



ISO 9001:2008



ALUMINUM SOLID WELD WIRES

MIG ER4043

ลวดเชื่อมอลูมิเนียม

ER4043 เป็นลวดเชื่อมฐานซิลิคอน สามารถใช้เชื่อมอลูมิเนียมเกรด 2014, 5052, 6061 และ 6101 ได้ ทนต่อการกัดกร่อนได้เป็นอย่างดีในน้ำเค็ม

ER4043 is a silicon alloyed aluminum weld rod great for filler 4xxx series alloys. 2014, 5052, 6061, and 6101 (in various conditions of heat treatment and 6063 sheets, plates and shapes). Offers better corrosion resistance in salt water conditions.



| Mechanical Properties | | | Weight | Price |
|-----------------------|------------------|------------|---------------|-------------------|
| Size (mm) | Tensile Strength | Elongation | | |
| 0.8 | - | - | 0.5 kg | 420.-/ม้วน |
| 1.2 | - | - | 6.0 kg | 360.-/กก. |



| CHEMICAL COMPOSITION (%) | | | | | | | |
|--------------------------|------|---------|-------|-------|-------|-------|-------|
| ELEMENT | Fe | Si | Mn | Mg | Zn | Cu | Ti |
| REQUIREMENT | ≤0.8 | 4.5~6.0 | ≤0.05 | ≤0.05 | ≤0.10 | ≤0.30 | ≤0.20 |
| ACTUAL RESULT | 0.10 | 5.1 | 0.01 | 0.003 | 0.003 | 0.03 | 0.02 |

Application :

- โครงสร้างรถบรรทุก (Truck Bodies)
- ถังแรงดัน (Pressure Vessels)
- ชิ้นส่วนยานยนต์ (Automotive Components Such as Frame and Drive Shafts)
- โครงสร้างสิ่งก่อสร้าง (Structural Members)
- ระบบไฟฟ้ารถบัส (Electrical Bus Bars)
- ท่อส่งน้ำมัน (Petroleum Distribution Equipment)

สินค้าแนะนำที่ใช้คู่กับลวดเชื่อมอลูมิเนียม ER4043 ขนาด 0.8mm 0.5 กก./ม้วน

ชุดสายเชื่อมสปูนกัน
SPOOL GUN
200A

9400.-/Pc





ISO 9001:2000
AWS A5.10 ER5356



ALUMINUM SOLID WELD WIRES

MIG ER5356

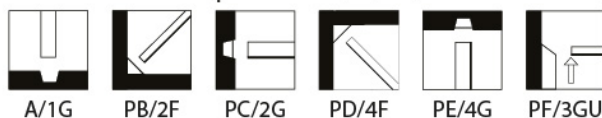
ลวดเชื่อมอลูมิเนียม

ER5356 เป็นลวดเชื่อมอลูมิเนียมฐานแมกนีเซียม
สามารถใช้เชื่อมอลูมิเนียมเกรด
5050, 5052, 5083, 5086, 5356,
5454 และ 5456 ได้ให้ ความแข็งแรง
สูงมากมีความเหนียวและต้านทาน
การกัดกร่อนได้ดี

ER5356 is a 5% magnesium aluminum weld metal recommended for general purpose welding 5050, 5052, 5083, 5086, 5356, 5454 and 5456. has high strength, ductility, toughness, fatigue and good corrosion resistance.

Welding Position :

สามารถเชื่อมได้ทุกท่าเชื่อม(All, except vertical down)



Guideline For USE :

For MIG : set machine on DC reverse polarity. Use Ar shielding gas. Make sure all contaminants such as grease and oil are removed. Hold a short arc and weld with stringer beads or a slight weave bead.

Recommended : This alloy is not recommended for elevated temperature applications (above 150°F).

Storage : Product should be stored in a dry, enclosed environment, and in its original intact packaging.



หน่วย : mm

เชื่อมได้นิ่ม และ เนียนมาก

THE BEST OF MILD AND
EXCEPTIONALLY
SMOOTH WELDS

6กก.
kg



| Mechanical Properties | | | Weight | Price |
|-----------------------|------------------|------------|---------------|------------------|
| Ø Size (mm) | Tensile Strength | Elongation | | |
| 1.2 | - | - | 0.6 kg | 450.-/กก. |

Shielding Gases (ACC.ISO 14175)

I1 Inert gas Ar (100%)
I3 Inert gas Ar+ 0.5-95% Helium mixtures
Flow rate 4.2 - 23.6L/min

CHEMICAL COMPOSITION (%) Ø1.2 mm

| ELEMENT | Fe | Si | Mn | Cr | Zn | Mg | Cu | Ti |
|---------------|------|-------|----------|----------|-------|---------|------|----------|
| REQUIREMENT | ≤0.4 | ≤0.25 | 0.05~0.2 | 0.05~0.2 | ≤0.1 | 4.5~5.5 | ≤0.1 | 0.06~0.2 |
| ACTUAL RESULT | 0.12 | 0.026 | 0.082 | 0.061 | 0.020 | 5.12 | 0.01 | 0.12 |

Application : เหมาะสำหรับใช้ในงานอุตสาหกรรม • อุตสาหกรรมโครงสร้างการต่อเรือ • อลูมิเนียมหล่อ และเสื่อสับเครื่องยนต์
• ฝาสูบ • ท่อหรือเฟรม • อุตสาหกรรมเฟรมจักรยาน ยานยนต์ รถบัส หรือรถพ่วง • อุตสาหกรรมรางรถไฟ

This alloy is commonly used in the construction industry in • Structural Frames in The Shipbuilding Industry. • Cts and Housings.
• Cylinder Heads. • Pipes and Frames. • Bicycle, Automotive, Bus and Trailer Industry tructural Frames. • Railway Industry.

TYPICAL GMAW (MIG) WELDING PROCEDURES : DCEP 100% Ar

| Wire Diameter | Amps | Volts | Travel Speed (ipm) | Argon (cfh) |
|-----------------|-----------|---------|--------------------|-------------|
| 0.8 mm | 60 - 175 | 15 - 24 | 25 - 45 | 25 - 30 |
| 0.9 mm | 70 - 185 | 15 - 27 | 25 - 40 | 30 - 35 |
| ▶ 1.2 mm | 125 - 260 | 20 - 29 | 24 - 35 | 35 - 45 |
| 1.6 mm | 170 - 300 | 24 - 30 | 28 - 38 | 45 - 55 |
| 2.4 mm | 275 - 400 | 26 - 31 | 14 - 20 | 60 - 75 |

▶ = มีสินค้า

WARNING

PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can KILL. • Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs) , and your employer's safety practices. • Keep your head out of fumes. • Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. • Wear correct eye, ear, and body protection. • Do not touch live electrical parts.





ER70S-6

CO₂ WELDING WIRE

ISO 9001:2015 WG ER50-6 ISO14341-A - G 42 3 C1 3Si1 CE

STABLE ARC WITH LOW FEEDING FORCE & EXTREMELY LOW OVERALL SPATTER

BENEFITS :

- Consistent welding performance
- Stable arc with low feeding force
- Excellent arc ignition
- High current applicability
- Extremely low overall spatter
- Low fume emission
- Trouble-free feed ability, even at high wire feed speeds and lengthy feed distances

WELDING POSITIONS



A/1G



PD/4F



PC/2G



PE/4G



A general purpose of welding wire with copper coated for long contact tip life is provides superior feeding and arc stability design for fabrication of mild steel. Contains higher levels of manganese and silicon than the other standard grades of MIG wire, provide high deoxidizers to heavy mill scale surfaces that provide better wetting, yielding a flatter bead shape and the capability of faster travel speeds. Usually used with 75/25 (Argon/CO₂) shielding gas or higher contents of Argon, such as 90/10. Can also be used with 100% CO₂. Conforms to AWS A5.18 **ER70S-6**.

APPLICATIONS : SUMO ER70S-6 It is a great choice for welding light to moderately scaled, oily or rusty plates. It can also be recommended for spray transfer arc welding applications. Used for butt and fillet welding of sheet and plate of a variety of thickness. Applications included general carbon steel fabrication.

STORAGE :

Product should be stored in a dry, enclosed environment, and in its original intact packaging.

Chemical Composition (%) - 1KG

| Element | C | Si | Mn | S | P | Cr | Ni | Mo | V | Cu |
|-----------------------|------------------|----------------|-------------|--------------|-------------------|------------|--------|--------|--------|-------|
| Requirement | 0.06-0.15 | 0.8-1.15 | 1.4-1.85 | ≤ 0.035 | ≤ 0.025 | ≤ 0.15 | ≤ 0.15 | ≤ 0.15 | ≤ 0.03 | ≤ 0.5 |
| Actual Result | 0.06 | 0.9 | 1.51 | 0.016 | 0.012 | 0.013 | 0.005 | 0.002 | 0.002 | 0.13 |
| Mechanical Properties | | | | | Soundness Test | | | | | |
| | Tensile Strength | Yield Strength | Elongation% | Test Temp °C | Absorbed Energy J | II | | | | |
| Requirement | ≥ 480 | ≥ 400 | ≥ 22 | -30 | ≥ 27 | | | | | |
| Sample Test | 545 | 432 | 30 | -30 | 86 94 90 | | | | | |
| | | | | | | Acceptable | | | | |

Chemical Composition (%) - 5 / 15KG

| Element | C | Si | Mn | S | P | Cr | Ni | Mo | V | Cu |
|-----------------------|------------------|----------------|--------------|--------------|-------------------|------------|--------|--------|--------|--------|
| Requirement | 0.06-0.15 | 0.80-1.15 | 1.40-1.85 | ≤ 0.035 | ≤ 0.025 | ≤ 0.15 | ≤ 0.15 | ≤ 0.15 | ≤ 0.03 | ≤ 0.50 |
| Actual Result | 0.074 | 0.91 | 1.48 | 0.010 | 0.017 | 0.015 | 0.017 | 0.011 | 0.007 | 0.036 |
| Mechanical Properties | | | | | Soundness Test | | | | | |
| | Tensile Strength | Yield Strength | Elongation % | Test Temp °C | Absorbed Energy J | II | | | | |
| Requirement | ≥ 480 | ≥ 400 | ≥ 22.0 | -30 | ≥ 27 | | | | | |
| Sample Test | 546 | 449 | 27.0 | -30 | 71 91 73 | | | | | |
| | | | | | | Acceptable | | | | |

| ขนาด Size (mm) | น้ำหนัก Weight (kg) | ราคา (Price) |
|-------------------|------------------------|-----------------|
| ● 0.8 | 1 | 105.- /kg |
| ▶ 0.8 | 5 | 70.- /kg |
| ▶ 0.8 | 15 | 60.- /kg |
| ▶ 0.9 | 15 | 60.- /kg |
| ▶ 1.0 | 15 | 58.- /kg |
| ▶ 1.2 | 15 | 57.- /kg |
| ● 1.2 | 250 | XX.- /kg |

SHIELDING GAS :

100% CO₂
75-95% Argon / Balance CO₂
95-98% Argon / Balance O₂
Flow Rate : 30-50 CFH

GUIDELINE FOR USE :

Oil stains and rust must be removed from surface of weldment prior to welding in accordance with appropriate welding standards.

● กำลังจะเข้า ▶ มีสินค้า



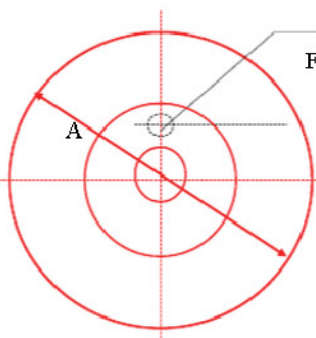
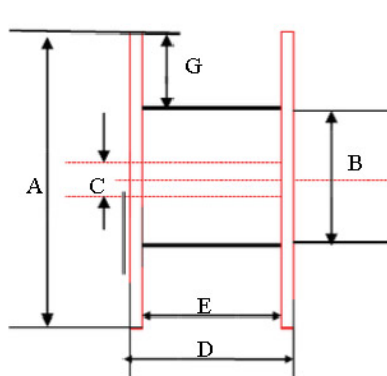
ER70S-6

CO₂ WELDING WIRE

ISO 9001:2015 WG ER50-6 ISO14341-A - G 42 3 C1 3Si1 CE

**STABLE ARC WITH LOW FEEDING FORCE
& EXTREMELY LOW OVERALL SPATTER**

Factory control standard For Plastic Spool precision layer winding CO₂ wire

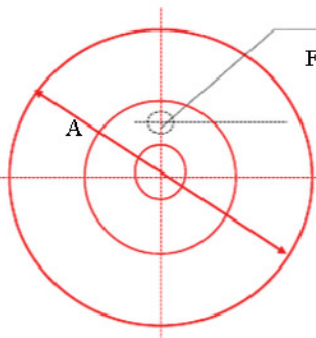
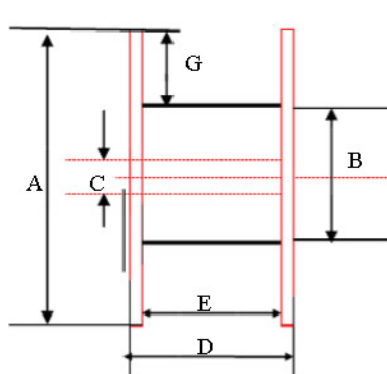


D100 (Black)

Main parameter

1kg

| | | |
|---|--------|--------------------|
| 1 | C | 16 +0.5mm |
| 2 | A | 100 +5mm |
| 4 | B | 45 +2mm -2mm |
| 5 | G | 28.5 +0.5mm -0.5mm |
| 6 | D | 42 +1.5mm -1.5mm |
| 7 | E | 38 +1mm -1mm |
| 8 | Weight | 53 +5g -5g |

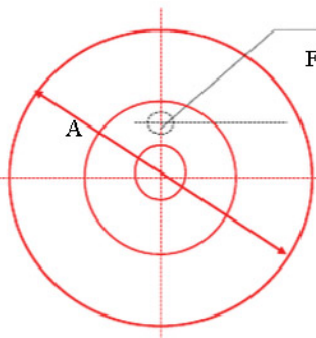
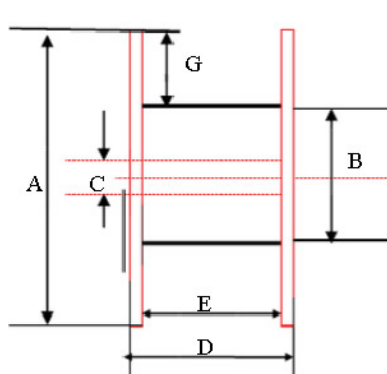


D200 (Black)

Main parameter

5kg

| | | |
|---|--------|--------------------|
| 1 | C | 50.5 +2.5mm |
| 2 | A | 200 +5mm |
| 4 | B | 95 +2mm -2mm |
| 5 | G | 44.5 +0.5mm -0.5mm |
| 6 | F | 11 +1mm |
| 7 | D | 56 +1.5mm -1.5mm |
| 8 | E | 46 +1mm -1mm |
| 9 | Weight | 260 +10g -10g |



D270 (Black)

Main parameter

15kg

| | | |
|---|--------|------------------|
| 1 | C | 50.5 +2.5mm |
| 2 | A | 270 +5mm |
| 4 | B | 138 +2mm -2mm |
| 5 | G | 60 +0.5mm -0.5mm |
| 6 | F | 11 +1mm |
| 7 | D | 102 -3mm |
| 8 | E | 90 +1mm -1mm |
| 9 | Weight | 680 +10g -10g |



GASLESS FLUX CORED WELDING WIRE

AWS E71T-GS

ลวดเชื่อมมิกฟลักซ์คอร์

ไม่ใช้แก๊ส

ใช้ได้กับงานเชื่อมเหล็กทุกชนิด



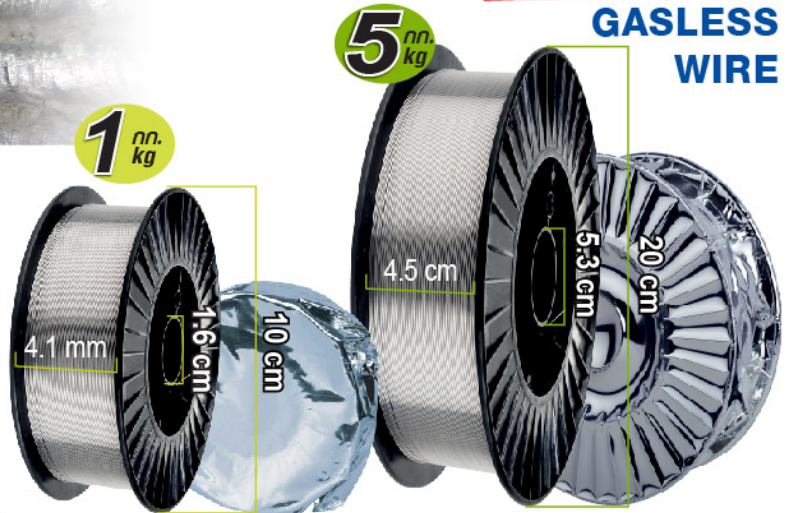
- ลวดเชื่อมแบบไม่ใช้แก๊ส FLUX CORE 0.8 mm, 1.0 mm E71T-GS SUMO
- เป็นลวดเชื่อมที่ไม่มีการสึกหรอเป็นเชื้อเพลิงชั้นพื้นฐานที่ออกแบบมาสำหรับการเชื่อมตำแหน่งเหล็กอ่อนในทุกตำแหน่งที่ต้องการ
- ความแข็งแรงระดับปานกลางและ
- ความเหนียวที่ดีมาก
- ไม่ใช้แก๊ส GASLESS WIRE

มีสินค้า

| Mechanical Properties | | | QTY Spool / Box | Weight | Price |
|-----------------------|------------------|------------|--------------------|--------|-----------|
| Size (mm) | Tensile Strength | Elongation | | | |
| ▶ Ø0.8 | - | - | 1 | 1 kg | 188.-/กก. |
| ▶ Ø0.8 | - | - | 1 | 5 kg | 180.-/กก. |
| ▶ Ø1.0 | - | - | 1 | 1 kg | 180.-/กก. |
| ▶ Ø1.0 | - | - | 1 | 5 kg | 160.-/กก. |

Reference Current (DC+)

| Wire Diameter | Amps |
|---------------|--------|
| Ø0.8 mm | 70-120 |
| Ø1.0 mm | 80-180 |



SUGGESTION :

Storage product should be stored in a dry, enclosed environment, and in its original intact packaging.

CHARACTERISTIC :

This kind of wire is 1kg, 5kg self protective flux cored wire.

SUITABLE :

For all position. When welding, the spatter is smaller, the arc is stable and soft, slag removal is easy and the forming is beautiful.



| | | | | | | | | | |
|--|---|-----------|----------------|--------|------------------------------------|-------------------------|---|-------------------|-------------------------|
| Trade Name | E71T-GS | Size (mm) | 0.8 mm | 1.0 mm | Production Batch | | | | DATE : |
| Executive Standard | GB/T10045-2001 E501T-GS (AWS A5.20 E71T-GS) | | | | | Quantities | 1 KG | 5 KG | |
| Chemical Composition (%) Ø0.8 mm , Ø1.0 mm | | | | | Mechanical Properties of Deposited | | | | |
| C | Mn | Si | P | S | Al | Tensile Strength MPa | Yield Strength MPa | Longation &(%) | Impact Energy -20 °C |
| 0.12 | 0.89 | 0.32 | 0.012 | 0.009 | 1.23 | 540 | 476 | 27 | 110/107/112 |
| Examination Clerk | | | Quality Leader | | | | This certificate is invalid without seal of quality control department. | | |



ELECTRIC SHOCK CAN KILL :

- Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood.
- Wear dry, hole-free gloves. (Change as necessary to keep dry.)
- Do not touch electrically "hot" parts or electrode with bare skin or wet clothing.
- If wet area and welder cannot be insulated from workpiece with dry insulation, use a semiautomatic, constant-voltage welder or stick welder with voltage reducing device.
- Keep electrode holder and cable insulation in good condition. Do not use if insulation damaged or missing.



WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION :

- Do not weld on containers which have held combustible materials (unless strict AWS F4.1 procedures are followed). Check before welding.
- Remove flammable materials from welding area or shield from sparks, heat.
- Keep a fire watch in area during and after welding. • Keep a fire extinguisher in the welding area.
- Wear fire retardant clothing and hat. Use earplugs when welding overhead.



ARC RAYS CAN BURN EYES AND SKIN :

- Select a filter lens which is comfortable for you while welding.
- Always use helmet when welding. • Provide non-flammable shielding to protect others. • Wear clothing which protects skin while welding.



FUMES AND GASES CAN BE DANGEROUS :

- Use ventilation or exhaust to keep air breathing zone clear, comfortable.
- Use helmet and positioning of head to minimize fume in breathing zone.
- Read warnings on electrode container and material safety data sheet (MSDS) for electrode.
- Provide additional ventilation/exhaust where special ventilation requirements exist.
- Use special care when welding in a confined area.
- Do not weld unless ventilation is adequate.

CONFINED SPACE :

- Carefully evaluate adequacy of ventilation especially where electrode requires special ventilation or where gas may displace breathing air.
- If basic electric shock precautions cannot be followed to insulate welder from work and electrode, use semiautomatic, constant-voltage equipment with cold electrode or stick welder with voltage reducing device.
- Provide welder helper and method of welder retrieval from outside enclosure.

WELDING POSITIONS





ISO 9001:2005



FLUX CORED WELDING WIRE

AWS E71T-1**ลวดเชื่อมฟลักซ์คอร์****15 กก.**
kg

SHIELDING GAS

100% CO₂ shielding gas.

ลวดเชื่อมฟลักซ์คอร์ 1.2 mm E71T-1 เป็นลวดเชื่อมที่มี ฟลักซ์คอร์ อยู่ในแกนกลางของลวดเชื่อม เหมาะสำหรับงานเชื่อมต่อเรือ ชิ้นส่วนรถยนต์ หรืออุตสาหกรรมที่มีขนาดใหญ่

Sumo AWS E71T-1

Is a flux-cored welding wire basic-rutile designed for all position welding of mild steel in applications requiring moderate levels strength and very good toughness. Impact values of weld metal are good.

APPLICATIONS

All position welding of machinery, shipbuilding, bridges, offshore structures, Structural fabrication.

ADVANTAGE

- Excellent mechanical properties.
- Slag system provides for puddle support, good wetting, and bead shape in all position.
- Arc action and metal transfer are smooth.
- Slag removal is easily achieved with hand tools.
- One sided welding is possible with ceramic backing and will produce excellent results.
- Applications include those in general fabrication, Ship or barge construction, building or bridge erection, and off-shore industries.
- Manufactured under a quality system certified to ISO 9001 requirements.

▶ มลิลินคำ

| Mechanical Properties | | | QTY | Weight | Price |
|-----------------------|------------------|------------|-------------|--------|-----------|
| Size (mm) | Tensile Strength | Elongation | Spool / Box | | |
| ▶ Ø1.2 | - | - | 1 | 15 kg | 110.-/กก. |



Reference Current (DC+)

| Wire Diameter | Amps |
|---------------|----------|
| Ø1.2 mm | 160-320A |

SUGGESTION :

Product should be stored in a dry, enclosed environment, and in its original intact packaging.



ข้อแนะนำ : ผลิตภัณฑ์ควรเก็บไว้ในที่แห้ง

| | | | | | | | | |
|----------------------------------|--|-----------|---|------------------------------------|-------------------------|-----------------------|-------------------|-------------------------|
| Trade Name | E71T-1 | Size (mm) | 1.2 mm | Production Batch | | DATE : | | |
| Executive Standard | GB/T10045-2001 E501T-1 (AWS A5.20 E71T-1C) | | | | Quantities : 15 kg | | | |
| Chemical Composition (%) Ø1.2 mm | | | | Mechanical Properties of Deposited | | | | |
| C | Mn | Si | P | S | Tensile Strength MPa | Yield Strength MPa | Longation &(%) | Impact Energy -20 °C |
| 0.06 | 1.44 | 0.41 | 0.012 | 0.009 | 557 | 485 | 27 | 110/107/112 |
| Examination Clerk | Quality Leader | | This certificate is invalid without seal of quality control department. | | | | | |



ELECTRIC SHOCK CAN KILL :

- Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood.
- Wear dry, hole-free gloves. (Change as necessary to keep dry.)
- Do not touch electrically "hot" parts or electrode with bare skin or wet clothing.
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- Provide additional ventilation/exhaust where special ventilation requirements exist.
- Use special care when welding in a confined area.
- Do not weld unless ventilation is adequate.

CONFINED SPACE :

- Carefully evaluate adequacy of ventilation especially where electrode requires special ventilation or where gas may displace breathing air.
- If basic electric shock precautions cannot be followed to insulate welder from work and electrode, use semiautomatic, constant-voltage equipment with cold electrode or stick welder with voltage reducing device.
- Provide welder helper and method of welder retrieval from outside enclosure.

WELDING POSITIONS





EN17632 ⚓
CE 0035-CPD-C742-15



FLUX CORE WELDING WIRES

MIG E71T-1C

ลวดเชื่อมฟลักซ์คอร์

15 กก.
kg

SHIELDING GAS

100% CO₂ shielding gas.

แนวเชื่อมมันเงา อาร์คได้นิ่ม สะเก็ดไฟน้อย

Sumo E71T-1C

is a flux-cored welding wire basic-rutile designed for all position welding of mild steel in applications requiring moderate levels strength and very good toughness. Impact values of weld metal are good.

APPLICATIONS

All position welding of machinery, shipbuilding, bridges, offshore structures, Structural fabrication.

CONFORMANCE

ISO 9001:2000
AWS A5.20 E71T-1C

ADVANTAGE

- Excellent mechanical properties.
- Slag system provides for puddle support, good wetting, and bead shape in all position.
- Arc action and metal transfer are smooth.
- Slag removal is easily achieved with hand tools.
- One sided welding is possible with ceramic backing and will produce excellent results.
- Applications include those in general fabrication, Ship or barge construction, building or bridge erection, and off-shore industries.
- Manufactured under a quality system certified to ISO 9001 requirements.

▶ มีสินค้า

| Mechanical Properties | | | QTY | Weight | Price |
|-----------------------|------------------|------------|-------------|--------|-----------|
| Size (mm) | Tensile Strength | Elongation | Spool / Box | | |
| ▶ Ø1.2 | - | - | 1 | 15 kg | 140.-/กก. |



Reference Current (DC+)

| Wire Diameter | Amps |
|---------------|----------|
| Ø1.6 mm | 180-450A |
| Ø1.2 mm | 120-300A |

SUGGESTION :

Product should be stored in a dry, enclosed environment, and in its original intact packaging.

APPROVALS

| | | |
|------|---|-----------|
| CCS | : | 3YSH10 |
| LR | : | 3YSH10 |
| GL | : | 3YH5S |
| ABS | : | 3YSAH10 |
| DNV | : | IIISH10 |
| BV | : | SA3YMH10 |
| NK | : | KSW53GH10 |
| RINA | : | 3YSAH10 |

ข้อแนะนำ : ผลิตภัณฑ์ควรเก็บไว้ในที่แห้ง

CHEMICAL COMPOSITION (%) Ø1.2mm

| ELEMENT | C | Mn | Si | S | P | Cr | Ni | Mo | V | Cu |
|---------------|-------|-------|-------|--------|-------|----|----|----|---|----|
| REQUIREMENT | ≤0.12 | ≤1.75 | ≤0.90 | ≤0.03 | ≤0.03 | - | - | - | - | - |
| ACTUAL RESULT | 0.048 | 1.22 | 0.38 | 0.0038 | 0.012 | - | - | - | - | - |

Mechanical Properties

| | Tensile Strength MPa | Yield Strength MPa | Elongation (%) | Impact Temp (°C) | Impact Value (J) |
|----------------|-------------------------|-----------------------|----------------|------------------|------------------|
| Requirement | ≥490 | ≥400 | ≥22 | -20 | ≥47 |
| Real Parameter | 529 | 462 | 26 | -20 | 54 63 119 |

WELDING POSITIONS



⚠ WARNING

PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can KILL.
• Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices. • Keep your head out of fumes. • Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. • Wear correct eye, ear, and body protection. • Do not touch live electrical parts.



ลวดเชื่อมสแตนเลส

STAINLESS STEEL WIRE

MIG ER308LSi

12.5^{mm}
kg



ใช้แก๊ส
100% CO₂
shielding gas.

Shielding Gas

• 100% CO₂

• 90% Helium / 7-1/2% Argon / 2-1/2% CO₂

MIG ER308LSi สำหรับงานเชื่อมสแตนเลสเกรด 304 และ 304L หรือสแตนเลสทั่วไปในกลุ่ม Austenitic ที่จะนิยมเรียกกันว่า "18-8" มีคุณสมบัติดีกว่า ER308L เนื่องจากมีส่วนผสมของซิลิกอน จึงทำให้การเชื่อมมีประสิทธิภาพดีกว่ามีลักษณะการไหลของน้ำโลหะได้ดีแนวเชื่อมซึมลึกเชื่อมได้นิ่มและเรียบเหมาะกับการใช้งานที่ต้องการแนวเชื่อมที่สวยงามพร้อมทั้งทนต่อการกัดกร่อนได้ดีเยี่ยม

ER308LSi is designed for joining type 304 and 304L stainless steels and other common austenitic stainless steels referred to as "18-8" steels. It has the same analysis as ER308L but with higher silicon content. The higher silicon content improves arc stability, bead appearance and wetting action. ER308LSi produces exceptionally smooth welds for applications that require a good cosmetic appearance and excellent corrosion resistance.

| Type | Mechanical Properties | | | Weight | Price |
|------------|-----------------------|-----------------------------|------------|---------|------------------|
| | Size (mm) | Tensile Strength | Elongation | | |
| MIG (Wire) | 0.8 | - | - | 12.5 kg | 385.-/กก. |
| | 0.9 | 1350-1450 N/mm ² | 2% | 12.5 kg | 375.-/กก. |
| | 1.2 | 1250-1350 N/mm ² | 3% | 12.5 kg | 370.-/กก. |

| Certificate of Quality For Welding Electrode | | | | |
|--|---------------|-----------|----------------------|--|
| Name of Commodity : Welding Wire | | | Cer No.: TW23E0130E | |
| Trade name | Diameter (mm) | Batch No. | Application Standard | |
| MIG ER308LSi | 0.8mm | 2.30E+07 | AWS A5.9 ER308LSi | |

| Chemical Composition of Deposited Metal (%) Ø0.8, Ø1.2 mm | | | | | | | | | |
|---|-------|-----------|-----------|-------|--------|------------|-------------|-------|-------|
| Test item | C | Si | Mn | S | P | Ni | Cr | Mo | Cu |
| Standard | ≤0.03 | 0.65-1.00 | 1.00-2.50 | ≤0.02 | ≤0.025 | 9.00-11.00 | 19.50-22.00 | ≤0.75 | ≤0.75 |
| Actual Result | 0.022 | 0.83 | 1.87 | 0.008 | 0.018 | 9.73 | 19.96 | 0.01 | 0.02 |

| Mechanical Properties of Deposited Metal | | | | | | | |
|--|---------------------------------|-----------------------|----------------|---------------------|--------------------------|-------|--------------------------------------|
| Test item | Tensile Test Of Deposited Metal | | | V-Notch Impact Test | | | |
| | Tensile strength Rm (MPa) | Yield point ReL (MPa) | Elongation (%) | Impact Temp (°C) | Impact value Average (J) | X-Ray | Diffusion hydrogen content (ml/100g) |
| Standard | ≥510 | - | ≥25 | - | - | I | - |
| Actual Result | 600 | - | 45 | - | - | I | - |

| CHEMICAL COMPOSITION (%) Ø0.9 mm | | | | | | | | | | | | |
|----------------------------------|------------------------|----------------|---------------|-------|-----------|-----------|--------|--------|------------|-------------|-------|-------|
| ELEMENT | Tensile Strength (MPa) | Elongation (%) | ELEMENT | C | Si | Mn | P | S | Ni | Cr | Mo | Cu |
| REQUIREMENT | ≤520 | ≤35 | REQUIREMENT | ≤0.3 | 0.65-1.00 | 1.00-2.50 | ≤0.030 | ≤0.030 | 9.00-11.00 | 19.50-22.00 | ≤0.75 | ≤0.75 |
| ACTUAL RESULT | 594 | 45 | ACTUAL RESULT | 0.016 | 0.86 | 1.94 | 0.017 | 0.013 | 9.73 | 19.98 | 0.010 | 0.010 |

Advantage

- Excellent operator appeal-great weld puddle fluidity and bead shape.
- Superior corrosion and crack resistance.
- ISO 9001 certified-manufactured to standards for environmental and quality management systems.

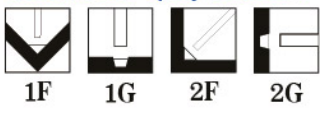
Key Features

- High silicon level for increased puddle fluidity and toe wetting.
- Proprietary surface lubricant for steady feeding and arc stability.
- Versatile electrode designed to weld CrNi austenitic stainless steels.
- Controlled ferrite content for maximum corrosion resistance.

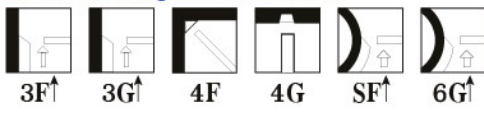
Application :

Welding Positions

Globular and Spray Transfer :



Short Circuiting and Pulsed Arc :



การใช้งาน

เหมาะกับการงานอุตสาหกรรมต่อเรือ ยานยนต์ เครื่องจักรในอุตสาหกรรมอาหาร ยา และเครื่องใช้ไฟฟ้า

Application: Ship building, automobile, electric power food medicine machinery manufacturing.

วิธีใช้ : สำหรับเชื่อมสแตนเลส

ข้อแนะนำ :

เลือกลวดเชื่อมให้เหมาะกับชิ้นงาน

WARNING

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คำเตือน: สวมอุปกรณ์ป้องกันทุกครั้ง



AWS E308LT1-1
AWS A5.22 E308LT1-1
GB/T 17853 TS 308L-FC11
JIS Z3323 YF308LC
EN ISO 17633-B TS308L-FB1



ลวดเชื่อมฟลักซ์คอร์สแตนเลส FLUX CORE STAINLESS STEEL WIRE **MIG E308L**

MIG 308L สำหรับงานเชื่อมสแตนเลส
มีคุณสมบัติในการป้องกันการกัดกร่อน
ไม่มีรูอากาศ เหมาะสำหรับงานเชื่อม
ที่ต้องการคุณภาพสูงและผ่านการ
X-Ray ได้ดี เช่น งานเชื่อมท่อน้ำมัน
ถึงน้ำมันงานอุตสาหกรรมการต่อเรือ

MIG 308L for stainless steel welding
Has anti-corrosion properties, no air holes,
suitable for welding work that Need high
quality and pass X-Ray well, such as welding
of oil pipes, oil tanks, shipbuilding industry.

Features

- Easy to control, able to welding at any position.
- Has anti-corrosion properties.

Key Features

- X-ray quality welds and good penetration.
- Excellent slag removal.
- Provides excellent weldability and crack resistance.

Shielding Gas

- 100% CO₂
- 75% Argon 25% CO₂



| Type | Size (mm) | Weight | Price |
|------------|------------|----------------|------------------|
| MIG (Wire) | 1.2 | 12.5 kg | 520.-/กก. |

| Specification & Classification | GB/T17853 TS 308L-FC11 AWS A5.22 E308LT1-1 | | | | Commodity | MIG 308L | Dimension | 1.2 mm | |
|--|---|----------------------|--------------|---------------------|---------------------|----------------|---------------------------|---------------------------|--------------------|
| (%) CHEMICAL COMPOSITION OF DEPOSITED METAL Ø1.2 mm | | | | | | | | | |
| Elements | C | Mn | Si | S | P | Cr | Ni | Mo | Cu |
| Requirement | ≤0.04 | 0.5-2.5 | ≤1.0 | ≤0.03 | ≤0.04 | 18.0-21.0 | 9.0-11.0 | ≤0.5 | ≤0.5 |
| Actual Result | 0.026 | 1.110 | 0.6 | 0.005 | 0.013 | 19.960 | 9.66 | 0.02 | 0.01 |
| Mechanical Property of Deposited Metal | Yield Strength Mpa | Tensile Strength Mpa | Elongation % | Reduction of Area % | Test Temperature °C | Ave. Energy J | BENDING TEST ACCORDING TO | RADIOGRAPHIC ACCORDING TO | FILET WEIDING TEST |
| Requirement | – | ≥520 | ≥35 | – | – | – | – | II | – |
| Actual Result | – | 610 | 42 | – | – | – | | I | |
| SHIELDING GAS | | CURRENT (A) | VOLTAGE (V) | POLARITY | PREHEAT | INTERPASS (°C) | | WS (MM/MIN) | |
| CO2 | | 130-260 | 26-32 | DCEP | – | 16~150 | | 300-400 | |
| We hereby certify that this report is correct and that all test results are in compliance with the specification described herein. | | | | | Inspection Stamp | | Manager of QA | | Remarks |

Welding Positions

Globular and Spray Transfer :



Short Circuiting and Pulsed Arc :



WARNING



คำเตือน : สวมอุปกรณ์ป้องกันทุกครั้ง

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