

# WELDING CONSUMABLES



*Multimet*<sup>®</sup>  
Inżynieria spawalnicza



*Multimet*<sup>®</sup>  
Inżynieria spawalnicza

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## Dear Customer,

Multimet is a family owned company manufacturing a high quality welding wires, based on newest technologies and European reliable raw material since 1980.

Being present globally we are providing high quality products in tailored made characteristics if required. Production offer contains a complete range of welding wires produced in *Multimet* brand or **OEM** [privat label] customers.

Continious improvement and global expansion of Our offer is an effect of the very dynamic activity of R&D and close cooperation with customers defining and fullfiling their needs. Our commitment to the best solutions possible allow us to further increase the range of high quality products. The variety of welding consumables materials for sure will meet the individual needs of each customer.

The high quality materials offered by Multimet has been proven in professional operations by satisfied customers in most demanding applications. Products received certificates by notified units such as DB, BV, LR, DNV, ABS, TUV. The strong and stable position of Multimet is based on pre and post sales service including tests, training and education is an additional value.

Our highly qualified staff is ready to help You to solve the most challenging welding cases.

If you are interested in purchasing goods please contact head quater. I truly hope that Multimet offer will meet desire requirements and we are going to have occasion to cooperate.

**Best Regards**  
**Grzegorz Całek**  
**President**

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## WELDING POSITIONS



all positions



all positions, except vertical down



all positions, except vertical down and overhead



flat butt and fillet welds only



flat butt welds only



vertical down only



vertical up only

## SYMBOLS FOR TYPE OF CURRENT AND POLARITY



DC, electrode connected to positive pole



DC, electrode connected to negative pole



DC, electrode connected to either positive or negative pole



AC



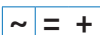
preferably DC, electrode connected to positive pole, AC



preferably DC, electrode connected to negative pole, AC



preferably DC, electrode connected to either positive or negative pole, AC



preferably AC, DC electrode connected to positive pole

A large spool of solid wire, likely made of copper or aluminum, is shown in a close-up, curved perspective. The wire is tightly packed and forms a thick, cylindrical shape. A blue horizontal line is visible at the top of the image, partially obscured by the wire. The background is a light, neutral color.

# SOLID WIRES

## IMT 2

## IMT 2

## CLASSIFICATIONS:

EN ISO 14341-A: G3Si1  
 AWS A 5.18: ER70S-6  
 Werkstoff Nr - 1.5125

## DESCRIPTION:

GMAW solid wire, copper coated, with the de-oxidising agents Mn and Si. This product is designed for semi-automatic welding under the shielding gas of C1 (CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). Metallurgical properties of the wire guarantee high quality welds and reliable wire-feeding during mechanized welding. The working temperature of welded joints is (-40°C) ÷ (450°C). IMT 2 is suitable for welding of unalloyed construction steels, boiler steels, shipbuilding steels and lowalloyed, general purpose, C-Mn steels of increased strength.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,07	0,85	1,45	coating

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	KV [J]
C1(CO <sub>2</sub> ); M21 (Ar + CO <sub>2</sub> )	> 420	500 ÷ 640	> 20	> 60 (-40°C) M21	> 47 (-40°C) C1

## APPROVALS:

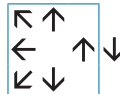
TÜV	LR	ABS	DNV	BV	PRS	DB	UDT
+	+	+	+	+	+	+	+

Approvals: + obtained, x on request

## CURRENT:

= +

## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



## IMT 2E

### CLASSIFICATIONS:

EN ISO 14341-A: G3Si1  
 AWS A 5.18: ER70S-6  
 Werkstoff Nr - 1.5125

### DESCRIPTION:

GMAW solid wire, copper coated, with de-oxidising agents Mn and Si. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). Metallurgical properties of the wire guarantee high quality of the welds and reliability of feeding of the wire in the process of mechanized welding. The working temperature is (-40°C) ÷ (350°C).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,075	0,95	1,65	coating

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	KV [J]
C1(CO <sub>2</sub> ); M21 (Ar + CO <sub>2</sub> )	> 420	500 ÷ 640	> 20	> 60 (-40°C) M21	> 47 (-40°C) C1

### APPROVALS:

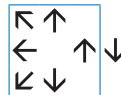
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT 3

## IMT 3

## CLASSIFICATIONS:

EN ISO 14341-A: G4Si1  
 AWS A 5.18: ER70S-6  
 Werkstoff Nr - 1.5130

## DESCRIPTION:

GMAW solid wire, copper coated, with de-oxidising agents Mn and Si. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). The increased content of Mn gives higher weld strength, higher resistance to surface contamination and better impact strength, when compared to IMT 2 wire. The working temperature is (-40°C) ÷ (450°C). IMT 3 is suitable for welding of unalloyed construction steels, boiler steels, shipbuilding steels and low-alloyed, general purpose, C-Mn steels of increased strength.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,075	0,95	1,65	coating

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	KV [J]
C1(CO <sub>2</sub> ); M21 (Ar + CO <sub>2</sub> )	> 460	530 ÷ 680	> 20	> 60 (-40°C) M21	> 60 (-20°C) C1

## APPROVALS:

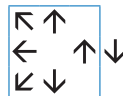
TÜV	LR	ABS	DNV	BV	PRS	DB	UDT
+	+	+	+	+	+	+	+

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT 3E

### CLASSIFICATIONS:

EN ISO 14341-A: G4Si1  
 AWS A 5.18: ER70S-6  
 Werkstoff Nr - 1.5130

### DESCRIPTION:

GMAW solid wire, copper coated, with de-oxidising agents Mn and Si. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). The increased content of Mn gives higher weld strength, higher resistance to surface contamination and better impact strength when compared to IMT 2E wire. The working temperature is [-40°C] ÷ [350°C].

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,075	0,95	1,65	coating

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	KV [J]
C1(CO <sub>2</sub> ); M21 (Ar + CO <sub>2</sub> )	> 460	530 ÷ 680	> 20	> 60 [-40°C] M21	> 47 [-40°C] C1

### APPROVALS:

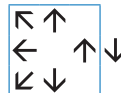
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:

= +

### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT Mo

### CLASSIFICATIONS:

EN ISO 14341-A: G2Mo  
 AWS A 5.28: ER80S-G  
 Werkstoff Nr - 1.5424

### DESCRIPTION:

GMAW solid wire copper coated, with 0,5% Mo, for semi-automatic welding under shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). The welds are characterized by high strength, ductility and resistance to aging. The working temperature of welded joints is up to (500°C). IMT Mo is suitable for welding of construction steels, boiler steels, shipbuilding steels, creep resistant steels of 0,5% type and low-alloyed general purpose steels of increased strength.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cu
0,10	0,59	1,13	0,50	coating

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	KV [J]
C1(CO <sub>2</sub> ); M21 (Ar + CO <sub>2</sub> )	> 460	530 ÷ 680	> 20	> 47 (-20°C) M21	> 47 (-20°C) C1

### APPROVALS:

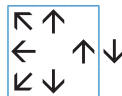
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	+

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT CrMo1Si

## CLASSIFICATIONS:

EN ISO 21952-A:G CrMo1Si  
AWS A 5.28: ER80S-G

## DESCRIPTION:

GMAW solid wire, copper coated with 1,25% Cr, 0,5% Mo. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>) for single and multipass welding of creep resistant steels with working temperature up to (500°C). IMT CrMo1Si is suitable for welding of high-pressure boilers and pipe-lines.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,08	0,70	0,65	0,50	1,25

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 470	> 550	> 19	> 70 (-20°C) M21	700°C - 1h

## APPROVALS:

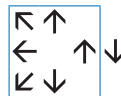
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT CrMo2Si

### IMT CrMo2Si

#### CLASSIFICATIONS:

EN ISO 21952-A:G CrMo2Si  
AWS A 5.28: ER90S-G

#### DESCRIPTION:

GMAW solid wire copper coated with 2,25% Cr, 1% Mo. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>) for single and multipass welding of creep resistant steels with working temperature up to (600°C). IMT CrMo2Si is suitable for welding of high- pressure boilers and pipe-lines.

#### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,07	0,50	0,65	1,00	2,30

#### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 760	> 890	> 17	> 70 (+20°C) M21	700°C - 1h

#### APPROVALS:

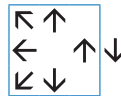
TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

#### CURRENT:



#### WELDING POSITIONS:



#### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT CrMo91

## CLASSIFICATIONS:

EN ISO 21952-A: G CrMo9 1  
 AWS A 5.28: ER90S-B9

## DESCRIPTION:

GMAW solid wire, copper coated with 9% Cr, 1%Mo. This product is designed for semi-automatic welding under the shielding gas of (Ar + CO<sub>2</sub>) or (Ar + CO<sub>2</sub> + O<sub>2</sub>) for single and multipass welding of creep resistant steels with working temperature up to (650°C). IMT CrMo91 is suitable for welding of the steel for high temperature, creep-resistant and heatresistant type P91.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Ni	Mo	V	Nb
0,090	0,30	0,50	9,10	0,50	0,90	0,20	0,07

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
EN ISO 14175: M20 M21 M24 M26	690	780	21	+20°C : 150	700°C - 1h

## WELDING PROCESS:

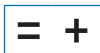
Preheat Temperature: 205-320°C  
 Interpass Temperature: 205-320°C  
 Post-Weld Heat Treatment: 760±15°C

## APPROVALS:

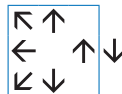
TÜV	LR	ABS	DNV	BV	DB	UDT
x						

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT CORTEN

### CLASSIFICATIONS:

EN ISO 14341-A: GZ  
AWS A 5.28: ER80S-G

### DESCRIPTION:

GMAW solid wire, copper coated with 0,3% Cr. This product is designed for semi-automatic welding under the protective atmosphere of mixtures M21 (Ar + CO<sub>2</sub>) for single and multipass welding of weathering steels, also suitable for joining high yield strength steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Cu	Ni
0,1	0,7	1,4	0,3	0,3	0,8

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 490	> 560	> 24	> 60 (-20°C)

### APPROVALS:

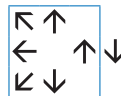
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



# IMT NiMoCr

## CLASSIFICATIONS:

EN ISO 16834-A:G Mn3Ni1CrMo  
AWS A 5.28: ER100S-G

## DESCRIPTION:

GMAW solid low-alloyed wire, copper-coated. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). The welds made with this wire are characterised by good resistance to brittle cracking. IMT NiMoCr is suitable for welding of high strength steels in productions of heavy-duty machinery, crane installations, equipment for excavation and mining industry.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	Cu
0,08	0,45	1,60	0,25	0,30	1,90	coating

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 690	> 720	> 17	> 47 (-40°C) M21

## APPROVALS:

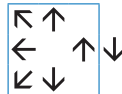
TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

## CURRENT:

= +

## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT NiMoCr-2

### IMT NiMoCr-2

#### CLASSIFICATIONS:

EN ISO 16834-A:G Mn4Ni2CrMo  
AWS A 5.28: ER110S-G

#### DESCRIPTION:

GMAW solid low- alloyed wire, copper- coated. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>) for single and multipass welding. The welds made with this wire are characterised by good resistance to brittle cracking. IMT NiMoCr-2 is suitable for welding of high strength steels with yield strength up to 890MPa in production of heavy-duty machinery, crane installations, equipment for excavation and mining industry.

#### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni
0,09	0,80	2,90	0,60	0,30	2,30

#### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 890	> 960	> 15	> 47 (-60°C) M21

#### APPROVALS:

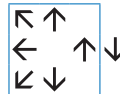
TÜV	LR	ABS	DNV	BV	DB	UDT
					+	

Approvals: + obtained, x on request

#### CURRENT:

= +

#### WELDING POSITIONS:



#### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT NiMoCr-2.5

### CLASSIFICATIONS:

EN ISO 16834-A: G Mn4Ni2.5CrMo  
AWS A 5.28: ER120S-G

### DESCRIPTION:

GMAW solid low-alloyed wire, copper coated. This product is designed for semi-automatic welding under the shielded gas of mixtures M21 (Ar + CO<sub>2</sub>) for single and multipass welding. IMT NiMoCr-2.5 is suitable for welding of high strength steels with requirements for high impact resistance in low temperatures.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni
0,07	0,5	1,5	0,45	0,3	2,5

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21	> 960	> 1040	> 16	> 60 [-40°C]

### APPROVALS:

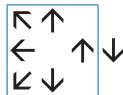
TÜV	LR	ABS	DNV	BV	DB	UDT
					+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT G2Ni2

### IMT G2Ni2

#### CLASSIFICATIONS:

EN ISO 14341-A: G2 Ni2  
AWS A5.28: ER80S-Ni2

#### DESCRIPTION:

GMAW solid wire, copper coated with 2% Ni. This product is designed for semi-automatic welding under the shielding gas of C1(CO<sub>2</sub>) or mixtures M21 (Ar + CO<sub>2</sub>). IMT G2Ni2 is suitable for single and multipass welding for low temperature steels with impact resistance up to (-60°C).

#### CHEMICAL COMPOSITION [%]:

C	Si	Mn	P	S	Ni
0,08	0,60	1,10	< 0,015	< 0,015	2,50

#### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 470	> 600	> 26	> 60 (-60°C) M21

#### APPROVALS:

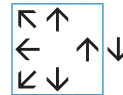
TÜV	LR	ABS	DNV	BV	DB	UDT
x					+	

Approvals: + obtained, x on request

#### CURRENT:



#### WELDING POSITIONS:



#### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



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# STAINLESS STEEL WIRES

## IMT 307 Si

### CLASSIFICATIONS:

EN ISO 14343-A: G 18 8 Mn  
 AWS A5.9: ER 307

### DESCRIPTION:

The wires and rods for welding and surfacing of semi-automatic shield gas mixture Ar+CO<sub>2</sub> (MAG) and argon Ar (TIG). This gives austenitic-ferritic weld metal, exhibiting high resistance to hot cracking, intended primarily for making joint dissimilar stainless steels, eg. with unalloyed steels (low and high-carbon), low-alloy or to join ferritic steels, ferritic-martensitic, ferritic-austenitic tool, spring, high-manganese (13 -14% Mn) - wear resistant, heat resistant. Also used for buffer layers before hardfacing hard alloys.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Ni
0,20	0,65-1,0	4,5-7,5	17,0-20,0	7,0-10,0

### MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M1	> 500	> 350	> 25	+20°C : 120

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:

MAG:

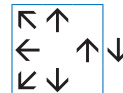


TIG:



### WELDING POSITIONS:

MAG:



TIG:



### DIAMETER:

MAG: Ø mm*			
0,8	1,0	1,2	1,6

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

# IMT 308 LSi

## CLASSIFICATIONS:

EN ISO 14343-A: W/G 19 9 LSi  
 AWS A5.9: ER 308 LSi

## DESCRIPTION:

The wires and rods for welding and surfacing of semi-automatic shield gas mixture of Ar+CO<sub>2</sub> (MAG) and argon Ar (TIG). The weld metal resistant to intergranular corrosion and corrosion in liquid media up to 350°C, acid oxidizing and reducing acids at low temperatures. Designed for austenitic stainless steels with low carbon content. Also used to unstabilized and stabilized Nb, Ti corrosion-resistant steel series. The increased silicon content in purpose to improve the weldability.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Ni
0,30	0,65-1,0	1,0-2,5	19,5-22,0	9,0-11,0

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M1	> 510	> 320	> 30	-190°C : 47

## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

## CURRENT:

MAG:

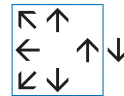


TIG:



## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*			
0,8	1,0	1,2	1,6

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 309 LSi

### CLASSIFICATIONS:

EN ISO 14343-A: W/G 23 12 LSi  
 AWS A5.9: ER 309 LSi

### DESCRIPTION:

The wires and rods for welding and surfacing of semi-automatic shield gas mixture Ar+CO<sub>2</sub> (MAG) and argon Ar (TIG). After welding, the weld metal obtained austenitic high content of Cr and Ni with a low carbon content. Designed to joint unalloyed, low-alloy steel, stainless steel, heat resistant steels with austenitic steels. Also used stacking buffer layers by plating the surface of the sheet non-stabilized, stabilized and austenitic steels with low carbon content. The increased silicon content in purpose to improve the weldability.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Ni
0,03	0,65-1,0	1,0-2,5	23,0-25,0	12,0-14,0

### MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M1	> 510	> 320	> 25	-20°C : 47

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:

MAG:

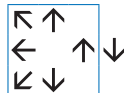


TIG:



### WELDING POSITIONS:

MAG:



TIG:



### DIAMETER:

MAG: Ø mm*			
0,8	1,0	1,2	1,6

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement



# IMT 316 LSi

## CLASSIFICATIONS:

EN ISO 14343-A: W/G 19 12 3 LSi  
 AWS A5.9: ER 316 LSi

## DESCRIPTION:

The wires and rods for welding and surfacing of semi-automatic shield gas mixture Ar+CO<sub>2</sub> (MAG) and argon Ar (TIG). Designed primarily for welding low-carbon, acid-resistant, austenitic CrNiMo steel, as well as for welding of Nb or Ti stabilized. Resistant to intergranular corrosion and corrosion in liquid media (in dilute acids) to 400°C. Ensure the achievement of the welds on the structure of austenitic-ferritic and austenitic.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cr	Ni	Ni
0,03	0,65-1,0	1,0-2,5	2,0-3,0	18,0-20,0	11,0-14,0

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M1	> 550	> 350	> 20	+20°C : 100

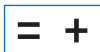
## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

## CURRENT:

MAG:

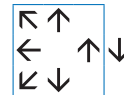


TIG:



## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*			
0,8	1,0	1,2	1,6

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement





# ALUMINIUM WIRES

## IMT AlSi5

### CLASSIFICATIONS:

EN ISO 18273: S Al 4043 (AlSi5)  
 AWS A5.10: ER 4043

### DESCRIPTION:

Aluminium wires and rods containing 5% Si for welding semi-automatic MIG and TIG argon, helium or a mixture of Ar + H<sub>1</sub>. Suitable for welding aluminum alloys (AlSi) containing 7% Si as the main alloying element and aluminum alloys (AlMgSi) containing 2% of alloying elements.

### CHEMICAL COMPOSITION [%]:

C	Fe	Cu	Mn	Zn	Ti	Mg
5,0	0,8	0,03	0,05	0,10	0,20	0,05

### MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	Melting range [°C]
IL	> 40	> 120	> 8	573-625

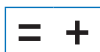
### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+	x		x		x	

Approvals: + obtained, x on request

### CURRENT:

MAG:

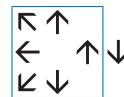


TIG:

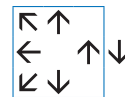


### WELDING POSITIONS:

MAG:



TIG:



### DIAMETER:

MAG: Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

# IMT AlSi12

## CLASSIFICATIONS:

EN ISO 18273: S Al 4047A (AlSi12(A))  
 AWS A5.10: ER 4047

## DESCRIPTION:

Aluminium wires and rods containing 12% Si for welding semi-automatic MIG and TIG argon, helium or a mixture of Ar + H1. Suitable for welding aluminum alloys (AlSi) containing more than 7% Si as the main alloying element. Corrosion resistance of the weld metal. The low melting temperature minimizes deformation of the parent material.

## CHEMICAL COMPOSITION [%]:

Si	Fe	Cu	Mn	Zn	Mg
12,0	0,8	0,03	0,05	0,20	0,10

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	Melting range [°C]
Il	> 60	> 130	> 5	573-585

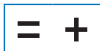
## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x	x		x		x	

Approvals: + obtained, x on request

## CURRENT:

MAG:

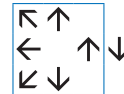


TIG:

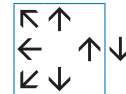


## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

# IMT AlMg5

## CLASSIFICATIONS:

EN ISO 18273: S Al 5356 (AlMg5Cr(A))  
 AWS A 5.10: ER 5356

## DESCRIPTION:

Aluminium wires and rods containing 5% Mg welding semi-automatic MIG and TIG argon, helium or a mixture of Ar + H1. Suitable for welding Al-Mg alloys and AlMgSi. The weld metal resistant to seawater. After anodizing produces a similar color to the parent material.

## CHEMICAL COMPOSITION [%]:

Si	Fe	Cr	Cu	Mn	Zn	Ti	Mg
0,25	0,40	0,05-0,20	0,10	0,05-0,20	0,10	0,06-0,20	5,0

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	Melting range [°C]
Il	> 110	> 235	> 17	562-633

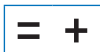
## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+	x	+	x		+	

Approvals: + obtained, x on request

## CURRENT:

MAG:

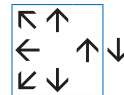


TIG:

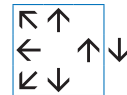


## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

# IMT AlMg4.5Mn

## CLASSIFICATIONS:

EN ISO 18273: S Al 5183 (AlMg4.5Mn0.7(A))  
 AWS A5.10: ER 5183

## DESCRIPTION:

Aluminum wires and rods for semi-automatic MIG welding and TIG argon, helium or a mixture of Ar + H1 containing approx. 5% Mg and Mn content increased to increase the strength. Suitable for welding Al-Mg alloy AlMgSi and high strength. The weld metal is highly resistant to seawater.

## CHEMICAL COMPOSITION [%]:

Si	Fe	Cr	Cu	Mn	Zn	Ti	Mg
0,40	0,40	0,05-0,25	0,10	0,50-1,0	0,25	0,15	4,30-5,20

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	Melting range [°C]
Il	> 125	> 275	> 17	568-638

## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+	x	+	x		+	

Approvals: + obtained, x on request

## CURRENT:

MAG:

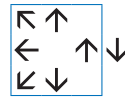


TIG:

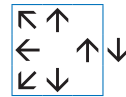


## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

# IMT AlMg4.5MnZr

## CLASSIFICATIONS:

EN ISO 18273: S Al 5087 AlMg4,5MnZr(A)  
 AWS A5.10: ER 5087

## DESCRIPTION:

Aluminium wires and rods for welding semi-automatic MIG and TIG argon, helium or a mixture of Ar + H1 containing approx. 5% Mg, Mn content increased and micro-addition Zr. Suitable for welding Al-Mg alloys and AlMgSi. The weld metal has a high strength, resistance to hot cracking, and high resistance to sea water.

## CHEMICAL COMPOSITION [%]:

Si	Fe	Cr	Cu	Mn	Zn	Ti	Zr	Mg
0,25	0,40	0,05-0,25	0,05	0,70-1,1	0,25	0,15	0,10-0,20	4,50-5,20

## MECHANICAL PROPERTIES:

GAS	Re [MPa]	Rm [MPa]	A5 [%]	Melting range [°C]
Il	> 125	> 275	> 17	568-638

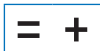
## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x	x		x		x	

Approvals: + obtained, x on request

## CURRENT:

MAG:

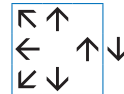


TIG:

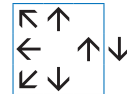


## WELDING POSITIONS:

MAG:



TIG:



## DIAMETER:

MAG: Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

TIG: Ø mm*								
0,8	1,0	1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement





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# SEAMLESS FLUX CORED WIRES

## IMT M700

### CLASSIFICATIONS:

EN ISO 17632-A: T46 6 M M21 1 H5  
AWS A5.18: E70C-6M H4

### DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding. Very low hydrogen content (HD < 5ml/100g) provides excellent mechanical properties in temperatures as low as (-60°C). IMT M700 is suitable for application, shipbuilding and steel construction. CTOD tested.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	P	S
0,05	0,7	1,5	< 0,015	< 0,015

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 460	> 530- 680	> 27	> 47 (-60°C) M21

### APPROVALS:

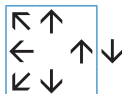
TÜV	LR	ABS	DNV	BV	DB	UDT
+	x	+	+	+	+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT M700Ni

## CLASSIFICATIONS:

EN ISO 17632-A: T50 6 1Ni M M21 1 H5  
A 5.28: E80C-Ni1 H4

## DESCRIPTION:

Seamless metallic flux cored wire, copper coated with rapidly solidifying slag. This product is designed for single and multipass welding. Very low hydrogen content (HD < 5ml/100g) provides excellent mechanical properties in temperatures as low as (-60°C). IMT M700Ni is suitable for offshore application, shipbuilding and steel construction.

## CHEMICAL COMPOSITION [%]:

Gas	C	Si	Mn	Ni
M21	0,06	0,50	1,30	0,90

## MECHANICAL PROPERTIES:

Condition	Re [MPa]	Rm [MPa]	A5 [%]	KV[J] -60°C
a	530	620	27	90
b	500	560	26	90
c	360	520	33	100

a - untreated, as welded: shielding gas M21  
b - stress relieved 580°C/3h: shielding gas M21  
c - normalized 920°C/30min: shielding gas M21

## APPROVALS:

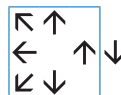
TÜV	LR	ABS	DNV	BV	DB	UDT
+		x	+		+	

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT R711

### CLASSIFICATIONS:

EN ISO 17632-A: T46 4 P M21 1 H5  
A5.20: E71T-1M/T-9M/T-12M JDH4

### DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding Very low hydrogen content (HD < 5ml/100g) provides excellent mechanical properties in temperatures as low as (-60°C). IMT R711 is suitable for offshore application, shipbuilding and steel construction. CTOD tested.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	P	S
0,05	0,5	1,3	< 0,015	< 0,015

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 470	> 540	> 25	60 (-40°C) M21

### APPROVALS:

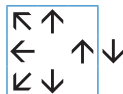
TÜV	LR	ABS	DNV	BV	DB	UDT
+	x	+	+	+	+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT R711Ni

## CLASSIFICATIONS:

EN ISO 17632-A: T46 5 P M21 1 H5  
A5.20: E71T1M/T-9M/T-12M JH4

## DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding. Very low hydrogen content (HD < 5ml/100g) provides excellent mechanical properties in temperatures as low as (-60°C). IMT R711Ni is suitable for offshore application, shipbuilding and steel construction.

## CHEMICAL COMPOSITION [%]:

Gas	C	Si	Mn	Ni
M21	0,06	0,45	1,30	0,35
C1	0,05	0,35	1,00	0,30

## MECHANICAL PROPERTIES:

Gas	Re [MPa]	Rm [MPa]	A5 [%]	KV[J]		
				+20°C	-20°C	-40°C
M21	590	560	28	120	110	90
C1	550	520	37	110	100	

## APPROVALS:

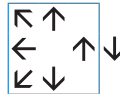
TÜV	LR	ABS	DNV	BV	DB	UDT
+	x		x			

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT R811

### CLASSIFICATIONS:

EN ISO 17632-A: T50 6 1Ni P M21 1 H5  
A5.29:E81T1-Ni1M-JH4

### DESCRIPTION:

Seamless rutile flux cored wire, copper coated. This product is designed for single and multipass welding. Low hydrogen content (HD < 5ml/100g) provides excellent mechanical properties even in temperatures as low as (-60°C). IMT R811 is suitable for offshore application, shipbuilding and steel construction.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Ni	P	S
0,05	0,5	1,3	0,8	< 0,015	< 0,015

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 510	> 570	> 20	> 47 (-60°C) M21

### APPROVALS:

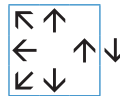
TÜV	LR	ABS	DNV	BV	DB	UDT
+	x	x	x	x	+	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT M CORTEN

## CLASSIFICATIONS:

EN ISO 17632-A: T46 4 Z M M 2 H5  
 AWS A 5.28: E80C-G H4

## DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding. Very low hydrogen content (HD < 5 ml/100 g) provides excellent mechanical properties in temperatures as low as (-40°C). IMT M CORTEN is suitable for welding atmosphere resistance steel type Corten.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu	Ni
0,06	0,45	1,20	0,50	0,20

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	470	550-680	22	-40°C > 47, -60°C > 27

## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT R CrMo1

### CLASSIFICATIONS:

EN ISO 17632-A: T CrMo1 P M 1 H5  
 AWS A 5.29: E81T1-B2 H4

### DESCRIPTION:

Seamless rutile flux cored wire, copper coated. This product is designed for single and multipass welding of creep resistant steels with a working temperature up to (500°C). Excellent mechanical properties, very low hydrogen content (HD < 5ml/100g).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,05	0,5	0,8	0,50	1,30

### MECHANICAL PROPERTIES:

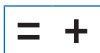
SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 470	> 570	> 19	> 50 (+20°C) M21	700°C - 1h

### APPROVALS:

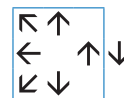
TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



# IMT M CrMo1

## CLASSIFICATIONS:

EN ISO 17632-A: T CrMo1 M M 2 H5  
 AWS A 5.28: E80C-B2 H4

## DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding of creep resistant steel with a working temperature up to (500°C). Excellent mechanical properties, very low hydrogen content (HD < 5ml/100g).

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,06	0,4	1,1	0,50	1,20

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 470	> 570	> 19	> 70 (+20°C) M21	700°C - 1h

## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT R CrMo2

### CLASSIFICATIONS:

EN ISO 17632-A: T CrMo2 P M 1 H5  
 AWS A 5.29: E91T1-B3 H4

### DESCRIPTION:

Seamless rutile flux cored wire, copper coated. This product is designed for single and multipass welding of creep resistance steel with working temperature up to (600°C). Good mechanical properties, very low hydrogen content (HD < 5ml/100g).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,06	0,35	1,10	1,00	2,20

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 540	> 700	> 17	> 70 (20°C) M21	700°C - 1h

### APPROVALS:

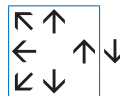
TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT M CrMo2

### CLASSIFICATIONS:

EN ISO 17632-A: T CrMo2 M M 2 H5  
AWS A 5.28: E90C-B3 H4

### DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding of creep resistance steel with working temperature up to (600°C). Good mechanical properties, very low hydrogen content (HD < 5ml/100g).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr
0,06	0,35	1,1	1	2,20

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]	PWHT
M21 (Ar + CO <sub>2</sub> )	> 540	> 700	> 17	> 70 (20°C) M21	700°C - 1h

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT R NiMoCr

### CLASSIFICATIONS:

EN ISO 18276-A: T69 4 Z P M 1 H5  
 AWS A 5.29: E110T1-K4 H4

### DESCRIPTION:

Seamless rutile flux cored wire, copper coated. This product is designed for single and multipass welding of high strength steels. Low hydrogen content (HD < 5 ml/100g) provides excellent mechanical properties even in temperatures as low as (-40°C). IMT R NiMoCr is suitable for offshore application, pipe line construction and heavy duty machinery.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Ni	P	S
0,07	0,40	1,70	0,18	2,00	< 0,020	< 0,020

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 690	> 780	> 17	> 70 (-40°C) M21

### APPROVALS:

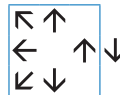
TÜV	LR	ABS	DNV	BV	DB	UDT
x	x		x	x	x	

Approvals: + obtained, x on request

### CURRENT:



### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

# IMT M NiMoCr

## CLASSIFICATIONS:

EN ISO 18276-A: T69 4 Mn2NiCrMo M M 2 H5  
 AWS A 5.28: E110TC-K4 H4

## DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding of high strength steels. Low hydrogen content (HD < 5 ml/100g) Provides excellent mechanical properties, high impact resistance in temperatures as low as (-40°C). IMT M NiMoCr is suitable for offshore application, pipe line construction, and heavy duty machinery.

## CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	P	S
0,07	0,40	1,40	0,40	0,50	2,20	< 0,025	< 0,025

## MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 690	> 800	> 19	> 47J (-40°C) M21

## APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x	x		x	x	x	

Approvals: + obtained, x on request

## CURRENT:



## WELDING POSITIONS:



## DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement

## IMT M NiMoCr2

### CLASSIFICATIONS:

EN ISO 18276-A: T89 4 Mn2NiCrMo M M 2 H5  
 AWS A 5.28: E120C-G H4

### DESCRIPTION:

Seamless metallic flux cored wire, copper coated. This product is designed for single and multipass welding of high strength steels. Excellent mechanical properties, high impact resistance in temperatures as low as (-40°C), very low hydrogen content (HD < 5ml/100g).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	P	S
0,06	0,50	1,60	0,40	1,00	2,20	< 0,025	< 0,025

### MECHANICAL PROPERTIES:

SHIELDING GAS	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21 (Ar + CO <sub>2</sub> )	> 960	> 1080	> 15	> 50 (-40°C)

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x			x		x	

Approvals: + obtained, x on request

### CURRENT:



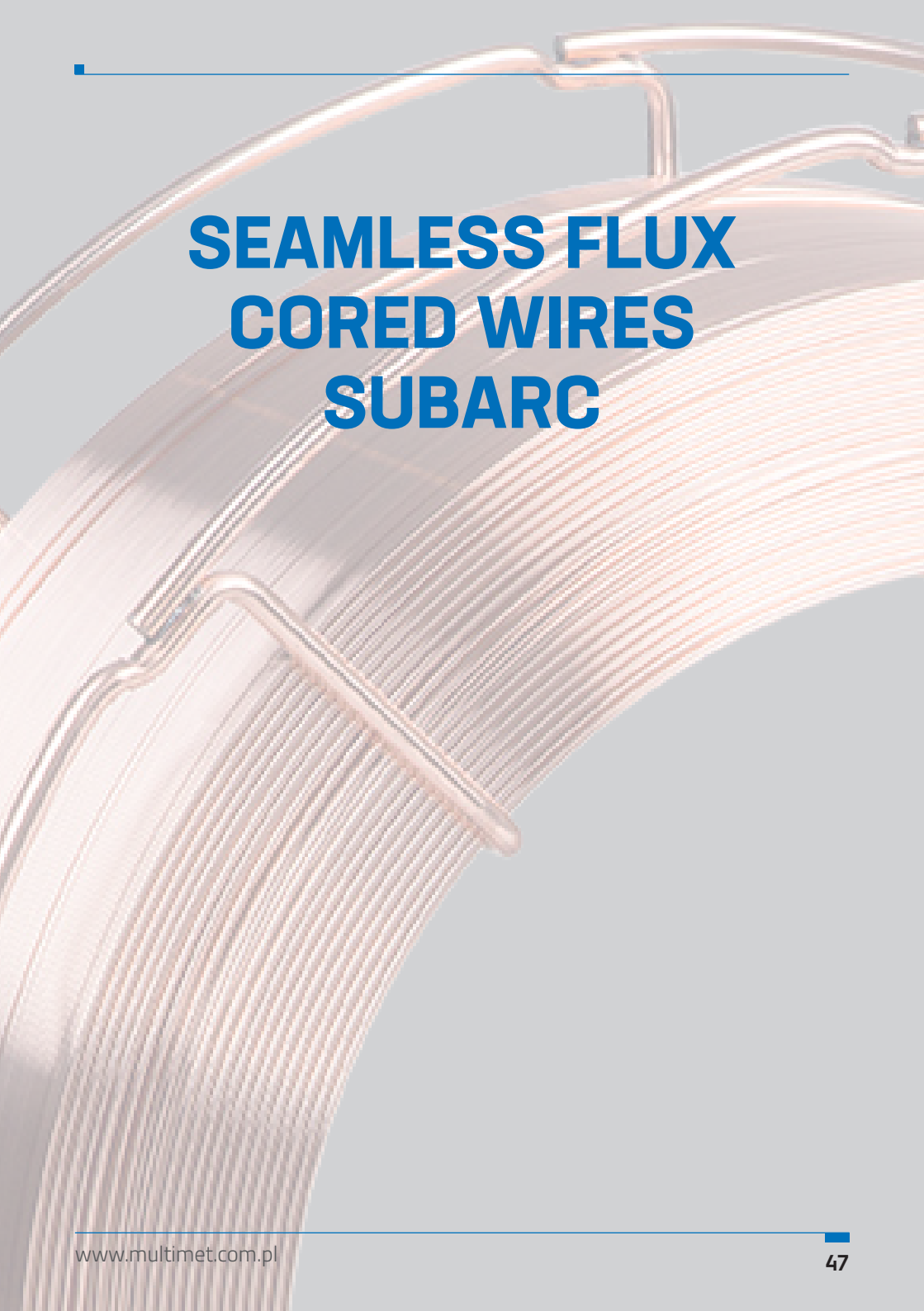
### WELDING POSITIONS:



### DIAMETER:

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



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# **SEAMLESS FLUX CORED WIRES SUBARC**

## MULTICORE B35

### CLASSIFICATIONS:

EN- ISO 14171-A: S46 6 FB T3 H5  
AWS A 5.17: F7A8-EC1 / F7P8-EC1

### DESCRIPTION:

MULTICORE B-35 is a seamless copper coated basic flux cored wire for SAW with an excellent quality of the joint and meets the highest requirements. Used for the welding of structural and fine grain steels in combination with fluxes TAL 3000 MV, TAL 1700. Welding with this wire enables up to 30% more cost-effective production compared to solid wire of the same diameter. The wire is used with success in applications such as offshore wind energy, platforms, shipbuilding, steel and apparatus construction, mechanical engineering and pipe work. It is very suitable for multi-layer welding (wall thickness unlimited), two-run technique up to 20mm and single-pass joint (one side welding on back up). MULTICORE B-35 is extremely crack resistant weld metal conditioned by the basic slag in combination with very low hydrogen content and does not moisture pick up. It can be stored indefinitely.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	P	S
0,04	0,25	1,65	0,4	< 0,02	< 0,02

### MECHANICAL PROPERTIES:

Yield Rp0,2 [MPa]:	Tensile Rm [MPa]:	Elongation A5 [%]:	KV [J]:
> 470	550-700	> 22	> 80 (-60°C) >100 (-40°C)

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*			
1,6	2,4	4,0	5,0

\*Other diameters available after agreement





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# SEAMED FLUX CORED WIRES

## IMT M70 M

### CLASSIFICATIONS:

EN ISO 17632-A: T46 4 M M 1 H5  
 AWS A 5.18: E70 C-6 M

### DESCRIPTION:

Seamed metalcored wire designed for universal application. Provides high mechanical properties, stable arc, smooth weld bead. High melting coefficient and capability to work in all positions. Suitable for butt and fillet welding. Excellent arc stability and optimum current range for spray transfer arc with less spatters. Shielding gas M21.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn
0,05	0,65	1,60

### MECHANICAL PROPERTIES:

Shielding Gas	Re [MPa]	Rm [MPa]	KV [J]	A5 [%]
M21	Min. 460	530-650	> 47 (-40°C) M21	> 22

### APPROVALS:

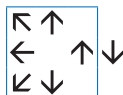
TÜV	LR	ABS	DNV	BV	DB	UDT
x	x	x	x	x	x	

Approvals: + obtained, x on request

### CURRENT:

FCAW/ D.C (+)

### WELDING POSITIONS:



### DIAMETER:

∅ mm
1,2    1,6

\*Other diameters available after agreement

# IMT R71 M

## CLASSIFICATIONS:

EN ISO 17632-A: T46 2 P M 1 H5  
AWS A 5.20: E71 T-1M

## DESCRIPTION:

Seamed rutile flux cored wire designed for applications in ship and steel constructions in all positions. Provides high mechanical properties, stable arc, smooth weld bead. It has high melting coefficient and capability to work with high current in all positions.

Shielding gas: M21

## CHEMICAL COMPOSITION [%]:

C	Si	Mn
0,06	0,5	1,3

## MECHANICAL PROPERTIES:

Shielding Gas	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]
M21	Min. 460	530-600	> 22	> 50 J(-20°C)

## APPROVALS:

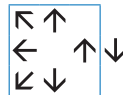
TÜV	LR	ABS	DNV	BV	DB	UDT
x	x	x	x	x	x	

Approvals: + obtained, x on request

## CURRENT:

FCAW/ D.C (+)

## WELDING POSITIONS:



## DIAMETER:

∅ mm*
1,2

\*Other diameters available after agreement

## IMT R71 C

### CLASSIFICATIONS:

EN ISO 17632-A: T42 4 P C 1 H5  
AWS A 5.20: E71 T-1C-J

### DESCRIPTION:

Seamed rutile flux cored wire designed for applications in ship and steel constructions in all positions. Provides high mechanical properties, stable arc, smooth weld bead. It has high melting coefficient and capability to work with high current in all positions.

Shielding gas: %100 CO<sub>2</sub>

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	P	S
0,06	0,5	1,3	0,015	0,015

### MECHANICAL PROPERTIES:

Shielding Gas	Re [MPa]	Rm [MPa]	KV [J]	A5 [%]
Co2	Min. 420	500-640	min. 50 J	> 22

### APPROVALS:

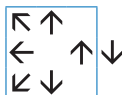
TÜV	LR	ABS	DNV	BV	DB	UDT
x	x	x	x	x	x	

Approvals: + obtained, x on request

### CURRENT:

FCAW/ D.C (+)

### WELDING POSITIONS:



### DIAMETER:

Ø mm*	
1,2	1,6

\*Other diameters available after agreement



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# SAW WIRES

## IMT 6

### CLASSIFICATIONS:

EN ISO 14171-A: S2Mo  
 A5.23: EA2  
 Werkstoff Nr - 1.5425

### DESCRIPTION:

SAW cooper coated wire, with Mo 0,5%. This product is designed for welding of construction steels, boiler steels, shipbuilding steels and low-alloyed general purpose C-Mn steels of increased strength. It is used in the energy industry for boilers and pipe line systems also for high pressure membrane walls. The working temperature of welded joints is up to (500°C).

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cu
0,11	0,13	1,02	0,50	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+			x		+	+

Approvals: + obtained, x on request

### CURRENT:

=	+	~
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### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 7

### CLASSIFICATIONS:

EN ISO 14171-A: S1  
 AWS A 5.17: EL12  
 Werkstoff Nr - 1.0351

### DESCRIPTION:

SAW copper coated wire for general purpose application.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,07	0,08	0,45	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 8

### CLASSIFICATIONS:

EN ISO 14171-A: S3  
 AWS A 5.17: EH10K  
 Werkstoff Nr - 1.0496

### DESCRIPTION:

SAW copper coated wire, manganese alloyed. Suitable for welding medium and high tensile strength steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,12	0,21	1,54	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+			x		+	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement



## IMT 8 Si

### CLASSIFICATIONS:

EN ISO 14171-A: S3Si  
AWS A 5.17: EH12K

### DESCRIPTION:

SAW copper coated wire, manganese alloyed. Suitable for welding medium and high tensile strength steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn
0,12	0,30	1,70

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+	x		+		x	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 8 Mo

### CLASSIFICATIONS:

EN ISO 14171-A: S3Mo  
AWS A 5.23: EA4

### DESCRIPTION:

SAW copper coated wire manganese alloyed with addition of 0,5% Mo. Suitable for welding medium and high tensile strength steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	P	S
0,13	0,13	1,45	0,48	0,07	0,08	0,009	0,007

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 8 Ni1Mo

### CLASSIFICATIONS:

EN ISO 14171-A: S3Ni1Mo  
AWS A 5.23: EG

### DESCRIPTION:

SAW copper coated wire, with additional of Ni=0,90% and Mo=0,525%. IMT 8 Ni1Mo is suitable for medium and high tensile strenght steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Ni
0,11	0,17	1,55	0,525	0,90

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 8 Ni2.5CrMo

### CLASSIFICATIONS:

EN ISO 26304-A: S3Ni2,5CrMo  
 AWS A 5.23: EG

### DESCRIPTION:

SAW copper coated wire, with addition of 2,5% Ni, 1,5% Mn, 0,65% Cr. Suitable for welding of high strength steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni
0,07 - 0,15	0,10 - 0,25	1,20 - 1,80	0,40 - 0,70	0,30 - 0,85	2,00 - 2,60

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+			+		x	x

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 9

### CLASSIFICATIONS:

EN ISO 14171-A: S2  
 AWS A 5.17: EM12  
 Werkstoff Nr - 1.0351

### DESCRIPTION:

SAW copper coated wire suitable for welding of unalloyed and low-alloyed steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,09	0,14	1,00	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	PRS	DB	UDT	RINA
+	+	+	+	+	+	+	+	+

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 9 Si

### CLASSIFICATIONS:

EN ISO 14171-A: S2Si  
 AWS A 5.17: EM12K  
 Werkstoff Nr - 1.0351

### DESCRIPTION:

SAW copper coated wire suitable for welding of unalloyed and low-alloyed steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Cu
0,11	0,24	0,92	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					+	

Approvals: + obtained, x on request

### CURRENT:

=	+	~
---	---	---

### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT 9 Ni2

### CLASSIFICATIONS:

EN ISO 14171-A: S2Ni2  
 AWS A 5.23: ENi2  
 Werkstoff Nr - 1.6227

### DESCRIPTION:

SAW copper coated wire with addition 2% Ni. Suitable for welding of low- alloyed and low temperature steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Ni	Cu
0,075	0,13	1,04	2,46	coating

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+			x			

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement

## IMT CrMo1

### CLASSIFICATIONS:

EN ISO 24598-A: S CrMo1  
 AWS A 5.23: EB2R

### DESCRIPTION:

SAW copper coated wire with addition of 1,1% Cr, 0,5% Mo. Suitable for welding of creep resistance steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	P	S
0,10	0,16	0,73	0,53	1,25	0,04	0,005	0,004

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
+					x	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement



## IMT CrMo2

### CLASSIFICATIONS:

EN ISO 24598-A: S CrMo2  
AWS A 5.23: EB3R

### DESCRIPTION:

SAW copper coated wire with addition of 2,39% Cr, 1% Mo. Suitable for welding of creep resistance steels.

### CHEMICAL COMPOSITION [%]:

C	Si	Mn	Mo	Cr	Ni	P	S
0,11	0,16	0,63	1,01	2,39	0,05	0,004	0,004

### APPROVALS:

TÜV	LR	ABS	DNV	BV	DB	UDT
x					x	

Approvals: + obtained, x on request

### CURRENT:



### DIAMETER:

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement



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# WELDING FLUXES

## TAL 800

### CLASSIFICATIONS:

EN ISO 14174 SA AR 1 76 AC H5

### DESCRIPTION:

TAL 800 is acid agglomerated flux designed for all submerg arc welding processes of carbon-manganese, low alloy structural and boiler quality steels with  $R_{e<355}$ MPa combined with following wires S1, S2, S2Si, S2Mo, S2CrMo1, S2CrMo2. Designed for welding with AC, DC current. TAL 800 is excellent for high speed welding up to 2m/min. Provides very smooth weld appearance, excellent slag removal even in narrow gap welding. Chemical composition of the flux provide high resistance to cracking.

### CHEMICAL COMPOSITION [%]:

CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	SiO <sub>2</sub> + TiO <sub>2</sub>
5%	55%	10%	25%

### BONISZEWSKI COEFFICIENT:

~ 0,6

### CHEMICAL ANALYSIS OF THE WELD METAL [%]:

	C	Si	Mn	Cr	Mo	Ni
S1	0,04-0,08	0,3-0,6	0,8-1,1			
S2	0,04-0,08	0,3-0,6	1,0-1,4			
S2Si	0,04-0,08	0,4-0,8	1,0-1,4			
S2Mo	0,04-0,08	0,3-0,7	1,0-1,4		0,4-0,6	
S CrMo1	0,04-0,08	0,3-0,7	0,9-1,3	1,0	0,4-0,6	

### MECHANICAL PROPERTIES OF THE WELD METAL:

	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]		
				+20°C	0°C	-20°C
S1	400	510	24	70	40	
S2	420	530	22	70	47	
S2Si	430	540	22	70	47	
S2Mo	480	580	20	60	47	
S CrMo1	520	610	20	50		

### ADDITIONAL INFORMATION:

FLUX DENSITY	GRAIN SIZE ACC. TO DIN EN ISO 14174	CURRENT - CARRYING CAPACITY	PACKAGING
1,0 kg/dm <sub>3</sub> [lt.]	2-12, 2-16, 2-20	800 A (DC or AC) using on wire	25 kg bags, 1 000 kg big bags

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# TAL 1700

## CLASSIFICATIONS:

EN ISO 14174 SA AB 1 67 AC H5

## DESCRIPTION:

TAL 1700 is basic agglomerated flux designed for submerg arc welding of low alloy, fine grained steels with  $Re < 460$  MPa combined with following wires S1, S2, S2Si, S2Mo, S2Ni2. Designed for welding with AC, DC current. It is suitable for the two-run or multilayer technique using single or multi wire processes. The flux is keeping constant metalurgical characteristics which provides excellent mechanical properties and easy slag relase even in narrow gap welding.

## CHEMICAL COMPOSITION [%]:

CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	SiO <sub>2</sub> + TiO <sub>2</sub>
30%	30%	15%	20%

## BONISZEWSKI COEFFICIENT:

~ 1,7

## CHEMICAL ANALYSIS OF THE WELD METAL [%]:

	C	Si	Mn	Cr	Mo	Ni
S2	0,05-0,08	0,2-0,4	1,1-1,5			
S2Si	0,05-0,08	0,2-0,4	1,1-1,5		0,5	
S2Mo	0,05-0,08	0,2-0,4	1,1-1,5			2,0
S CrMo1	0,05-0,08	0,2-0,4	1,0-1,4	1,0	0,5	

## MECHANICAL PROPERTIES OF THE WELD METAL:

	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]		
				+20°C	0°C	-20°C
S2	420	510	24	160	120	60
S2Si	500	590	22	140	90	40
S2Mo	480	580	20		130	
S CrMo1	400	520	22	80	47	

## ADDITIONAL INFORMATION:

FLUX DENSITY	GRAIN SIZE ACC. TO DIN EN ISO 14174	CURRENT - CARRYING CAPACITY	PACKAGING
1,1 kg/dm <sub>3</sub> (lt.)	2	1000 A (DC or AC) using on wire	25 kg bags, 1 000 kg big bags

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## TAL 1720

### CLASSIFICATIONS:

EN ISO 14174 SA AB 1 67 AC H5

### DESCRIPTION:

TAL 1720 is basic agglomerated flux designer for submerg arc welding of low alloy, fine grained steel combined with following wires S1, S2, S2Si, S2Mo. Designed for welding with AC, DC current. It is suitable for the two-run or multilayer technique using single or multi wire processes. Additional advantage is the easy slag release and very low hydrogen diffusion (<4ml/100g weld).

### CHEMICAL COMPOSITION [%]:

CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	SiO <sub>2</sub> + TiO <sub>2</sub>
25%	40%	10%	20%

### BONISZEWSKI COEFFICIENT:

~ 1,8

### CHEMICAL ANALYSIS OF THE WELD METAL [%]:

	C	Si	Mn	Cr	Mo	Ni
S1	0,05-0,08	0,2-0,4	0,9-1,3			
S2	0,05-0,08	0,2-0,4	1,4-1,8			
S2Si	0,05-0,08	0,2-0,5	1,4-1,8			
S2Mo	0,04-0,08	0,2-0,4	1,3-1,7		0,5	

### MECHANICAL PROPERTIES OF THE WELD METAL:

	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]				
				0°C	-20°C	-40°C	-51°C	-73°C
S1	> 400	> 510	> 24	> 140	> 100	> 50	70	70
S2	> 420	> 500	> 22			> 90	> 60	> 47
S2Si	> 430	> 560	> 22			> 90	> 60	> 47
S2Mo	> 490	> 570	> 20	> 130	> 80	> 60	> 47	> 27

### ADDITIONAL INFORMATION:

FLUX DENSITY	GRAIN SIZE ACC. TO DIN EN ISO 14174	CURRENT - CARRYING CAPACITY	PACKAGING
1,1 kg/dm <sub>3</sub> (lt.)	2-16, 2-20	1500 A (DC or AC)	25 kg bags, 1 000 kg big bags

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# TAL 3000

## CLASSIFICATIONS:

EN ISO 14174 SA FB 1 55 AC H5

## DESCRIPTION:

TAL 3000 is high basicity agglomerated flux with low impurity levels such as phosphorus and sulphur. It is suitable for DC and AC current. As the result of low oxygen levels in the weld deposits excellent mechanical properties can be achieved. Because of the almost neutral slag reactions the chemical analysis of the weld metal can be excellently controlled by the selection of appropriate wire electrodes.

## CHEMICAL COMPOSITION [%]:

CaO + MgO	Al <sub>2</sub> O <sub>3</sub> + MnO	CaF <sub>2</sub>	SiO <sub>2</sub> + TiO <sub>2</sub>
40%	20%	25%	15%

## BONISZEWSKI COEFFICIENT:

~ 3,0

## CHEMICAL ANALYSIS OF THE WELD METAL [%]:

	C	Si	Mn	Cr	Mo	Ni
S2	0,06-0,09	0,1-0,3	0,8-1,2			
S3	0,06-0,06	0,1-0,3	1,1-1,5		0,5	
S2Mo	0,06-0,09	0,1-0,3	0,8-1,2		0,5	2,0
S2Ni2	0,06-0,09	0,1-0,3	0,8-1,2			2,5
S3Ni2,5CrMo	0,06-0,09	0,1-0,3	1,2-1,6	0,5	0,5	
S CrMo1	0,06-0,09	0,1-0,3	0,5-0,9	1,2	0,5	

## MECHANICAL PROPERTIES OF THE WELD METAL:

	Re [MPa]	Rm [MPa]	A5 [%]	KV [J]		
				-20°C	-40°C	-60°C
S2	400	490	26	130	70	60
S3	450	530	25	130	80	0
S2Mo	490	570	23	110	47	80
S2Ni2	460	550	25	140	120	
S3Ni2,5CrMo	740	820	18	90	70	
S CrMo1	420	520	22	47	130	

GRAIN SIZE ACC. TO DIN EN ISO 14174	PACKAGING	STORAGE	REDRYING RECOMMENDATION
2-20	25 kg PE - coated Aluminum bags	The flux should be stored in dry storage rooms	Redry flux at 300°C to 350°C effective flux temperature

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## SOLID WIRES

PRODUCT	TÜV	LR	ABS	DNV	BV	PRS	DB	UDT
IMT 2	+	+	+	+	+	+	+	+
IMT 2E	+						+	
IMT 3	+	+	+	+	+	+	+	+
IMT 3E	+						+	
IMT Mo	+						+	+
IMT CrMo1Si	+						+	
IMT CrMo2Si	x						x	
IMT CrMo91	x							
IMT CORTEN	+						+	
IMT NiMoCr	+						+	
IMT NiMoCr-2							+	
IMT NiMoCr-2,5							+	
IMT G2Ni2	+						x	
IMT 307 Si	+						+	
IMT 308 LSi	+						+	
IMT 309 LSi	+						+	
IMT 316 LSi	+						+	
IMT AlSi 5	+	x		x			+	
IMT AlSi 12	x	x		x			x	
IMT AlMg 5	+	x	+	x			+	
IMT AlMg4,5Mn	+	x	+	x			+	
IMT AlMg4,5MnZr	x	x		x			x	

Approvals: + obtained, x on request

## FLUX CORED WIRES

PRODUCT	TÜV	LR	ABS	DNV	BV	PRS	DB	UDT
IMT M700	+	x	+	+	+		+	
IMT M70 M	x	x	x	x	x		x	
IMT M700Ni	+		x	+			+	

Approvals: + obtained, x on request



## FLUX CORED WIRES

PRODUCT	TÜV	LR	ABS	DNV	BV	PRS	DB	UDT
IMT R711	+	X	+	+	+		+	
IMT R71 M	x	x	x	x	x		x	
IMT R71 C	x	x	x	x	x		x	
IMT R711Ni	+	x		x				
IMT R811	+	x	x	x	x		+	
IMT M CORTEN	x						x	
IMT R CrMo1	x						x	
IMT M CrMo1	x						x	
IMT R CrMo2	x						x	
IMT M CrMo2	x						x	
IMT R NiMoCr	x	x		x	x		x	
IMT M NiMoCr	x	x		x	x		x	
IMT M NiMoCr-2	x			x			x	

Approvals: + obtained, x on request

## SOLID WIRES

PRODUCT	TÜV	LR	ABS	DNV	BV	GL	DB	UDT
IMT 6	+			x			+	+
IMT 7	+						+	
IMT 8	+						+	
IMT 8 Si	+	x		+			x	
IMT 8 Mo	x						x	
IMT 8 Ni1Mo	x						x	
IMT 8 Ni2.5CrMo	+			+			x	x
IMT 9	+	+	+	+	+	+	+	+
IMT 9 Si	+						+	
IMT 9 Ni2	+			x				
IMT CrMo1	+			x			x	
IMT CrMo2	x						x	

Approvals: + obtained, x on request



**Type of spool: D200**

Precision layer spooling

Ø mm*				
0,8	0,9	1,0	1,2	1,4

\*Other diameters available after agreement



**Type of spool: K300**

Precision layer spooling

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



**Type of spool: BS300**

Precision layer spooling

Ø mm*			
0,8	1,0	1,2	1,6

\*Other diameters available after agreement



**Type of spool: K415**

Precision layer spooling

Ø mm*						
1,6	2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement



### Type of spool: C800

Precision layer spooling

Ø mm*					
2,0	2,4	3,0	3,2	4,0	5,0

\*Other diameters available after agreement



### Drum 250 kg

Precision layer spooling

Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

\*Other diameters available after agreement



### Drum 500 kg

Precision layer spooling

Ø mm*					
0,8	1,0	1,2	1,6	2,0	2,4

\*Other diameters available after agreement



### Rack System max. 1250 kg

Precision layer spooling

Ø mm*						
1,2	1,6	2,0	2,4	3,2	4,0	5,0

\*Other diameters available after agreement

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**DNV-GL**  
VERIFICATION STATEMENT  
This is to certify that the product meets the requirements of the applicable standards.  
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MULTIMET, Poland  
DNV-GL  
DNV GL is a member of the DNV Group.

WZPZwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten

UKRAJIN DOZORU TECHNICESKO  
CERTIFICATE OF APPROVAL  
ZAKRES UPRAWNIENIA  
MULTIMET Sp. z o.o.  
MULTIMET, Poland

WZPZwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten

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Zwzrostek for Schweissarbeiten  
Zwzrostek for Schweissarbeiten

Zulassungszertifikat  
Schweißnähte und Schweißverbindungen  
Hersteller: Multimet Sp. z o.o.  
Schweißnaht: 02  
Zulassungszertifikat  
Schweißnähte und Schweißverbindungen

Zulassungszertifikat  
Schweißnähte und Schweißverbindungen  
Hersteller: Multimet Sp. z o.o.  
Schweißnaht: 02  
Zulassungszertifikat  
Schweißnähte und Schweißverbindungen

TYPE APPROVAL CERTIFICATE  
MULTIMET Sp. z o.o.  
Flat-Cord Wire for Semi-Automatic or Automatic Welding with Shielding Gas  
Hersteller: Multimet Sp. z o.o.  
Schweißnaht: 02  
Zulassungszertifikat  
Schweißnähte und Schweißverbindungen

Zulassungszertifikat  
Schweißnähte und Schweißverbindungen  
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Schweißnaht: 02  
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Schweißnähte und Schweißverbindungen

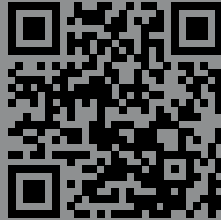
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Schweißnaht: 02  
Zulassungszertifikat  
Schweißnähte und Schweißverbindungen

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