody>
</table>

#### Basic Electrodes

<table>
<thead>
<tr>
<th>Standards</th>
<th>Painted or rusty materials</th>
<th>Positional welding</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
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<tbody>
<tr>
<td>BASO® G</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard / Protech™</td>
</tr>
<tr>
<td>CONARC® 49</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard / Protech™</td>
</tr>
</tbody>
</table>

#### STAINLESS STEEL

<table>
<thead>
<tr>
<th>Standards</th>
<th>Painted or rusty materials</th>
<th>Positional welding</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>LINOX 308L</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>300 - 350</td>
<td>Cardboard / Protech™</td>
</tr>
<tr>
<td>AROSTA® 304L</td>
<td></td>
<td></td>
<td></td>
<td>Ø1.5 Ø2.0 Ø2.5 Ø3.0 Ø4.0 Ø5.0</td>
<td>250 - 300</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LIMAROSTA® 304L</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 350</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LINOX 316L</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard / Protech™</td>
</tr>
<tr>
<td>AROSTA® 316L</td>
<td></td>
<td></td>
<td></td>
<td>Ø1.5 Ø2.0 Ø2.5 Ø3.0 Ø4.0 Ø5.0</td>
<td>250 - 350</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LIMAROSTA® 316L</td>
<td></td>
<td></td>
<td></td>
<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 450</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LINOX 309L</td>
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<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350 - 400</td>
<td>Cardboard / Protech™</td>
</tr>
<tr>
<td>AROSTA® 309S</td>
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<td></td>
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<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>350</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LIMAROSTA® 309S</td>
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<td></td>
<td></td>
<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>300 - 350</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
</tr>
<tr>
<td>LIMAROSTA® 312</td>
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<td>Ø2.0 Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>300 - 350</td>
<td>Cardboard / PE foil Linc Can / SRP</td>
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### HARDFACING

#### WEARSHEILD®MM

<table>
<thead>
<tr>
<th>Standards</th>
<th>Types</th>
<th>Examples</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>E2-UM-55*</td>
<td>Metal on Metal</td>
<td>Crane and mine car wheels, Sprockets and gear teeth, Skip guides, Dredger buckets Ingots, Ingots, Ingots, Rolling mill guides, Screw flights, Coal mining chutes</td>
<td>Ø1.2 Ø1.4 Ø1.6 Ø4.0 Ø6.0 Ø8.0 Ø10.0</td>
<td>350 - 450</td>
<td>Linc Pack / PE Tube</td>
<td></td>
</tr>
</tbody>
</table>

#### WEARSHEILD®ME

<table>
<thead>
<tr>
<th>Standards</th>
<th>Types</th>
<th>Examples</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>E10-UM-60</td>
<td>Metal on Earth</td>
<td>Coal mining chutes, Rolling mill guides, Screw flights, Coal mining chutes</td>
<td>Ø1.2 Ø4.0 Ø5.0 Ø6.0 Ø8.0 Ø10.0</td>
<td>450</td>
<td>PE Tube</td>
<td></td>
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</tbody>
</table>

#### REPTEC CAST 1

<table>
<thead>
<tr>
<th>Standards</th>
<th>Types</th>
<th>Examples</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td>ENi-Ci</td>
<td>Cast iron</td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>300 - 350</td>
<td>Linc Pack / PE Tube</td>
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</tbody>
</table>

#### REPTEC CAST 31

<table>
<thead>
<tr>
<th>Standards</th>
<th>Types</th>
<th>Examples</th>
<th>Easy to weld</th>
<th>Diameters (mm)</th>
<th>Lengths (mm)</th>
<th>Packaging</th>
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</thead>
<tbody>
<tr>
<td>ENiFe-Ci</td>
<td>Cast iron</td>
<td></td>
<td>Ø2.5 Ø3.2 Ø4.0 Ø5.0</td>
<td>300 - 350</td>
<td>Linc Pack / PE Tube</td>
<td></td>
</tr>
</tbody>
</table>
MIG & FLUX-CORED WIRES

**SOLID WIRES**

- **STEEL**
  - 4Si (SG9)
  - 3Si (SG2)
  - Ultramag® SG3
    - Standard quality
  - Supramig Ultra®
    - Superior quality
  - Supramig Ultra®HD
    - High deposition rate

- **LOW ALLOY STEEL**
  - ER100S-G
  - ER110S-G
  - ER120S-G
  - LNM 2B
  - LNM MoNi
  - LNM MoNiVa
  - LNM MoNiCr
  - LNM 304LSi
  - LNM 316LSi

- **STAINLESS STEEL**
  - 304/308
  - 316
  - LNM 304LSi
  - LNM 316LSi

- **ALUMINIUM**
  - AlSi 5
    - (4043)
  - AlMg 5
    - (5356)
  - Superglaze® MIG 4043
  - Superglaze® MIG 5356

- **HARDFACING**
  - Hardness 600 HRC
  - LNM 420FM

- **OUTERSHIELD**
  - Outershield® MC710-H
    - Gas-shielded metal cored wire
  - Outershield® 71E-H
    - Gas-shielded all position rutile cored wire
  - Outershield 71M-H
    - Gas-shielded all position cored wire
  - Innershield NR® 211MP
    - Self-shielded all position cored wire

**FLUX-CORED WIRES**

- **Cor-A-Rosta® 304L**
  - Positional welding

- **Cor-A-Rosta® 316L**

- **Cor-A-Rosta® P304L/P316L**
  - Positional welding

**SELECTION DIAGRAM**

- **STANDARD CERTIFICATES**: AVAILABLE
- **ESPECIAL CERTIFICATES**: ON REQUEST
- **APPROVALS (TÜV, DNV, DB)**: CONSULT US

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# Selection Table

**MIG & FLUX-CORED WIRES**

## Large Diameter Flux Cored Wires

<table>
<thead>
<tr>
<th>Type</th>
<th>Description</th>
<th>Standards</th>
<th>Diameters (mm)</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>ULTRAMAG®</strong></td>
<td>For semi-automatic and automatic welding applications</td>
<td>ER255-65S</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / S300 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>SUPRAMIG®</strong></td>
<td>High productivity, good feedability, consistent welding performance, stable arc, and low spatter.</td>
<td>ER255-65S</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>SUPRAMIG®HD</strong></td>
<td>Welding of structural steels (Tensile strength up to 590 N/mm²). Excellent feedability and very consistent welding performance. Tight and stable arc with extremely low spatter – better bead profile and appearance. Ultimate GMAW wire for robotics and hard automation.</td>
<td>ER255-65S</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>ULTRAMAG®SG3</strong></td>
<td>Good feedability, consistent welding performance. Very good weldability, stable arc, and low spatter - High productivity.</td>
<td>ER305-34G5</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>SUPRAMIG ULTRA®</strong></td>
<td>Excellent feedability and very consistent welding performance. Tight and stable arc with extremely low spatter.</td>
<td>ER305-34G5</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>SUPRAMIG ULTRA®HD</strong></td>
<td>Good weld bead aspect. Tight and stable arc with extremely low spatter. Self releasing silicate islands. Deep root penetration and improved fatigue life.</td>
<td>ER305-34G5</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>OUTERSHIELD®MC710-H</strong></td>
<td>All position high efficiency gas shielded metal cored wire. Superior on scaled plate, good resistance to porosity. Very few sllices, virtually no spatter, fast travel speed, excellent wire feeding.</td>
<td>E70C-6M-H</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>OUTERSHIELD®71M-H</strong></td>
<td>Excellent operator appeal due to superior welding characteristics and premium slag system. Specially developed for welding with 100% CO₂ and optimised for Ar/CO₂ mix gas; smooth arc with low spatter.</td>
<td>E71T-3/5C-H4 / E71T-3/5H-H4</td>
<td>Ø0.2 Ø0.4 Ø0.1 Ø0.6</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>OUTERSHIELD®71E-H</strong></td>
<td>All position gas shielded flux cored wire for high quality welding. Full out-of-position capability with higher deposition rate (up to 3.2 kg/h). Exceptional mechanical properties (EHNV = 430 at -30°C) with Mo21 shielding gas.</td>
<td>E71T-3M-H5</td>
<td>Ø0.2</td>
<td>Coil S200 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>INNERSHIELD® NR®211MP</strong></td>
<td>General purpose welding. Recommended for sheets from 2.5 to 2.0mm. Welding galvanized steel.</td>
<td>E71T-11</td>
<td>Ø0.9 Ø1.1 Ø1.2 Ø2.0</td>
<td>Coil S200 / S300</td>
</tr>
<tr>
<td><strong>LNM 28</strong></td>
<td>Welding of weather resisting steels; Contains a small % of copper to help preventing further oxidation of the weld bead.</td>
<td>G 3 Z MnNiCr</td>
<td>Ø1.0 Ø1.2</td>
<td>Coil B300</td>
</tr>
<tr>
<td><strong>LNM MoNi</strong></td>
<td>Welding of high strength steels with a yield up to 620 Mpa. Good impact values at -40°C.</td>
<td>G 624 M MnNiCr</td>
<td>Ø0.8 Ø1.0 Ø1.2</td>
<td>Coil B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>LNM MoNiVa</strong></td>
<td>Welding of high strength steels with yield strength up to 890MPa can be used as well (for welding grade 5860).</td>
<td>G 694 M MnNiCrMo</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.4</td>
<td>Coil B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>LNM MoNiCr</strong></td>
<td>Welding of high strength steels with yield strength up to 890 MPa.</td>
<td>G 694 M MnNiCrMo</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.4</td>
<td>Coil B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>LNM 304LSi</strong></td>
<td>Extra low carbon for welding austenitic CrNi-steels. With increased silicon for improved weldability.</td>
<td>ER308LSi</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>LNM 316LSi</strong></td>
<td>Extra low carbon for welding austenitic CrNiMo-steels. With increased silicon for improved weldability.</td>
<td>ER316LSi</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>LNM 309LSi</strong></td>
<td>Solid wire for welding stainless steel to carbon steel.</td>
<td>ER309LSi</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / B300 AccuT rak drum</td>
</tr>
<tr>
<td><strong>COR A ROSTA® 304L</strong></td>
<td>Gas shielded flux cored wire for downhand welding (304L or equivalents).</td>
<td>E308LT-0.9-4</td>
<td>Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil S200 / B300</td>
</tr>
<tr>
<td><strong>COR A ROSTA® 316L</strong></td>
<td>Gas shielded flux cored wire for downhand welding (316L or equivalents).</td>
<td>E316LT-0.9-4</td>
<td>Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300</td>
</tr>
<tr>
<td><strong>SUPERGLAZE® MIG 4043</strong></td>
<td>General purpose welder alloy for welding 5XXX series alloys suitable for sustained elevated temperature service. i.e. above 65°C.</td>
<td>ER4043</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / S100 / SemiPak</td>
</tr>
<tr>
<td><strong>SUPERGLAZE® MIG 5356</strong></td>
<td>General purpose filler alloy for welding 6XXX series alloys when 276 MPa tensile strength is not required. Excellent colour match after anodizing.</td>
<td>ER5356</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / S100 / SemiPak</td>
</tr>
<tr>
<td><strong>LNM 420FM</strong></td>
<td>Welding steel with difficult weldability. Often used as a buffer layer in hardfacing applications.</td>
<td>S Feb</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300</td>
</tr>
<tr>
<td><strong>LNM 307</strong></td>
<td>Welding steel with difficult weldability. Often used as a buffer layer in hardfacing applications.</td>
<td>ER307T</td>
<td>Ø0.8 Ø1.0 Ø1.2 Ø1.6</td>
<td>Coil B300 / AccuT rak drum</td>
</tr>
<tr>
<td><strong>LINCORE®55</strong></td>
<td>Deposits feature higher alloy levels than to resist both abrasion and moderate impact.</td>
<td>T Fe2</td>
<td>Ø1.6 Ø2.0</td>
<td>Coil S300</td>
</tr>
<tr>
<td><strong>LINCORE®60-0</strong></td>
<td>Deposits feature higher alloy levels than to resist both abrasion and moderate impact. Can be used at temperatures up to 700°C. Can be used on carbon, low alloy, manganese and stainless steels and cast iron.</td>
<td>T Fe2</td>
<td>Ø1.6 Ø2.0</td>
<td>Coil S300</td>
</tr>
</tbody>
</table>

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## TIG RODS

### SELECTION DIAGRAM

- **STEEL**
  - **7053**
  - **7056**
  - **LNT 25**
  - **LNT 26**

- **STAINLESS STEEL**
  - **304/308**
  - **316**
  - **LNT 304L**
  - **LNT 316L**
  - **LNT 304LSi**
  - **LNT 316LSi**

- **ALUMINIUM**
  - **AISi5 (4043)**
  - **AIMg5 (5356)**
  - **SUPERGLAZE® TIG 4043**
  - **SUPERGLAZE® TIG 5356**

### SELECTION TABLE

<table>
<thead>
<tr>
<th>Material</th>
<th>TIG rods</th>
<th>Standards</th>
<th>Diameters [mm]</th>
<th>Packaging</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>STEEL</strong></td>
<td><strong>LNT 25</strong></td>
<td>W 42 S WSiI</td>
<td>Ø1.6 Ø2.0 Ø2.4 Ø3.0</td>
<td>PE tube</td>
</tr>
<tr>
<td><strong>STEEL</strong></td>
<td><strong>LNT 26</strong></td>
<td>W 42 S WSiI</td>
<td>Ø1.6 Ø2.0 Ø2.4 Ø3.2</td>
<td>PE tube</td>
</tr>
<tr>
<td><strong>STAINLESS STEEL</strong></td>
<td><strong>LNT 304LSi</strong></td>
<td>ER308LSi</td>
<td>Ø1.2 Ø1.6 Ø2.0 Ø2.4 Ø3.2</td>
<td>PE tube</td>
</tr>
<tr>
<td><strong>STAINLESS STEEL</strong></td>
<td><strong>LNT 316LSi</strong></td>
<td>ER316LSi</td>
<td>Ø1.2 Ø1.6 Ø2.0 Ø2.4 Ø3.2</td>
<td>PE tube</td>
</tr>
<tr>
<td><strong>ALUMINIUM</strong></td>
<td><strong>SUPERGLAZE® TIG 4043</strong></td>
<td>R4043</td>
<td>Ø1.6 Ø2.0 Ø2.4 Ø3.0 Ø3.2</td>
<td>Cardboard</td>
</tr>
<tr>
<td><strong>ALUMINIUM</strong></td>
<td><strong>SUPERGLAZE® TIG 5356</strong></td>
<td>R5356</td>
<td>Ø1.6 Ø2.0 Ø2.4 Ø3.2</td>
<td>Cardboard</td>
</tr>
</tbody>
</table>

- **Standards Certificates**: Available
- **Special Certificates**: On request
- **Approvals (TÜV, DNV, DB)**: Consult us

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PACKAGING SOLUTIONS

STICK ELECTRODES

LINC PACK: 1kg pack
CARDBOARD: The cost effective solution
PE TUBE
LINC CAN™: High quality packaging
PROTECH™: Vacuum packaging
SAHARA READYPACK® The best vacuum pack

MIG & FLUX-CORED WIRES

ACCU TRAK DRUM®
GEM-PAK™
PE TUBE
CARDBOARD

ROD OVEN HYDROGUARD™
Protect your stick electrodes from moisture pick up and prevent weld cracking and porosity
BEING PRESENT LOCALLY
MAKES US MORE AWARE GLOBALLY

CUSTOMER ASSISTANCE POLICY
The business of The Lincoln Electric Company® is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers’ particular purpose is specifically disclaimed.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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