



Welding
Alloys
Group



ACTING GLOBAL
WELDING LOCAL

WA Electrodes

Joining, Cladding, Hardfacing, Repair

Product Selection

The go-to provider of advanced welding consumables

Welding Alloys Group is an international manufacturer of top quality welding consumables. This catalogue presents a selection of covered and tubular electrodes for joining, hardfacing and repair applications. Don't hesitate to contact us for any specific enquiries.



Packaging

- 3 boxes per carton
Standard weight per box (depending on type and diameter):
- Covered electrodes - 4 kg to 6.5 kg
 - 1 kg box available on request
 - Tubular electrodes - 5 kg

Welding of constructional steels

Product name	ASME/AWS Standard	Main features
Mild steels		
SPEEDARC 7016-E	E7016	Basic, double coated, for repair, rebuilding
High strength steels		
SPEEDARC HLE 700-E	E11018-M	Basic, for high impact strength, rebuilding

Welding of highly alloyed steels

Product name	ASME/AWS Standard	Main features
Duplex and Super Duplex		
TETRA 22 9 3L-E	E2209-17	Rutile, duplex steels and dissimilar assemblies
TETRA B D57L-E	E2594-15	Basic, joining of super duplex steels
Austenitic stainless steels		
TETRA 308L-E	E308L-16	Type 308L, rutile
TETRA 347-E	E347-17	Type 347
TETRA 316L-E	E316L-16	Type 316L, rutile
TETRA 904L-E	E385-16	Type 385, rutile
Heat resistant steels		
TETRA 310-E	~E310-16	Type 310, rutile
Dissimilar joints & repair		
TETRA 307-E	~E307-16	Modified type 307, rutile
TETRA 309L-E	E309L-16	Type 309L, rutile
TETRA 309LMo-E	E309Mo-17	Type 309LMo for joining dissimilar metals
TETRA 312-E	~E312-16	Type 312, exceptional cracking resistance

Nickel alloys for joining, cladding and repair

Product name	ASME/AWS Standard	Main features
GAMMA 182HL-E	ENiCrFe-3	Alloy 600, for repair, high recovery
GAMMA 182-E	ENiCrFe-3	Alloy 600, alloyed core wire for fabrication
GAMMA 625-E	ENiCrMo-3	625 type alloy
GAMMA 276-E	ENiCrMo-4	276 type alloy

Welding of cast irons

Product name	EN ISO Standard	Main features
FONTE Ni-E	ENi-CI	Pure Nickel
FONTE BI NiFe-E	ENiFe-CI	Bimetal, repair & dissimilar joints

-E: covered electrodes -TE: tubular electrodes

Work-hardening manganese alloys

Product name	Hardness	EN 14700 Standard	Main features
HARDFACE AP-E	240 HB / 48 HRC (WH)	E Fe9	High rate of work-hardening, high impact, railway

Hardfacing - Heat treated steels for Tooling

Product name	Hardness	EN 14700 Standard	Main features
ROBOTOOL 46-E	44 HRC	T ZFe8	Hot and cold working tools
HARDFACE AR-E	60 HRC	T Fe4	High speed steel, cold cutting applications
HARDFACE DCO-E	47 HRC	T ZFe3	Similar performance to cobalt base alloys

Hardfacing - Medium alloyed and anti-abrasion

Product name	Hardness	EN 14700 Standard	Main features
Medium alloyed			
HARDFACE L-E	58 HRC	E Fe8	Abrasion, impact, cutting properties
Anti abrasion - low impact			
HARDFACE HCNB-E	64 HRC	E Fe15	Ultra-hard single layer - pure abrasion, 230%
Anti abrasion - moderate impact			
HARDFACE HC-E	61 HRC	E Fe15	Cr carbide deposit, high recovery 190%
HARDFACE HC-TE	61 HRC	T Fe15	Cr carbide deposit - tubular*
HARDFACE CN-E	63 HRC	E Fe15	For fine abrasive particles of high hardness
HARDFACE CNV-E	65 HRC	E Fe16	High resistance to abrasion and impact at high temperatures
HARDFACE ZUCAR-E	61 HRC	~E Fe15	Arcing of sugar mill rolls, 200% recovery
HARDFACE STEELCARBW45-TE	65 HRC	T Fe20	45% Tungsten carbides for extreme abrasion - tubular*

Hardfacing - Cobalt base

Product name	Hardness	EN 14700 Standard	Main features
STELLOY 25-E	210 HB / 40 HRC (WH)	-	High temperature and metal-to-metal abrasion
STELLOY 21-E	33 HRC / 47 HRC (WH)	E CoCr-E	Ideal choice for multiple combinations of stresses
STELLOY 6 -E	42 HRC	E CoCr-A	Combines all properties of Co base alloys

Others

Product name	Main features
GROOVALLOY-E	For bevelling, grooving and gouging

*Tubular electrodes

- Less dilution
- Higher productivity
- Easy to weld
- No moisture pick-up



Our Technical 'Spark' Solves Your Industrial Challenges



WA Consumables

The go-to provider of advanced welding consumables



WA Machines

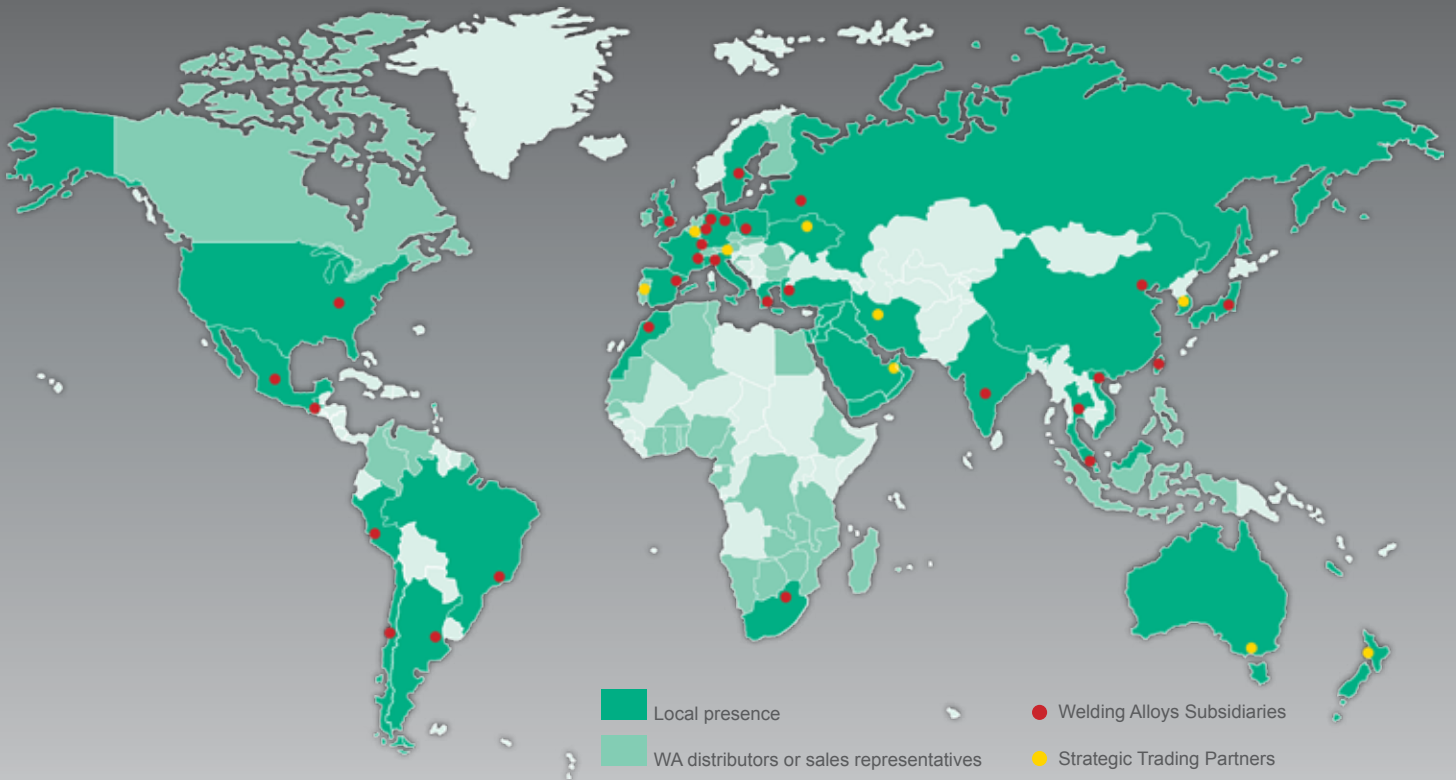
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