

## Prodejní program - Product data:

Dráty-pásy pro svařování a navařování ocelí metodou SAW  
Wires-Strips for welding proces SAW



**SAW dráty pro svařování Cr-Ni ocelí / SAW Wires for Stainless and Heat resistant steels**

| Obchodní značení<br>přídavného materiálu<br>Product Name | Označení norem / Standards<br>Klasifikace / Classification |                |      |         | Chemická analýza / Chemical Analysis - typical values<br>[%] |       |      |      |      |     |                            |
|--|--|----------------|------|---------|--|-------|------|------|------|-----|----------------------------|
|  | EN / EN ISO  |                | AWS  |         | C  | Si    | Mn   | Cr   | Ni   | Mo  | další                      |
|  | OE-410   | 14343-A        | S 13 | A5.9    | ER 410   | ≤0.12 | ≤0.5 | ≤0.4 | 13   |     |                            |
| OE-430   | 14343-A  | S 17           | A5.9 | ER 430  | ≤0.1   | ≤0.5  | ≤0.6 | 16   |      |     |                            |
| OE-308L  | 14343-A  | S 19 9 L       | A5.9 | ER 308L | 0.02   | 0.4   | 1.5  | 20   | 10   |     | P≤0.02<br>S≤0.02           |
| OE-347   | 14343-A  | S 19 9 Nb      | A5.9 | ER 347  | 0.05   | 0.4   | 1.6  | 19.5 | 9.5  |     | P≤0.02<br>S≤0.02<br>Nb 0.7 |
| OE-316L  | 14343-A  | S 19 12 3 L    | A5.9 | ER 316L | 0.02   | 0.4   | 1.6  | 18   | 12.5 | 2.5 | P≤0.02<br>S≤0.02<br>Nb 0.7 |
| OE-318   | 14343-A  | S 19 12 3 Nb   | A5.9 | ER 318  | 0.05   | 0.4   | 1.3  | 19   | 12   | 2.7 | P≤0.02<br>S≤0.02<br>Cu 0.4 |
| OE-S 22 09   | 14343-A  | S 22 9 3 N L   | A5.9 | ER 2209 | 0.025  | 0.4   | 1.8  | 23   | 9    | 3   | P≤0.02<br>S≤0.02<br>N 0.12 |
| OE-S 25 10   | 14343-A  | S 25 9 4 L     |      |         | 0.02   | 0.4   | 2    | 26   | 10   | 4   | P≤0.02<br>S≤0.02<br>N 0.25 |
| OE-309L  | 14343-A  | S 23 12 L      | A5.9 | ER 309L | 0.02   | 0.4   | 1.8  | 24   | 13.5 |     | P≤0.02<br>S≤0.02           |
| OE-309LMo  | 14343-A  | S 23 12 2 L    | A5.9 | EG      | 0.02   | 0.4   | 1.8  | 24   | 13.5 | 2.7 | P≤0.02<br>S≤0.02           |
| OE-22 12 H   | 14343-A  | S 22 12 H      | A5.9 | EG      | 0.12   | 1     | 2    | 22   | 12   |     |                            |
| OE-20 16 L   | 14343-A  | S 20 16 3 Mn L | A5.9 | EG      | 0.02   | 0.2   | 7    | 20   | 16   | 3   | P≤0.02<br>S≤0.02<br>N 0.15 |

**SAW dráty pro svařování niklových slitin / SAW Wires for Nickel alloys**

| Obchodní značení | EN / EN ISO |           | AWS   |             | C     | Si   | Mn  | Cr   | Ni  | Mo | další          |
|------------------|-------------|-----------|-------|-------------|-------|------|-----|------|-----|----|----------------|
| NIFIL 600        | 18274       | S Ni 6082 | A5.14 | ER NiCr-3   | 0.02  | 0.2  | 3   | 20   | >65 |    | Nb 2.5         |
| NIFIL 625        | 18274       | S Ni 6625 | A5.14 | ER NiCrMo-3 | 0.02  | 0.3  | 0.3 | 22   | >60 | 9  | Nb 3.5<br>Fe<1 |
| NIFIL C276       | 18274       | S Ni 6276 | A5.14 | ER NiCrMo-4 | <0.02 | 0.07 | 0.7 | 15.5 | bal | 16 | Fe 5<br>W 4    |

**SAW dráty pro svařování Cr-Mo ocelí / SAW Wires for Chromium-Molybdenum steels**

| Obchodní značení | EN / EN ISO |          | AWS   |       | C     | Si   | Mn   | Cr   | Ni  | Mo  | další             |
|------------------|-------------|----------|-------|-------|-------|------|------|------|-----|-----|-------------------|
| OE-S2 CrMo1      | 24598-A     | S CrMo1  | A5.23 | EB2   | 0.12  | 0.2  | 1    | 1.2  |     | 0.5 | P≤0.02<br>S≤0.02  |
| OE-S1 CrMo2      | 24598-A     | S CrMo2  | A5.23 | EB3   | 0.12  | 0.2  | 0.5  | 2.5  |     | 1   | P≤0.02<br>S≤0.02  |
| OE-CROMO S225    | 24598-A     | S CrMo2  | A5.23 | EB3 R | 0.13  | ≤0.2 | ≤0.7 | 2.50 |     | 1   | P≤0.01<br>S≤0.01  |
| OE-CROMO S225V   | 24598-A     | SZ       | A5.23 | EG R  | ≤0.13 | ≤0.2 | ≤1   | 2.5  |     | 1   | Nb 0.02<br>V 0.25 |
| OE-S1 CrMo5      | 24598-A     | S CrMo5  | A5.23 | EB6   | 0.1   | 0.3  | 0.5  | 5.5  |     | 0.6 |                   |
| OE-KV7M          | 24598-A     | S CrMo91 | A5.23 | EB9   | 0.1   | 0.15 | 0.6  | 9    | 0.7 | 0.9 | Nb 0.06<br>V 0.22 |

**SAW páska pro plátování / SAW Strips for Cladding**

| Obchodní značení     | EN / EN ISO |             | AWS   |             | C     | Si   | Mn  | Cr   | Ni   | Mo  | další            |
|----------------------|-------------|-------------|-------|-------------|-------|------|-----|------|------|-----|------------------|
| SUPRASTRIP 19 9 L    | 14343-A     | B 19 9 L    | A5.9  | EQ 308L     | 0.01  | 0.4  | 1.9 | 20   | 10.5 |     |                  |
| SUPRASTRIP 24 13 L   | 14343-A     | B 23 12 L   | A5.9  | EQ 309L     | 0.01  | 0.4  | 1.8 | 23.6 | 13.3 |     |                  |
| SUPRASTRIP 19 9 LNb  | 14343-A     | B 19 9 Nb   | A5.9  | EQ 347      | 0.02  | 0.4  | 1.8 | 19.5 | 10.5 |     | Nb 0.5           |
| SUPRASTRIP 21 11 LNb | 14343-A     | B 21 11 Nb  | A5.9  | EQ 347      | 0.02  | 0.2  | 1.9 | 21   | 11   |     | Nb 0.6           |
| SUPRASTRIP 24 13 LNb | 14343-A     | B Z         | A5.9  | EQ 309 LNb  | 0.02  | 0.3  | 1.8 | 24   | 12.8 |     | Nb 0.7<br>N 0.05 |
| SUPRASTRIP 19 12 3 L | 14343-A     | B 19 12 3 L | A5.9  | EQ 316L     | 0.014 | 0.35 | 1.8 | 18.7 | 12.6 | 2.7 | N 0.05           |
| SUPRASTRIP 21 13 3 L | 14343-A     | B Z         | A5.9  | EQ 309LMo   | 0.01  | 0.3  | 2   | 20.5 | 14   | 2.9 |                  |
| SUPRASTRIP 625       | 18274       | Ni 6625     | A5.14 | EQ NiCrMo-3 | 0.02  | 0.1  | 0.2 | 22   | bal  | 9   | Nb 3.8<br>Cu 0.4 |
| SUPRASTRIP 825       | 18274       | Ni 8065     | A5.14 | EQ NiFeCr-1 | 0.02  | 0.25 | 0.8 | 20   | bal  | 3   | Cu 2<br>Fe 30    |

**SAW dráty pro svařování C-Mn ocelí / SAW Wires for C-Mn and low-alloy steels**

| Obchodní značení<br>přídavného materiálu<br>Product Name | Označení norem / Standards<br>Klasifikace / Classification |             |       |        | Chemická analýza / Chemical Analysis - typical values<br>[%] |      |      |      |      |      |  |
|--|--|-------------|-------|--------|--|------|------|------|------|------|--|
|  | EN / EN ISO  |             | AWS   |        | C  | Si   | Mn   | Cr   | Ni   | Mo   | další                                    |
|  | OE-S1  | 756         | S1    | A5.17  | EL 12  | 0.1  | 0.1  | 0.5  |      |      |  |
| OE-S2  | 756  | S2          | A5.17 | EM 12K | 0.1  | 0.1  | 1    |      |      |      | P≤0.02<br>S≤0.02                         |
| OE-S3  | 756  | S3          | A5.17 | EH 10K | 0.1  | 0.1  | 1.45 |      |      |      | P≤0.02<br>S≤0.02                         |
| OE-S4  | 756  | S4          | A5.17 | EH 14  | 0.1  | 0.1  | 1.9  |      |      |      | P≤0.01<br>S≤0.01                         |
| OE-SD3   | 756  | S3Si        | A5.17 | EH 12K | 0.1  | 0.3  | 1.7  |      |      |      | P≤0.015<br>S≤0.015<br>Cu 0.4             |
| OE-S2 NiCu   | 756  | SNi1Cu      | A5.23 | EG     | 0.1  | 0.25 | 1    | <0.3 | 1    |      | P≤0.02<br>S≤0.02<br>Cu 0.5               |
| OE-S2 Ni1  | 756  | S2Ni1       | A5.23 | ENi1   | 0.1  | 0.15 | 1    |      | 0.9  |      |  |
| OE-S2 Ni2  | 756  | S2Ni2       | A5.23 | ENi2   | 0.06   | 0.2  | 1    |      | 2.3  |      | P≤0.015<br>S≤0.015                       |
| OE-S2 Ni3  | 756  | S2Ni3       | A5.23 | ENi3   | 0.08   | 0.2  | 1    |      | 3.2  |      | P≤0.015<br>S≤0.015                       |
| OE-S2 Mo   | 756  | S2Mo        | A5.23 | EA2    | 0.1  | 0.2  | 1    |      |      | 0.5  | P≤0.02<br>S≤0.02                         |
| OE-SD3 Mo  | 756  | S3Mo        | A5.23 | EA4    | 0.1  | 0.1  | 1.6  |      |      | 0.5  | P≤0.015<br>S≤0.015<br>Cu 0.4             |
| OE-S4 Mo   | 756  | S4Mo        | A5.23 | EA3    | 0.1  | 0.2  | 1.9  |      |      | 0.5  | P≤0.02<br>S≤0.02                         |
| OE-SD3 1Ni 1/4Mo   | 756  | SZ          | A5.23 | EG     | 0.1  | 0.25 | 1.5  |      | 0.95 | 0.25 |  |
| OE-SD3 1Ni 1/2Mo   | 14295  | S3Ni1Mo     | A5.23 | EF3/EG | 0.12   | 0.2  | 1.7  |      | 0.95 | 0.5  | P≤0.015<br>S≤0.015                       |
| OE-SD2 1NiCrMo   | 14295  | SZ          | A5.23 | EG     | 0.1  | 0.25 | 1    | 1.1  | 1    | 0.5  |  |
| OE-SD3 2NiCrMo   | 14295  | S3Ni2.5CrMo | A5.23 | EG     | 0.12   | 0.2  | 1.5  | 0.6  | 2.4  | 0.5  |  |
| TIBOR 22   | 14295  | SZ          | A5.23 | EG     | 0.1  | ≤0.1 | 1.3  |      |      | 0.4  | Ti 0.05<br>B 0.005                       |
| TIBOR 33   | 14295  | SZ          | A5.23 | EG     | 0.09   | 0.3  | 1.2  |      |      | 0.5  | P≤0.015<br>S≤0.015<br>Ti 0.16<br>B 0.013 |