

## MMA elektrody pro svařování Cr-Mo ocelí / MMA Electrodes for Chromium-Molybdenum steels

Obchodní značení přídavného materiálu Product Name	Označení norem / Standards Klasifikace / Classification				Chemická analýza / Chemical Analysis - typical values [%]						
	EN / EN ISO		AWS		C	Si	Mn	Cr	Ni	Mo	další
MOLYCORD Ti	3580-A	E Mo R 12	A5.5	E 8013-G	0.08	0.3	0.6			0.5	P≤0.025 S≤0.025
MOLYCORD Kb	3580-A	E Mo B 42 H5	A5.5	E 7018-A1 H4	0.06	0.4	1			0.6	P≤0.020 S≤0.015
OE-KV2HR	1599	E Mo B 32 H5	A5.5	E7018-A1H4R	0.08	0.45	0.8			0.53	P≤0.015 S≤0.015
CROMOCORD 55	3580-A	E CrMo0.5 B 12 H5	A5.5	E 8018-B1	0.05	0.4	0.7	0.55		0.5	P≤0.025 S≤0.020
CROMOCORD KB	3580-A	E CrMo1 B 42 H5	A5.5	E 8018-B2 H4	0.07	0.3	0.7	1.2		0.55	P≤0.012 S≤0.010
OE-KV5L	1599	E CrMo1L B 22 H5	A5.5	E 7015-B2L	0.04	0.27	0.7	1.25		0.5	P≤0.015 S≤0.015
OE-KV5HR	1599	E CrMo1 B 32 H5	A5.5	E8018-B2 H4R	0.08	0.25	0.75	1.25		0.5	P≤0.01 S≤0.01
CROMOCORD 2 STC	3580-A	E CrMo 2 B 42 H5	A5.5	E 9018-B3 H4	0.09	0.3	0.5	2.4		1	P≤0.012 S≤0.010
OE-KV3L	1599	E CrMo2L B 22 H5	A5.5	E 8015-B3LH4	0.04	0.35	0.75	2.25		1	P≤0.020 S≤0.015
OE-KV3HR	1599	E CrMo2 B 32 H5	A5.5	E 9018-B3H4R	0.1	0.3	0.75	2.25		1	P≤0.01 S≤0.01
CROMO E225	3580-A	E CrMo2 B 22 H5	A5.5	E 9015-B3 H4	0.1	0.25	0.7	2.3		1.1	P≤0.01 S≤0.01
CROMO E225V	3580-A	E Z CrMoV 2 B 22 H5	A5.5	E 9015-G	0.09	0.2	0.6	2.3		1	P≤0.01 S≤0.01 Nb 0.02 V 0.25
CROMOCORD E223			A5.5	E 8015-G	0.04	0.3	0.5	2	0.5		P≤0.01 S≤0.01 W 1.5 V 0.25
CROMOCORD 5L	1599	E CrMo5 B 22 H5	A5.5	E 8015-B6L	0.04	0.4	0.75	5		0.5	P≤0.015 S≤0.015
CROMOCORD 5	3580-A	E CrMo5 B 22 H5	A5.5	E 8015-B6 H4	0.07	0.3	0.8	5		0.5	P≤0.012 S≤0.010
CROMOCORD 9	1599	E CrMo9 B 22 H5	A5.5	E 8015-B8	0.08	0.4	0.7	9	0.06	1	P≤0.015 S≤0.015
CROMOCORD 9M	3580-A	E CrMo9 B 42 H5	A5.5	E 9018-B9 H4	0.09	0.2	0.95	9		1	P≤0.015 S≤0.010 Nb 0.07 V 0.2 N 0.04
CROMOCORD 91	3580-A	E CrMo 9 1 B 42 H5	A5.5	E 9018-B9 H4	0.1	0.3	0.7	9	0.4	1	P≤0.012 S≤0.010 Nb 0.05 V 0.2 N 0.04
CROMOCORD 92	3580-A	E Z CrMoWVNb 9 0.5 2 B 42 H5	A5.5	E 9018-G	0.095	0.2	1.1	9		0.5	P≤0.012 S≤0.012 Nb 0.05 V 0.20 N 0.04 Co 1, W1.7
CROMOCORD 10M	3580-A	E Z CrMoWV 10 B 42 H5	A5.5	E 9018-G	0.1	0.25	1	9.5	0.7	1	P≤0.015 S≤0.010 Nb 0.05 V 0.2, W1 N 0.05
CROMOCORD N125	3580-A	E CrMoV 1 B 42 H5	A5.5	E 9015-G H4	0.12	0.4	0.9	1.4		1	P≤0.020 S≤0.015 V 0.25

**OERLIKON**

**AIR LIQUIDE**  
WELDING

### Prodejní program - Product data:

#### Obalené elektrody pro svařování a navařování ocelí metodou MMA Electrodes for welding proces MMA Díl 1 - Part 1



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**MMA Elektrody pro svařování C-Mn ocelí / MMA Electrodes for C-Mn and low-alloy steels**

Obchodní značení přídavného materiálu Product Name	Označení norem / Standards Klasifikace / Classification				Chemická analýza / Chemical Analysis - typical values [%]						
	EN / EN ISO		AWS		C	Si	Mn	Cu	Ni	Mo	další
FINCORD M	2560-A	E 38 0 R 12	A5.1	E 6013	0.05-0.09	0.2-0.5	0.3-0.6				P≤0.02 S≤0.02
OVERCORD E	2560-A	E 38 0 R 12	A5.1	E 6013	0.05-0.11	0.2-0.4	0.4-0.7				P≤0.03 S≤0.02
SUPERCORD	2560-A	E 38 0 R 12	A5.1	E 6013	0.05-0.11	0.2-0.4	0.4-0.7				P≤0.03 S≤0.02
OVERCORD S	2560-A	E 38 2 R 12	A5.1	E 6013	0.06	0.2	0.5				P≤0.03 S≤0.02
SUPERCORD 42	2560-A	E 42 A R 12	A5.1	E 6013	0.05-0.11	0.4	0.4				P≤0.03 S≤0.03
SUPERCORD 45	2560-A	E 42 0 R 12	A5.1	E 6013	0.06-0.1	0.2-0.5	0.4-0.7				P≤0.03 S≤0.02
OVERCORD R92	2560-A	E 35 0 RC 11	A5.1	E 6013	0.07	0.4	0.55				P≤0.03 S≤0.03
OVERCORD	2560-A	E 38 0 RC 11	A5.1	E 6013	0.08	0.3	0.5				
OVERCORD R10	2560-A	E 38 0 RC 11	A5.1	E 6013	0.07	0.4	0.5				P≤0.03 S≤0.03
OVERCORD R12	2560-A	E 38 0 RC 11	A5.1	E 6013	0.07	0.4	0.6				P≤0.03 S≤0.03
OVERCORD Z	2560-A	E 38 0 RC 11	A5.1	E 6013	0.08	0.3	0.5				
CITOCORD	2560-A	E 42 0 RC 11	A5.1	E 6013	0.08	0.4	0.6				
FLEXAL 60	2560-A	E 38 3 C 21	A5.1	E 6010	0.1	0.2	0.6				
FLEXAL 70	2560-A	E 42 2 Mo C 21	A5.5	E 7010-P1	0.1	0.2	0.7			0.5	
FLEXAL 80	2560-A	E 46 3 1NiMo C 21	A5.5	E 8010-G	0.1	0.2	0.8		0.7	0.3	
FLEXAL 90	2560-A	E 50 2 1Ni C 21	A5.5	E 9010-G	0.15	0.2	0.8		0.8	0.3	
FINCORD S	2560-A	E 42 A RR 12	A5.1	E 6013	0.08	0.5	0.6				
FINCORD	2560-A	E 42 0 RR 12	A5.1	E 6013	0.08	0.45	0.6				
FINCORD DB	2560-A	E 42 0 RR 12	A5.1	E 6013	0.08	0.35	0.5				
SUPERCORD R14	2560-A	E 42 0 RR 12	A5.1	E 6013	0.7	0.5	0.6				
FERROMATIC 130	2560-A	E 42 0 RR 53	A5.1	E 7024	0.1	0.4	0.8				
FERROMATIC 160	2560-A	E 42 0 RR 73	A5.1	E 7024	0.1	0.45	0.9				
FERROMATIC 180	2560-A	E 42 0 RR 73	A5.1	E 7024	0.1	0.4	0.9				
FERROMATIC 200	2560-A	E 42 0 RR 73	A5.1	E 7024	≤0.1	0.5	0.6-1.2				
CITOREX	2560-A	E 38 2 RB 12	A5.1	E 6013	0.08	0.2	0.6				
CITORAPID	2560-A	E 38 2 RA 13	A5.1	E 6020	0.08	0.2	0.6				
CITORAPID 160 W	2560-A	E 38 2 RA 73	A5.1	E 6027	0.06	0.25	0.8				
EXTRA	2560-A	E 42 4 B 32 H10	A5.1	E 7016-H8	0.08	0.45	1.3				P≤0.025 S≤0.015
SPEZIAL	2560-A	E 38 3 B 12 H10	A5.1	E 7016-H8	0.06	0.7	0.9				P≤0.025 S≤0.015
TENAX 56S	2560-A	E 42 5 B 12 H5	A5.1	E 7016-1 H4	0.06	0.5	1.2				P≤0.02 S≤0.02
ULTRACITO	2560-A	E 42 2 RB 32 H10	A5.1	E 7018	0.05	0.4	1.25				P≤0.02 S≤0.02
SUPERCITO A	2560-A	E 42 4 B 42 H5	A5.1	E 7018	0.05-0.9	0.25-0.65	0.8-1.2				P≤0.025 S≤0.015
SUPERCITO E	2560-A	E 42 4 B 32 H5	A5.1	E 7018	0.05-0.08	≤0.55	1-1.5				P≤0.025 S≤0.015
TENACITO R	2560-A	E 42 6 B 42 H5	A5.1	E 7018-1 H4	0.06	0.3	1.45				P≤0.012 S≤0.012
UNIVERS	2560-A	E 38 6 B 42 H5			0.07	0.4	0.9				P≤0.020 S≤0.015
FEBAMATIC 160S	2560-A	E 42 4 B 54 H5	A5.1	E 7028	0.1	0.6	1.1				P≤0.025 S≤0.015
TENAX CY17	2560-A	E 42 5 B 32 H5	A5.1	E 7018-1	0.07	0.3	1.4				P≤0.025 S≤0.02
SUPERCITO	2560-A	E 42 5 B 32 H5	A5.1	E 7018-1 H4	0.05-0.08	0.55	1-1.5				P≤0.025 S≤0.025
SUPERCITO 7018S	2560-A	E 42 5 B 32 H5	A5.1	E 7018-1 H4	0.05	0.4	1.2				P≤0.020 S≤0.015
TENAX 35S	2560-A	E 42 5 B 32 H5	A5.1	E 7018-1 H4	0.075	0.35	1.35				P≤0.020 S≤0.015
TENAX 55H	2560-A	E 42 5 B 32 H5	A5.1	E 7018-1 H4	0.06	0.35	1.5				P≤0.03 S≤0.03

**MMA elektrody pro svařování atmosféricky odolných ocelí / MMA Electrodes for Weathering steels**

Obchodní značení přídavného materiálu Product Name	Označení norem / Standards Klasifikace / Classification				Chemická analýza / Chemical Analysis - typical values [%]						
	EN ISO		AWS		C	Si	Mn	Cu	Ni	Mo	další
BOR SP6	2560-A	E 46 6 B 34 H10			0.06	0.7	1.8				P≤0.025 S≤0.015
TENAX 76S	2560-A	E 46 6 1Ni B 32 H5	A5.5	E 7018-G	0.07	0.3	1.4		0.9		P≤0.02 S≤0.01
TENACITO 38R	2560-A	E 46 6 1Ni B 42 H5	A5.5	E 7018-G H4	0.06	0.4	1.3		0.95		P≤0.012 S≤0.015
OE-CRYO 87	2560-A	E 42 6 3Ni B 12 H5	A5.5	E 7016-C2L	0.03	0.2	0.5		3.5		P≤0.02 S≤0.02
OE-CRYO 75H	2560-A	E 42 6 2Ni B 32 H5	A5.5	E 7018-C1L	0.04	0.3	0.5		2.3		P≤0.015 S≤0.015
OE-CRYO 55	2560-A	E 46 6 2Ni B 42 H5	A5.5	E 8018-C1	0.04	0.4	1		2.3		P≤0.020 S≤0.015
TENAX 88S	2560-A	E 50 6 Mn1Ni B 12 H5	A5.5	E 8016-G	0.06	0.4	1.7		0.8		P≤0.02 S≤0.02
TENAX 88S HR	2560-A	E 50 6 Mn1Ni B 32 H5	A5.5	E 8018-G H4	0.06	0.3	1.5		0.9	0.2	P≤0.015 S≤0.015
TENACITO 70B	2560-A	E 46 6 2Ni B 42 H5	A5.5	E8018-C1H4	0.06	0.3	1.1		2.4		P≤0.012 S≤0.012
TENACITO 70	2560-A	E 50 6 Mn1Ni B 42 H5	A5.5	E 8018-G H4	0.06	0.3	1.6		0.75		P≤0.020 S≤0.015
FREEZAL ENi3	2560-A	E 46 6 3Ni B 32 H5	A5.5	E 8018-C2	0.04	0.3	0.75		3.3		P≤0.015 S≤0.015
VERTICORD 80	2560-A	E 46 4 B 45 H5	A5.5	E 8018 G	0.07	0.5	1.5				P≤0.020 S≤0.015
VERTICORD 90	757	E 55 4 Z B 45 H5	A5.5	E 9018-G	0.06	0.5	1.4		0.9	0.3	P≤0.02 S≤0.02

**MMA elektrody pro svařování Cr-Mo ocelí / MMA Electrodes for Chromium-Molybdenum steels**

Obchodní značení	EN ISO		AWS		C	Si	Mn	Cr	Ni	Cu	další
TENCORD Kb	2560-A	E 42 4 ZNiCu1 B 42 H5	A5.5	E 7018-G H4	0.06	0.4	1		1	0.45	P≤0.020 S≤0.015
TENCORD 85 CP	2560-A	E 46 4 Z B 32 H5	A5.5	E 8018-G	0.06	0.4	1.3	0.5	0.45	0.45	P≤0.02 S≤0.02

**MMA elektrody pro svařování vysokopevných ocelí / MMA Electrodes for High strength steels**

Obchodní značení	EN ISO		AWS		C	Si	Mn	Cr	Ni	Mo	další
TENAX 98M	757	E 55 5 Z B 32 H5	A5.5	E 9018-M H4	0.07	0.4	1.2		1.6	0.3	P≤0.02 S≤0.02
TENACITO 65R	757	E 55 6 Mn1NiMo B T 42 H5	A5.5	E 9018-G H4	0.05	0.3	1.6		0.9	0.35	P≤0.012 S≤0.012
TENAX 118-D2	757	E 62 4 Mn1NiMo B T 32 H5	A5.5	E 10018-D2	0.08	0.3	1.80		0.8	0.35	P≤0.025 S≤0.02
TENACITO 75	757	E 69 6 Mn2NiCrMo B42 H5	A5.5	E 10018-G H4	0.05	0.5	1.4	0.4	2.4	0.40	P≤0.020 S≤0.012
TENAX 118	757	E 69 4 Mn2NiCrMo B32 H5	A5.5	E 11018-G H4	0.06	0.4	1.7	0.4	1.7	0.4	P≤0.020 S≤0.012
TENAX 118-M	757	E 69 5 Z B 32 H5	A5.5	E 11018-M H4	0.07	0.3	1.6		2.3	0.4	P≤0.02 S≤0.02
TENACITO 80	757	E 69 6 Mn2NiCrMo B42 H5	A5.5	E 11018-G H4	0.06	0.4	1.8	0.4	2.3	0.45	P≤0.020 S≤0.012
TENACITO 80 CL	757	E 69 6 Mn2NiMo B 42 H5	A5.5	E 11018-G H4	0.06	0.4	1.6	<0.2	2.4	0.4	P≤0.020 S≤0.012
TENAX 128-M	757	E 79 5 Mn2NiCrMo B32 H5	A5.5	E 12018-M	0.08	0.35	1.6	0.45	1.9	0.4	P≤0.015 S≤0.015
TENAX 128	757	E 89 2Mn2Ni1CrMoB32 H5	A5.5	E 12018-G H4	0.08	0.4	1.7	0.6	1.9	0.8	P≤0.020 S≤0.010
TENACITO 100	757	E 89 4 Mn2Ni1CrMoB42H5	A5.5	E 12018-G H4	0.07	0.4	1.7	0.8	2.45	0.5	P≤0.012 S≤0.012
TENAX 140			A5.5	E 14018-M H4	0.08	0.3	1.3	0.7	3.7	1.1	P≤0.012 S≤0.012