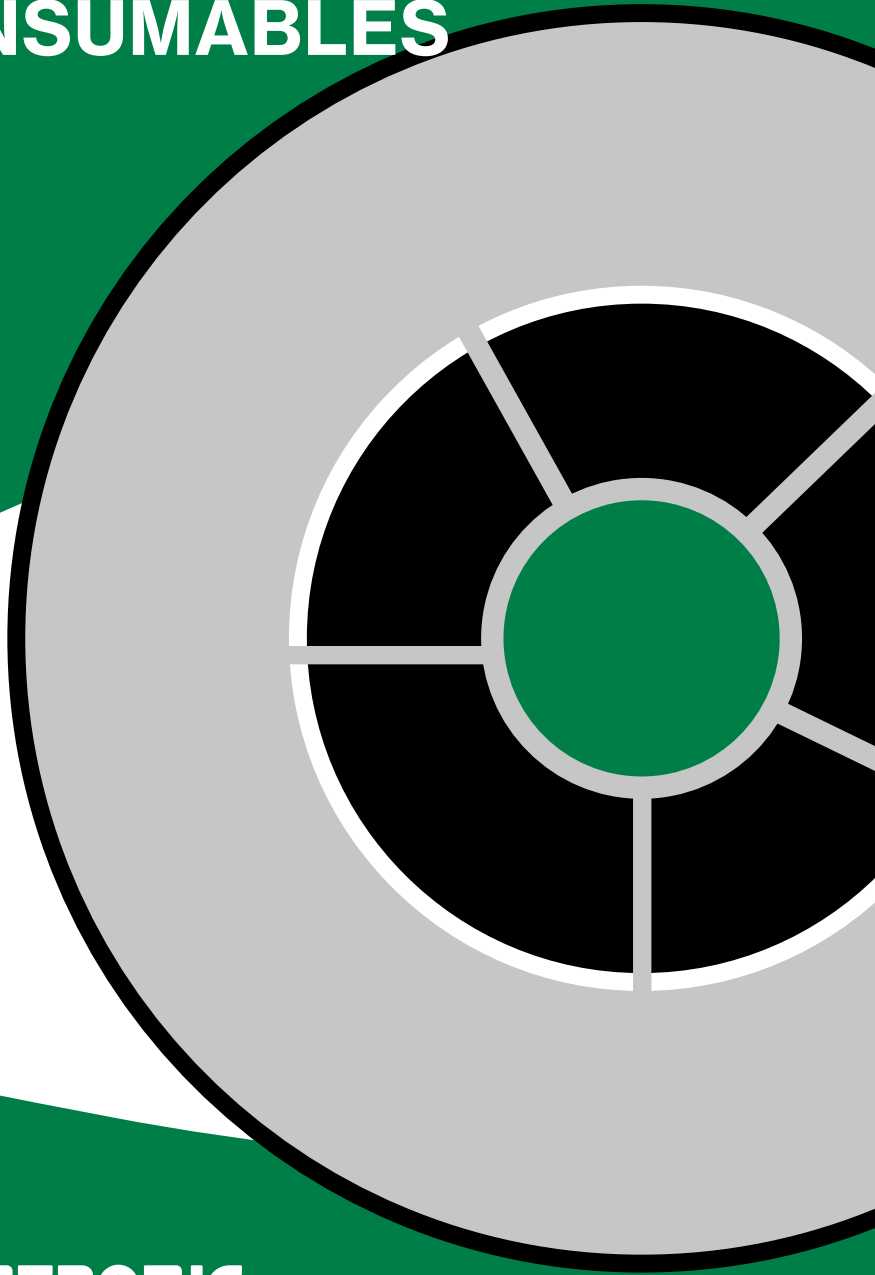


# MIGATRONIC CONSUMABLES



**MIGATRONIC**

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## Contact

If you have any questions relating to our consumable products, please do not hesitate to contact us by sending an e-mail to:

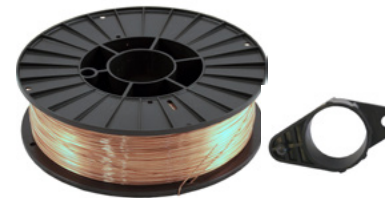
[Consumables@Migatron.com](mailto:Consumables@Migatron.com)

## CLASSIFICATION LEGEND

### EXAMPLE: G 42 2 M 3Si1

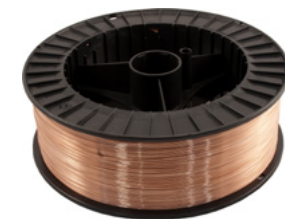
- G = Solid wire
- 42 = Yield strength / Tensile strength
- 2 = Temperature for minimum average impact energy
- M / C = Shielding gas
  - M2 : Mixed gas without He
  - M21: Mixed gas Ar+ >15 to 25% CO2
  - C1 : Active gas 100 % CO2
- 3Si1 = Chemical composition

## SPOOL TYPES:

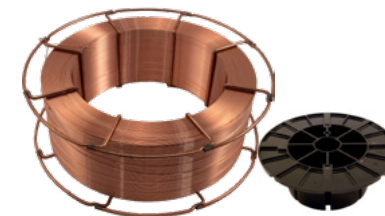


### D200 plastic spool

Use adapter 45050333 on machines prepared for 300mm spools.

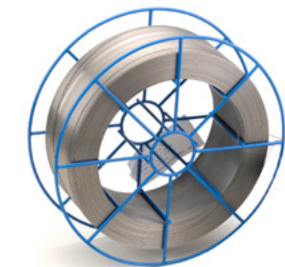


### D300 plastic spool



### K300 steel spool

Use adapter 81899017 on K300 spools.



### BS300 steel spool with hub

## MIG/MAG CONSUMABLES

### Solid wire - mild steel

| SG2 Precision Layer Wire - Copper-free              |             |   |          |          |          |
|---|-------------|---|----------|----------|----------|
| <b>Classification according to</b>                  |             | <b>EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b> |          |          |          |
| Copper-free solid wire for mild steel. PLW quality. |             |   |          |          |          |
| Quality   | Spool type  | 0.6 mm  | 0.8 mm   | 1.0 mm   | 1.2 mm   |
| SG2   | BS300/15 kg |   | 81840562 |          |          |
| SG2   | BS300/15 kg |   |          | 81840564 |          |
| SG2   | BS300/15 kg |   |          |          | 81840565 |

| SG2 Random wire - Copper-coated  |            |   |          |          |          |
|--|------------|---|----------|----------|----------|
| <b>Classification according to</b>   |            | <b>EN ISO 14341-A: G 46 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b> |          |          |          |
| Copper-coated solid wire in SG2 quality for mild steel. Random wire quality. |            |   |          |          |          |
| Quality  | Spool type | 0.6 mm  | 0.8 mm   | 1.0 mm   | 1.2 mm   |
| SG2  | D200/5 kg  | 81840611  |          |          |          |
| SG2  | D300/15 kg | 81840621  |          |          |          |
| <b>Classification according to</b>   |            | <b>EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b> |          |          |          |
| Quality  | Spool type | 0.6 mm  | 0.8 mm   | 1.0 mm   | 1.2 mm   |
| SG2  | D200/5 kg  |   | 81840702 |          |          |
| SG2  | D200/5 kg  |   |          | 81840704 |          |
| SG2  | D200/5 kg  |   |          |          | 81840705 |

### Solid wire - mild steel

| SG2 Precision Layer Wire - Copper-coated                             |                |   |          |          |          |
|--|----------------|---|----------|----------|----------|
| <b>Classification according to</b>                                   |                | <b>EN ISO 14341-A: G 42 4 M21 3Si1 / G 42 2 C1 3Si1 AWS A5.18: ER 70S-6</b> |          |          |          |
| Copper-coated solid wire in SG2 quality for mild steel. PLW quality. |                |   |          |          |          |
| Quality  | Spool type     | 0.6 mm  | 0.8 mm   | 1.0 mm   | 1.2 mm   |
| SG2  | BS300/15 kg    |   | 81840762 |          |          |
| SG2  | BS300/15 kg    |   |          | 81840764 |          |
| SG2  | BS300/15 kg    |   |          |          | 81840765 |
| SG2  | 300 kg fustage |   |          | 81840774 |          |
| SG2  | 300 kg fustage |   |          |          | 81840775 |

| SG3 Precision Layer Wire - Copper-coated                             |                |   |          |          |          |
|--|----------------|---|----------|----------|----------|
| <b>Classification according to</b>                                   |                | <b>EN ISO 14341-A: G 46 4 M21 4Si1 / G 42 3 C1 4Si1 AWS A5.18: ER 70S-6</b> |          |          |          |
| Copper-coated solid wire in SG3 quality for mild steel. PLW quality. |                |   |          |          |          |
| Quality  | Spool type     | 0.6 mm  | 0.8 mm   | 1.0 mm   | 1.2 mm   |
| SG3  | BS300/15 kg    |   | 81840962 |          |          |
| SG3  | BS300/15 kg    |   |          | 81840964 |          |
| SG3  | BS300/15 kg    |   |          |          | 81840965 |
| SG3  | 300 kg fustage |   | 81840972 |          |          |
| SG3  | 300 kg fustage |   |          | 81840974 |          |
| SG3  | 300 kg fustage |   |          |          | 81840975 |

## Solid wire - others

| MIGAWIRE HTS - Precision Layer Wire   |   |               |               |               |
|---|---|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 16834-A: G 69 4 M Mn3Ni 1CrMo</b><br><b>AWS A5.18: ER 100 S-G</b> |               |               |               |
| Solid wire for welding of high-tensile steel with tensile strength up to 755N/mm <sup>2</sup> . Applicable for cranes, pressure-carrying equipment and similar statically and dynamically influenced structures. PLW quality. |   |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> |
| D300/15 kg  |   | 81841408      |               |               |
| D300/15 kg  |   |               | 81841410      |               |
| D300/15 kg  |   |               |               | 81841412      |

| MIG 80S NI   |  |               |               |               |
|--|--|---------------|---------------|---------------|
| <b>Classification according to</b>   | <b>EN ISO 14341-A: G 46 5 M21 3Ni1</b><br><b>AWS A5.28: ER 100 S-G</b> |               |               |               |
| Manganese-nickel-alloy wire for welding of fine-grained steel to low-temperature steel and high-tensile steel. |  |               |               |               |
| <b>Spool type</b>  | <b>0.6 mm</b>  | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> |
| D300/15 kg   |  | 81843000      |               |               |

| MIGA SG CU - Precision Layer Wire  |   |               |               |               |
|--|---|---------------|---------------|---------------|
| <b>Classification according to</b>   | <b>EN ISO 16834-A: G Mn3Ni1CU</b><br><b>AWS A5.28: ER 80 S-G</b><br><b>EN ISO 14341-A: G504M21Z</b> |               |               |               |
| Solid wire for welding of corten steel, which is a corrosion-slow steel type. Copper-coating ensures fine current transfer. PLW quality. |   |               |               |               |
| <b>Spool type</b>  | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> |
| D300/15 kg   |   | 81843208      |               |               |
| D300/15 kg   |   |               | 81843210      |               |

## Solid wire - others

| MIGA SG1 Galva Wire - Precision Layer Wire   |   |               |               |               |
|--|---|---------------|---------------|---------------|
| <b>Classification according to</b>   | <b>EN ISO 14341-A: G 422M21Z</b><br><b>AWS A5.18: ER 70 S-G</b> |               |               |               |
| Solid wire in SG1 quality for welding of workpieces for subsequent galvanising. Also applicable for welding of galvanised, alu-coated or primed surfaces. PLW quality. |   |               |               |               |
| <b>Spool type</b>  | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> |
| D200/5 kg  | 81845106  |               |               |               |
| D200/5 kg  |   | 81845108      |               |               |
| D300/15 kg   |   | 81845008      |               |               |
| K300/15 kg   |   |               | 81845010      |               |

| MIGA HARD 600 - Precision Layer Wire  |   |               |               |               |
|---|---|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 14700: S FE8</b><br><b>AWS A5.14: MSG 6-6Z-60</b> |               |               |               |
| Solid wire for hardfacing. Applicable for rebuilding surfaces of heavily worn construction equipment shovels and the like. PLW quality. |   |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> |
| D300/15 kg  |   |               | 81845310      |               |
| D300/15 kg  |   |               |               | 81845312      |



## Stainless steel

### MIG 309 LSi

|   |   |               |               |               |               |
|---|---|---------------|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 14343-A: G 23 12 LSi<br/>AWS A5.9: ER 309L (Si)</b> |               |               |               |               |
| Applicable for welding of joints between mild steel and stainless steel. Also applicable for welding on unalloyed steel if you want an 18 Cr/8Ni steel surface. Recommended for buffer coating. |   |               |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> | <b>1.6 mm</b> |
| BS300/15 kg   |   | 81841708      |               |               |               |
| BS300/15 kg   |   |               | 81841710      |               |               |
| BS300/15 kg   |   |               |               | 81841712      |               |

### MIG 316 LSi

|   |  |               |               |               |               |
|---|--|---------------|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 14343-A: G 19 123 LSi<br/>AWS A5.9: ER 316L (Si)</b> |               |               |               |               |
| Applicable for welding of acid-proof low-carbon austenitic stainless steel. High silicon content provides fine flow properties. Operating temperature ranging from -196°C to 350°C. |  |               |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>  | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> | <b>1.6 mm</b> |
| D200/5 kg   |  | 81841805      |               |               |               |
| BS300/15 kg   |  | 81843808      |               |               |               |
| D200/5 kg   |  |               | 81841803      |               |               |
| BS300/15 kg   |  |               | 81843810      |               |               |
| BS300/15 kg   |  |               |               | 81843812      |               |

## Aluminium wire

### ALU MIG AISi5

|   |   |               |               |               |               |
|---|---|---------------|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 18273: S AL 4043<br/>AWS A5.10: ER 4043</b> |               |               |               |               |
| Aluminium wire with 5% silicon is the most common AlSi wire. Provides a nice surface. Ideal for the auto business and welding of common structures. Not seawater-proof and not suitable for workpieces which are subsequently anodised. |   |               |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> | <b>1.6 mm</b> |
| D300/6 kg   |   |               | 81846110      |               |               |
| D300/6 kg   |   |               |               | 81846112      |               |

### ALU MIG AISi12

|   |   |               |               |               |               |
|---|---|---------------|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 18273: S AL 4047<br/>AWS A5.10: ER 4047</b> |               |               |               |               |
| Aluminium wire with 12% silicon is softer than AlSi5 and light-fluid. Not seawater-proof and not suitable for workpieces which are subsequently anodised. |   |               |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> | <b>1.6 mm</b> |
| D300/6 kg   |   |               |               | 81846212      |               |

### ALU MIG AlMg 4.5MN

|   |   |               |               |               |               |
|---|---|---------------|---------------|---------------|---------------|
| <b>Classification according to</b>  | <b>EN ISO 18273: S AL 5183<br/>AWS A5.10: ER 5183</b> |               |               |               |               |
| Aluminium wire with 4.5% magnesium plus manganese. Seawater-proof. Allows subsequent anodising of workpieces. Typically used for ship-building. |   |               |               |               |               |
| <b>Spool type</b>   | <b>0.6 mm</b>   | <b>0.8 mm</b> | <b>1.0 mm</b> | <b>1.2 mm</b> | <b>1.6 mm</b> |
| D300/6 kg   |   |               | 81846610      |               |               |
| D300/6 kg   |   |               |               | 81846612      |               |

## Aluminium wire

| ALU MIG AlMg 5  |        |   |          |          |          |
|---|--------|---|----------|----------|----------|
| <b>Classification according to</b>  |        | <b>EN ISO 18273: S AL 5356</b><br><b>AWS A5.10: ER 5356</b> |          |          |          |
| Aluminium wire with 5% magnesium is the most common and versatile filler material for aluminium. Seawater-proof. Allows subsequent anodising of workpieces. |        |   |          |          |          |
| Spool type  | 0.6 mm | 0.8 mm  | 1.0 mm   | 1.2 mm   | 1.6 mm   |
| D200/2 kg   |        | 81846700  |          |          |          |
| D200/2 kg   |        |   | 81846701 |          |          |
| D200/2 kg   |        |   |          | 81846702 |          |
| D300/5 kg   |        | 81846708  |          |          |          |
| D300/6 kg   |        |   | 81846710 |          |          |
| D300/6 kg   |        |   |          | 81846712 |          |
| 80 kg drum  |        |   |          | 81846725 |          |
| 80 kg drum  |        |   |          |          | 81846732 |

## Wire for MIG brazing

| MIGA MIG CuSi 3wire for MIG brazing   |        |   |          |        |        |
|---|--------|---|----------|--------|--------|
| <b>Classification according to</b>  |        | <b>EN ISO 18273: S CU 6560/SUSi3MN1</b><br><b>AWS A5.7: ER CuCi A</b> |          |        |        |
| Copper-silicon wire for MIG brazing. Typically used in the auto business for joining high-tensile steel or coated workpieces. |        |   |          |        |        |
| Spool type  | 0.6 mm | 0.8 mm  | 1.0 mm   | 1.2 mm | 1.6 mm |
| D300/15 kg  |        | 81846808  |          |        |        |
| D200/5 kg   |        | 81846809  |          |        |        |
| D300/15 kg  |        |   | 81846810 |        |        |
| D200/5 kg   |        |   | 81846811 |        |        |

| MIGA MIG CuAl 8 wire for MIG brazing   |        |  |          |        |        |
|--|--------|--|----------|--------|--------|
| <b>Classification according to</b>   |        | <b>EN ISO 18273: S CU 6100/CUAL7</b><br><b>AWS A5.7: ER CuAl-A-1</b> |          |        |        |
| Copper-aluminium wire for MIG brazing. Typically used in the auto business for joining aluminium or coated workpieces. |        |  |          |        |        |
| Spool type   | 0.6 mm | 0.8 mm   | 1.0 mm   | 1.2 mm | 1.6 mm |
| D200/5 kg  |        | 81890055   |          |        |        |
| D200/5 kg  |        |  | 81890056 |        |        |

## Flux-cored wire - FCW

| MIGA/ABRAFIL FCW INNERSHIELD for mild steel  |                       |   |                       |
|--|-----------------------|---|-----------------------|
| <b>Classification according to</b>   |                       | <b>1: EN ISO 17632-A: T3T Z Z V 1</b><br><b>AWS A5.20: E 71-T11</b> |                       |
|  |                       | <b>2: EN ISO 17632-A: T42 Z Y NO 1 H10</b>                          |                       |
| Self-protective seamless cored wire for all welding positions.<br>For unalloyed and low-alloy steel. |                       |   |                       |
| Spool type   | 0.9 mm                | 1.0 mm  | 1.2 mm                |
| D200/4,5 kg  | 81845204 <sup>1</sup> |   | 81841109 <sup>2</sup> |
| K300/15kg  |                       |   | 81841110 <sup>2</sup> |

| FCW M 71 for mild steel   |        |  |          |
|---|--------|--|----------|
| <b>Classification according to</b>  |        | <b>EN ISO 17632-A: T46 4 M M 2 H5</b><br><b>AWS A5.18: E 70C-6 MH4</b> |          |
| Copper-coated seamless metal-cored wire. For single-pass and multi-pass welding of carbon-manganese steel and fine-grained steel. |        |  |          |
| Spool type  | 0.9 mm | 1.0 mm   | 1.2 mm   |
| D200/5 kg   |        |  | 81845211 |
| K300/15 kg  |        |  | 81845215 |

| Miga FCW 215 & FCW R 71 for mild steel  |        |   |                       |
|---|--------|---|-----------------------|
| <b>Classification according to</b>  |        | <b>1: EN ISO 17632-A: T46 2 P M21 1 H5</b><br><b>AWS A5.20: E 71T-1 MH4</b> |                       |
|   |        | <b>2: EN ISO 17632-A T46 2 PM1h5</b>  |                       |
| Seamless rutile flux-cored wire for welding of carbon steel and carbon-manganese steel. Applicable for all welding positions. |        |   |                       |
| Spool type  | 0.9 mm | 1.0 mm  | 1.2 mm                |
| D200/5 kg   |        | 81845242 <sup>1</sup>   |                       |
| D200/5 kg   |        |   | 81845220 <sup>1</sup> |
| K300/15 kg  |        | 81841222 <sup>2</sup>   |                       |
| K300/15 kg  |        |   | 81845225 <sup>1</sup> |

## Flux-cored wire - FCW

| RNi121 for mild steel  |        |   |          |
|--|--------|---|----------|
| Classification according to  |        | EN ISO 17632-A: T46 4 1Ni P M21 1 H5<br>AWS A5.29: E 81T1-Ni1 |          |
| Seamless rutile flux-cored wire for single-pass and multi-pass welding of low-temperature steel. |        |   |          |
| Spool type   | 0.9 mm | 1.0 mm  | 1.2 mm   |
| K300/15 kg   |        |   | 81845235 |

| MIGA FCW Hard 5CR for hardfacing                                      |        |                              |          |
|---|--------|------------------------------|----------|
| Classification according to   |        | EN 14700: T FE 8<br>DIN 8555 |          |
| Chromium-molybdenum-alloy metal-cored wire for hardfacing. HRC 57-62. |        |                              |          |
| Spool type  | 0.9 mm | 1.0 mm                       | 1.2 mm   |
| K300/16 kg  |        |                              | 81841413 |

## TIG CONSUMABLES

### Mild steel

| MIGA KV2 TIG for mild steel  |          |  |         |
|--|----------|--|---------|
| Classification according to  |          | EN ISO 636-A: W MoSi<br>AWS A5.28: ER 805-D2 |         |
| TIG wire for welding of 0.5% molybdenum steel and pressure-carrying equipment. Prevents cold cracks in the welding metal. Applicable for boilers, pressure tanks, pipings if operating temperature <550°C. |          |  |         |
| Art. no.   | Diameter | Length                                       | Packing |
| 81850116   | 1.6 mm   | 1000 mm                                      | 5 kg    |
| 81850120   | 2.0 mm   | 1000 mm                                      | 5 kg    |
| 81850124   | 2.4 mm   | 1000 mm                                      | 5 kg    |
| 81850132   | 3.2 mm   | 1000 mm                                      | 5 kg    |

### Stainless steel

| TIG 309 LSi   |          |  |         |
|---|----------|--|---------|
| Classification according to   |          | EN ISO 14343-A: W 23 12 LSi<br>AWS A5.9: ER 309LSi |         |
| Applicable for welding of joints between mild steel and stainless steel. Also applicable for welding on unalloyed steel if you want an 18 Cr/8Ni steel surface. Recommended for buffer coating. |          |  |         |
| Art. no.  | Diameter | Length   | Packing |
| 81851712  | 1.2 mm   | 1000 mm  | 5 kg    |
| 81851716  | 1.6 mm   | 1000 mm  | 5 kg    |
| 81851720  | 2.0 mm   | 1000 mm  | 5 kg    |
| 81851724  | 2.4 mm   | 1000 mm  | 5 kg    |
| 81851732  | 3.2 mm   | 1000 mm  | 5 kg    |



**TIG 316 LSi**

|                                    |   |
|------------------------------------|---|
| <b>Classification according to</b> | <b>EN ISO 14343-A: W 19 12 3 L Si<br/>AWS A5.9: ER 316LSi</b> |
|------------------------------------|---|

Applicable for welding of acid-proof low-carbon austenitic stainless steel. High silicon content provides fine flow properties. Operating temperature ranging from -196°C to 350°C.

| Art. no. | Diameter | Length  | Packing |
|----------|----------|---------|---------|
| 81853810 | 1.0 mm   | 1000 mm | 5 kg    |
| 81853812 | 1.2 mm   | 1000 mm | 5 kg    |
| 81853816 | 1.6 mm   | 1000 mm | 5 kg    |
| 81853820 | 2.0 mm   | 1000 mm | 5 kg    |
| 81853824 | 2.4 mm   | 1000 mm | 5 kg    |
| 81853832 | 3.2 mm   | 1000 mm | 5 kg    |
| 81853840 | 4.0 mm   | 1000 mm | 5 kg    |

**Aluminium wire****ALU TIG AISi 5**

|                                    |   |
|------------------------------------|---|
| <b>Classification according to</b> | <b>EN ISO 18273: S AL 40 43A<br/>AWS A5.10: ER 4043</b> |
|------------------------------------|---|

Aluminium wire containing 5% silicon provides a nice surface. Suitable for standard structures. Not seawater-proof and not suitable for workpieces which are subsequently anodised.

| Art. no. | Diameter | Length  | Packing |
|----------|----------|---------|---------|
| 81856124 | 2.4 mm   | 1000 mm | 10 kg   |
| 81856132 | 3.2 mm   | 1000 mm | 10 kg   |

**ALU TIG AIMg 4.5Mn**

|                                    |   |
|------------------------------------|---|
| <b>Classification according to</b> | <b>EN ISO 18273: S AL 5183<br/>AWS A5.10: ER 5183</b> |
|------------------------------------|---|

Aluminium wire containing 4.5% magnesium plus manganese. Seawater-proof. Allows subsequent anodising of workpieces. Typically used for ship-building.

| Art. no. | Diameter | Length  | Packing |
|----------|----------|---------|---------|
| 81856616 | 1.6 mm   | 1000 mm | 10 kg   |
| 81856624 | 2.4 mm   | 1000 mm | 10 kg   |
| 81856632 | 3.2 mm   | 1000 mm | 10 kg   |
| 81856640 | 4.0 mm   | 1000 mm | 10 kg   |

**ALU TIG AIMg 5**

|                                    |   |
|------------------------------------|---|
| <b>Classification according to</b> | <b>EN ISO 18273: S AL 5356<br/>AWS A5.10: ER 5356</b> |
|------------------------------------|---|

Aluminium wire containing 5% magnesium. The most common and allround filler material for aluminium. Seawater-proof. Allows subsequent anodising of workpieces.

| Art. no. | Diameter | Length  | Packing |
|----------|----------|---------|---------|
| 81856716 | 1.6 mm   | 1000 mm | 10 kg   |
| 81856720 | 2.0 mm   | 1000 mm | 10 kg   |
| 81856724 | 2.4 mm   | 1000 mm | 10 kg   |
| 81856732 | 3.2 mm   | 1000 mm | 10 kg   |

**Tungsten electrodes****Tungsten Electrode WP - Green****Classification according to EN ISO 6848: WP**

Unalloyed tungsten electrode. Applicable for AC/DC welding of aluminium and magnesium.

| Art. no. | Diameter | Length | Packing |
|----------|----------|--------|---------|
| 80360022 | 1.6 mm   | 175 mm | 10 pcs. |
| 80360024 | 2.4 mm   | 175 mm | 10 pcs. |
| 80360026 | 3.2 mm   | 175 mm | 10 pcs. |

**Tungsten Electrode WL10 - Black****Classification according to EN ISO 6848: WLA10**

Tungsten electrode containing 1% lanthanum oxide. Applicable for DC welding of mild steel and stainless steel and AC/DC welding of aluminium.

| Art. no. | Diameter | Length | Packing |
|----------|----------|--------|---------|
| 80360042 | 1.6 mm   | 175 mm | 10 pcs. |
| 80360043 | 2.4 mm   | 175 mm | 10 pcs. |
| 80360044 | 3.2 mm   | 175 mm | 10 pcs. |

### Tungsten Electrode WL20 - Blue

#### Classification according to EN ISO 6848: WLA20

Tungsten electrode containing 2% lanthanum oxide. Applicable for DC welding of mild steel and stainless steel and AC/DC welding of aluminium.

| Art. no. | Diameter | Length | Packing |
|----------|----------|--------|---------|
| 80360092 | 1.6 mm   | 175 mm | 10 pcs. |
| 80360094 | 2.4 mm   | 175 mm | 10 pcs. |
| 80360095 | 3.2 mm   | 175 mm | 10 pcs. |

### Tungsten Electrode WS2 - Super Blue

#### Classification according to EN ISO 6848: WG

Migatronic top-quality allround tungsten electrode. Applicable for DC and AC/DC welding of all materials. Fine ignition properties and stable arc provide pure welding and long service life.

| Art. no. | Diameter | Length | Packing |
|----------|----------|--------|---------|
| 80361371 | 1.0 mm   | 175 mm | 10 pcs. |
| 80361372 | 1.6 mm   | 175 mm | 10 pcs. |
| 80361373 | 2.0 mm   | 175 mm | 10 pcs. |
| 80361374 | 2.4 mm   | 175 mm | 10 pcs. |
| 80361376 | 3.2 mm   | 175 mm | 10 pcs. |
| 80361377 | 4.0 mm   | 175 mm | 10 pcs. |
| 80361378 | 4.8 mm   | 175 mm | 10 pcs. |

### Tungsten Electrode WL20 - Blue - Pointed 20 degrees

#### Classification according to EN ISO 6848: WLA20

Tungsten electrode for plasma welding.

| Art. no. | Diameter | Length | Packing |
|----------|----------|--------|---------|
| 80361396 | 4.8 mm   | 91 mm  | 1 pcs.  |
| 80361397 | 4.8 mm   | 111 mm | 1 pcs.  |

## MMA CONSUMABLES

### Basic / Rutile-coated electrodes

#### MIGA R 100 Rutile-coated electrode

**Classification according to** EN ISO 2560-A: E 42 0 RC 11  
AWS A5.1: E6013

Rutile-coated electrode with rapid-hardening slag, which makes it ideal for all welding positions. Allround electrode applicable for welding in mild steel. Fine ignition properties.

| Art. no. | Diameter | Length | Packing              | Welding positions |
|----------|----------|--------|----------------------|-------------------|
| 81331025 | 2.5 mm   | 350 mm | 5 kg                 | All               |
| 81331032 | 3.2 mm   | 350 mm | 5 kg                 | All               |
| 81331040 | 4.0 mm   | 350 mm | 5 kg                 | All               |
| 81351025 | 2.5 mm   | 350 mm | Blister with 14 pcs. | All               |
| 81351032 | 3.2 mm   | 350 mm | Blister with 9 pcs.  | All               |

#### MIGA B 120 Basic electrode

**Classification according to** EN ISO 2560-A: E 42 4 B 4 2 H5  
AWS A5.1: E7018-1H4

Basic high-yield electrode with good impact strength down to -50°C and low hydrogen content. Applicable for mechanically weight-carrying joints and other complicated structures.

| Art. no. | Diameter | Length | Packing              | Welding positions               |
|----------|----------|--------|----------------------|---------------------------------|
| 81431325 | 2.5 mm   | 350 mm | 5 kg                 | All but vertical downwards (PG) |
| 81431332 | 3.2 mm   | 350 mm | 5 kg                 | All but vertical downwards (PG) |
| 81431432 | 3.2 mm   | 450 mm | 6.7 kg               | All but vertical downwards (PG) |
| 81451325 | 2.5 mm   | 350 mm | Blister with 14 pcs. | All but vertical downwards (PG) |
| 81451332 | 3.2 mm   | 350 mm | Blister with 8 pcs.  | All but vertical downwards (PG) |

## Basic / Rutile-coated electrodes

| MIGA NI Nickel electrode  |          |  |                      |                   |
|---|----------|--|----------------------|-------------------|
| <b>Classification according to</b>  |          | <b>ENiFE-CL<br/>AWS A5.11: E Ni C1</b> |                      |                   |
| Graphited nickel-alloyed electrode. Applicable for repair and maintenance in cast iron, such as pump casings, bedplates, engine blocks. Subsequent finishing is possible. |          |  |                      |                   |
| Art. no.  | Diameter | Length                                 | Packing              | Welding positions |
| 81351125  | 2.5 mm   | 300 mm                                 | Blister with 11 pcs. | All               |
| 81351132  | 3.25 mm  | 350 mm                                 | Blister with 9 pcs.  | All               |

| MIGA 600B Hardfacing  |          |  |                     |                                  |
|---|----------|--|---------------------|----------------------------------|
| <b>Classification according to</b>  |          | <b>EN ISO 14700: E FE 4<br/>AWS A5.11: DIN 8585-83</b> |                     |                                  |
| Basic electrode for hardfacing. Applicable for rebuilding surfaces of heavily worn construction equipment shovels and the like. |          |  |                     |                                  |
| Art. no.  | Diameter | Length   | Packing             | Welding positions                |
| 81351232  | 3.25 mm  | 450 mm   | Blister with 8 pcs. | Flat (PA) and horizontal FW (PB) |

| RB86   |          |   |         |                                 |
|--|----------|---|---------|---------------------------------|
| <b>Classification according to</b>   |          | <b>EN ISO 2560-A: E 42 2 B 12 H10<br/>AWS A5.11: E 7016</b> |         |                                 |
| Double-coated basic-rutile electrode for carbon and carbon-manganese steel with tensile strength up to 510MPa. Applicable for maintenance and dirty work-pieces. |          |   |         |                                 |
| Art. no.   | Diameter | Length  | Packing | Welding positions               |
| 81430325   | 2.5 mm   | 350 mm  | 2 kg    | All but vertical downwards (PG) |
| 81430332   | 3.2 mm   | 350 mm  | 2 kg    | All but vertical downwards (PG) |

## Stainless electrodes

| 316L Stainless electrode  |          |  |                      |                   |
|---|----------|--|----------------------|-------------------|
| <b>Classification according to</b>  |          | <b>EN ISO 3581-A: E 19 12 3 LR<br/>AWS A5.4: E 316L-16</b> |                      |                   |
| Rutile electrode with low carbon content. Applicable for welding of austenitic stainless steel with application temperature up to 400°C. Acid-proof welding metal with good corrosion-resistance. |          |  |                      |                   |
| Art. no.  | Diameter | Length   | Packing              | Welding positions |
| 81351320  | 2.0 mm   | 350 mm   | Blister with 12 pcs. | All               |
| 81351325  | 2.5 mm   | 350 mm   | Blister with 10 pcs. | All               |
| 81351332  | 3.2 mm   | 350 mm   | Blister with 8 pcs.  | All               |

## Gouging

| Gouging electrode DC            |          |        |         |
|---------------------------------|----------|--------|---------|
| Gouging electrodes for cutting. |          |        |         |
| Art. no.                        | Diameter | Length | Packing |
| 81899005                        | 5.0 mm   | 305 mm | 50 pcs. |
| 81899006                        | 6.0 mm   | 305 mm | 50 pcs. |
| 81899008                        | 8.0 mm   | 305 mm | 50 pcs. |
| 81899010                        | 9.5 mm   | 305 mm | 50 pcs. |
| 81899013                        | 12.7 mm  | 305 mm | 50 pcs. |

## BACKING MATERIAL

### Aluminium tape for backing

Aluminium tape for fixation of ceramic backing.

| Art. no. | Packing                 |
|----------|-------------------------|
| 81790102 | 1 roll, thickness: 100µ |

### Ceramic backing on tape

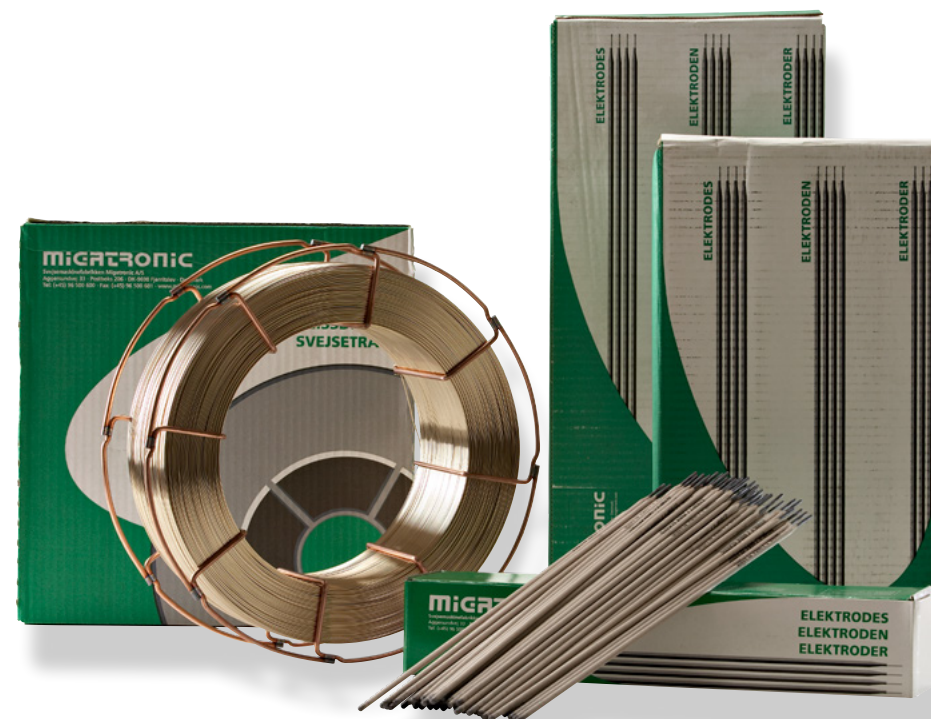
Ceramic backing ensures high-quality root passes with an even weld profile. Applicable for thick materials as support for root passes.

| Art. no. | Packing |  |
|----------|---------|--|
| 81791005 | 60      | Ceramic backing on tape 026-2410 U 6T 600        |
| 81791073 | 60      | Ceramic backing sloping 600 mm on aluminium tape |
| 81791077 | 60      | Ceramic backing 1C42-CEX600 mm on aluminium tape |
| 81791090 | 60      | Ceramic backing 1B93A25/600 mm on aluminium tape |
| 81792007 | 120     | Ceramic backing ø7x600 mm on aluminium tape      |
| 81792009 | 100     | Ceramic backing ø9x600 mm on aluminium tape      |
| 81792012 | 90      | Ceramic backing ø12x600 mm on aluminium tape     |
| 81792015 | 70      | Ceramic backing ø15x500 mm on aluminium tape     |

### Magnet for ceramic backing

Magnet for fixation of ceramic backing.

| Art. no. |                            |
|----------|----------------------------|
| 81792102 | Magnet for ceramic backing |



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