

Thermanit сварочные присадочные материалы

Для сварки нержавеющей сталей / литых сталей и никелевых сплавов

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту		Химический состав %								
			EN / EN ISO •	AWS A...	C	Si	Mn	Cr	Ni	Mo	Другие		
A	SAW	1.4576	12072	S 19 12 3 Nb	5.9	≈ ER318	≤0.05	0.6	1.7	19.5	11.5	2.8	Nb >12xC
A Si	GMAW	1.4576	12072	G 19 12 3 Nb Si	5.9	≈ ER318	≤0.05	0.8	1.5	19.0	12.0	2.8	Nb >12xC
A Si	GTAW	1.4576	12072	W 19 12 3 Nb	5.9	≈ ER318	≤0.05	0.8	1.5	19.0	12.0	2.8	Nb >12xC
AW	SMAW	1.4576	1600	E 19 12 3 Nb R 32	5.4	E318-17	<0.03	<0.9	0.8	19.0	12.0	2.8	Nb >10xC
GE - 316L	SAW	1.4430	12072	S 19 12 3 L	5.9	ER316L	0.02	0.6	1.7	18.5	12.2	2.8	
GE - 316L Si	GMAW	1.4430	12072	G 19 12 3 L Si	5.9	ER316LSi	0.02	0.8	1.7	18.8	12.5	2.8	
GE - 316L Si	GTAW	1.4430	12072	W 19 12 3 L	5.9	ER316L	0.02	0.5	1.7	18.5	12.3	2.8	
GEW 316L-17	SMAW	1.4430	1600	E 19 12 3 L R 32	5.4	E316L-17	≤0.04	<0.9	0.8	19.0	12.5	2.8	
H 347	SAW	1.4551	12072	S 19 9 Nb	5.9	ER347	≤0.06	≤0.6	1.8	19.5	9.5	–	Nb ≥12xC
H 347 Si	GTAW	1.4551	12072	W 19 9 Nb	5.9	ER347	0.05	0.5	1.8	19.5	9.5	–	Nb >12xC
H Si	GMAW	1.4551	12072	G 19 9 Nb Si	5.9	ER347Si	0.06	0.8	1.5	19.5	9.5	–	Nb >12xC
HW	SMAW	1.4551	1600	E 19 9 Nb R 32	5.4	E347-17	<0.07	<0.9	0.8	19.5	10.0	–	Nb >10xC
JE - 308L	SAW	1.4316	12072	S 19 9 L	5.9	ER308L	0.02	0.6	1.8	20.0	9.8	–	
JE - 308L Si	GMAW	1.4316	12072	G 19 9 L Si	5.9	ER308LSi	0.02	0.9	1.7	20.0	10.0	–	
JE - 308L Si	GTAW	1.4316	12072	W 19 9 L	5.9	ER308L	0.02	0.5	1.7	20.0	10.0	–	
JEW 308L-17	SMAW	1.4316	1600	E 19 9 L R 32	5.4	E308L-17	<0.04	<0.9	0.8	19.5	9.5	–	
Nicro 182	SMAW	2.4620	• 14172	E Ni 6182 (NiCr15Fe6Mn)	5.11	ENiCrFe-3	≤0.05	<0.5	6.5	16.0	Bal.	–	Nb = 2.0; Fe = <6.0
Nicro 82	SMAW	2.4648	• 14172	E Ni 6082 (NiCr20Mn3Nb)	5.11	≈ ENiCrFe-3	<0.05	0.4	4.0	19.5	Bal.	–	Nb = 2.0; Fe = <4.0
Nicro 82	GTAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Nb = 2.5; Fe = <2.0
Nicro 82	GMAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Nb = 2.5; Fe = <2.0
Nicro 82	SAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	3.2	20.5	Bal.	–	Nb = 2.6; Fe = <2.0
Nimo C 24	SMAW	2.4609	• 14172	E Ni 6059 (NiCr23Mo16)	5.11	ENiCrMo-13	<0.02	0.1	<0.5	23.0	Bal.	16.0	Fe = <1.5
Nimo C 24	GTAW	2.4607	• 18274	S Ni 6059 (NiCr23Mo16)	5.14	ERNiCrMo-13	0.01	0.1	<0.5	23.0	Bal.	16.0	Fe = <1.5
Nimo C 24	GMAW	2.4607	• 18274	S Ni 6059 (NiCr23Mo16)	5.14	ERNiCrMo-13	0.01	0.1	<0.5	23.0	Bal.	16.0	Fe = <1.5
X	SMAW	1.4370	1600	E 18 8 Mn B 22	5.4	≈ E307-15	0.10	0.6	7.0	18.5	8.0	–	N = 0.12
X	GTAW	1.4370	12072	W 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	
X	GMAW	1.4370	12072	G 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	
X	SAW	1.4370	12072	S 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	
XW	SMAW	1.4370	1600	E 18 8 Mn R 12	5.4	≈ E307-16	0.10	0.6	7.0	18.5	8.0	–	N = 0.08

Thermanit сварочные присадочные материалы

Для сварки жаропрочных сталей / литых сталей и сплавов

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
C	SMAW	1.4842	1600	E 25 20 B 22	5.4	≈ E310-15	0.13	1.0	2.5	25.0	20.0	–	
CW 310-16	SMAW	1.4842	1600	E 25 20 R 12	5.4	E310-16	0.10	0.5	2.0	26.0	21.0	–	
C Si	GTAW	1.4842	12072	W 25 20 Mn	5.9	≈ ER310	0.13	1.0	3.0	24.5	20.5	–	
C Si	GMAW	1.4842	12072	G 25 20 Mn	5.9	≈ ER310	0.13	1.0	2.2	25.0	20.0	–	
CR	SMAW	≈1.4846	(1600)	E 25 20 H B 22	5.4	≈ E310H-15	0.40	1.0	2.5	25.5	21.5	–	
CR	GTAW	1.4846	12072	W 25 20 H	5.9	≈ ER 310	0.45	1.0	1.5	25.5	21.5	–	
D	SMAW	1.4829	1600	E 22 12 B 22	5.4	≈ E309-15	0.11	1.0	0.9	22.5	11.0	–	
DW	SMAW	1.4829	1600	E 22 12 R 32	5.4	E309-17	0.11	0.9	0.8	22.5	12.5	–	
D	GTAW	1.4829	12072	W 22 12 H	5.9	≈ ER309	0.11	1.2	1.2	22.0	11.0	–	
D	GMAW	1.4829	12072	G 22 12 H	5.9	≈ ER309	0.11	1.2	1.2	22.0	11.0	–	
Nicro 82	SMAW	2.4648	• 14172	E Ni 6082 (NiCr20Mn3Nb)	5.11	≈ ENiCrFe-3	< 0.05	< 0.4	4.0	19.5	Bal.	–	Fe = <4.0; Nb = 2.0
Nicro 82	GTAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.01	0.1	3.0	20.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 82	GMAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.01	0.1	3.0	20.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 82	SAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.01	0.1	3.0	20.5	Bal.	–	Fe = <2.0; Nb = 2.6
X	SMAW	1.4370	1600	E 18 8 Mn B 22	5.4	≈ E307-15	0.10	0.6	7.0	18.5	8.0	–	N = 0.12
XW	SMAW	1.4370	1600	E 18 8 Mn R 12	5.4	≈ E307-16	0.10	0.6	7.0	18.5	8.0	–	N = 0.08
X	GTAW	1.4370	12072	W 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	
X	GMAW	1.4370	12072	G 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	
X	SAW	1.4370	12072	S 18 8 Mn	5.9	≈ ER307	0.08	0.8	7.0	19.0	9.0	–	

Thermanit сварочные присадочные материалы

Для сварки нержавеющей сталей / литых сталей и никелевых сплавов

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
18/17 E	GTAW	≈1.4440	12072	W 18 16 5 N L	5.9	≈ER317L	0.03	0.3	3.4	18.5	17.5	4.5	
18/17 E	GMAW	≈1.4440	12072	G 18 16 5 N L	5.9	≈ER317L	0.03	0.3	3.4	18.5	17.5	4.5	
19/15 H	GMAW	1.4455	12076	G 20 16 3 Mn N L	5.9	≈ER316L	0.03	0.5	7.5	20.5	15.5	3.0	N = 0.18
19/15 H	SMAW	1.4455	1600	E 20 16 3 Mn N L B 22	–	–	<0.04	<0.5	6.0	20.0	16.5	3.0	N = 0.18
19/15 H	GTAW	1.4455	12072	W 20 16 3 Mn N L	5.9	≈ER316L	0.03	0.5	7.5	20.5	15.5	3.0	N = 0.18
20/10 W	SMAW	1.4431	1600	E 20 10 3 R 32	5.4	≈E308Mo-17	0.05	0.9	1.0	20.0	10.5	3.3	
20/25 CuW	SMAW	1.4519	1600	E 20 25 5 Cu N L R 32	5.4	E385-16	<0.03	<0.7	1.3	20.0	25.0	4.5	Cu = 1.5
20/25 Cu	GTAW	1.4519	12072	W 20 25 5 Cu L	5.9	ER385	≤0.025	0.2	2.5	20.5	25.0	4.8	Cu = 1.5
20/25 Cu	GMAW	1.4519	12072	G 20 25 5 Cu L	5.9	ER385	≤0.025	0.2	2.5	20.5	25.0	4.8	Cu = 1.5
22/09 W	SMAW	≈1.4462	1600	E 22 9 3 N L R 32	5.4	E2209-17	<0.04	<0.9	0.9	22.5	9.0	3.0	N = 0.15
22/09	GTAW	≈1.4462	12072	W 22 9 3 N L	5.9	ER2209	0.02	0.5	1.6	23.0	9.0	3.0	N = 0.14
22/09	GMAW	≈1.4462	12072	G 22 9 3 N L	5.9	ER2209	0.02	0.5	1.6	23.0	9.0	3.0	N = 0.14
22/09	SAW	1.4462	12072	S 22 9 3 N L	5.9	ER2209	≤0.02	0.5	1.6	23.0	9.0	3.0	N = 0.14
25/09 CuT	SMAW	≈1.4501	1600	E 25 9 4 N L B 22	5.4	≈E2553-15	<0.03	0.8	1.4	25.0	9.0	4.0	Cu=0.7;W=0.6;N=0.2
25/09 CuT	GMAW	≈1.4501	12072	G 25 9 4 N L	5.9	≈ER2553	0.02	0.3	1.5	25.5	9.5	3.7	Cu=0.8;W=0.6;N=0.2
25/09 CuT	GTAW	≈1.4501	12072	W 25 9 4 N L	5.9	≈ER2553	0.02	0.3	1.5	25.5	9.5	3.7	Cu=0.8;W=0.6;N=0.2
25/09 CuW	SMAW	≈1.4501	1600	EZ 25 9 3 Cu N L R 12	5.4	≈E2553-15	0.02	0.7	0.9	25.0	9.0	3.0	Cu=2.0;N=0.1
25/14 EW 309L-17	SMAW	1.4332	1600	E 23 12 L R 32	5.4	E309L-17	<0.04	<0.9	0.8	24.5	13.0	–	
25/14 E-309L	GMAW	1.4332	12072	G 23 12 L	5.9	ER309L	0.03	0.9	2.0	24.0	13.0	–	
25/14 E-309L Si	GTAW	1.4332	12072	W 23 12 L	5.9	ER309L	0.03	0.5	2.0	24.0	13.0	–	
25/14 E-309L	SAW	1.4332	12072	S 23 12 L	5.9	ER309L	0.02	0.6	1.8	24.0	13.2	–	
25/22 H	SMAW	≈1.4465	1600	E 25 22 2 N L B 22	–	–	<0.035	<0.4	5.0	24.5	22.0	2.2	N = 0.15
25/22 H	GTAW	1.4465	12072	W 25 22 2 L	5.9	≈ER310	0.025	0.2	6.0	25.0	22.5	2.2	N = 0.13
30/10 W	SMAW	1.4337	1600	E 29 9 R 12	5.4	≈E312-16	0.10	1.1	0.8	29.0	9.0	–	N = 0.10
30/10	GMAW	1.4337	17072	G 29 9	5.9	ER312	0.15	0.5	1.6	30.0	9.0	–	
30/40 EV	SMAW	2.4653	• 14172	E Ni 8025 (NiCr29Fe30Mo)	–	–	<0.03	<0.9	1.5	28.0	36.0	4.3	Cu = 1.8
30/40 E	GTAW	2.4656	• 18274	S Ni 8025 (NiFe30Cr29Mo)	5.9	≈ER383	0.02	0.2	2.6	29.0	36.0	4.3	Cu = 1.8
625	SMAW	2.4621	• 14172	E Ni 6625 (NiCr22Mo9Nb)	5.11	ENiCrMo-3	<0.04	0.7	<1.0	21.5	Bal.	9.5	Fe = <2.0; Nb = 3.3
625	GTAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Fe = 1.5; Nb = 3.6
625	GMAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Fe = <1.5; Nb = 3.6
625	SAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	<0.2	0.2	22.0	Bal.	9.0	Fe = <1.5; Nb = 3.6

Thermanit сварочные присадочные материалы

Для сварки аустенитно-ферритных соединений

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
Nicro 82	SMAW	2.4648	• 14172	E Ni 6082 (NiCr20Mn3Nb)	5.11	≈ENiCrFe-3	<0.05	<0.4	4.0	19.5	Bal.	–	Fe = <4.0; Nb = 2.0
Nicro 82	GTAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 82	GMAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 182	SMAW	2.4620	• 14172	E Ni 6182 (NiCr15Fe6Mn)	5.11	ENiCrFe-3	<0.05	<0.5	6.5	16.0	Bal.	–	Fe = <6.0; Nb = 2.0
X	SMAW	1.4370	1600	E 18 8 Mn B 22	5.4	≈E307-15	0.10	0.6	7.0	18.5	8.0	–	N = 0.12
X	GTAW	1.4370	17072	W 18 8 Mn	5.9	≈ER307	0.08	0.8	7.0	19.0	9.0	–	
X	GMAW	1.4370	17072	G 18 8 Mn	5.9	≈ER307	0.08	0.8	7.0	19.0	9.0	–	
18/17 E	GTAW	1.4440	17072	W 18 16 5 N L	5.9	≈ER317L	≤0.03	0.3	3.4	18.5	17.5	4.5	
25/14 EVW309L-17	SMAW	1.4332	1600	E 23 12 L R 32	5.4	E309L-17	≤ 0.04	<0.9	0.8	24.5	13.0	–	
25/14 E309L Si	GTAW	1.4332	17072	W 23 12 L	5.9	ER309L	≤ 0.03	0.5	2.0	24.0	13.0	–	
30/10 W	SMAW	1.4337	1600	E 29 9 R 12	5.4	≈E312-16	0.10	1.1	0.8	29.0	9.0	–	N = 0.1

Для сварки промежуточных / буферных слоев

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
18/17 E	GTAW	1.4440	12072	W 18 16 5 N L	5.9	≈ER317L	0.03	0.3	3.4	18.5	17.5	4.5	N = 0.15
25/14 EW 309L-17	SMAW	1.4332	1600	E 23 12 L R 32	5.4	E309L-17	<0.04	<0.9	0.8	24.5	13.0	–	
25/14 E-309L Si	GTAW	1.4332	12072	W 23 12 L	5.9	ER309L	0.03	0.5	2.0	24.0	13.0	–	

Для сварки высокохромистых ферритных сталей

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
409 Сб	GMAW	~1.4009	12072	G Z13 Nb L	5.9	ER409Cb	≤ 0.05	0.6	0.6	11.5	–	–	Nb = ≥10 × C
430L Сб	GMAW	1.4511	12072	G Z18 Nb L	5.9	ER430 (mod.)	≤ 0.02	0.5	0.5	18.0	–	–	Nb = >12 × C
1610 Si	GMAW	1.4502	12072	G Z17Ti	5.9	~ER430	0.065	1.0	0.6	17.5	–	–	Ti = >8 × C
439 Ti	GMAW	~1.4009	12072	G Z18Ti L	–	–	≤ 0.03	0.8	0.8	18.0	–	–	Ti = ≤12 × C

Thermanit сварочные присадочные материалы

Для сварки низкотемпературных сталей / литых сталей

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
JEW 308L-17	SMAW	1.4316	1600	E 19 9 L R 32	5.4	E308L-17	<0.04	<0.9	0.8	19.5	9.5	–	
JE-308L Si	GTAW	1.4316	12072	W 19 9 L	5.9	ER308L	0.02	0.5	1.7	20.0	10.0	–	
JE-308L Si	GMAW	1.4316	12072	G 19 9 L Si	5.9	ER308LSi	0.02	0.9	1.7	20.0	10.0	–	
JE-308L	SAW	1.4316	12072	S 19 9 L	5.9	ER308L	0.02	0.6	1.8	20.0	10.0	–	
Nicro 82	SMAW	2.4648	• 14172	E Ni 6082 (NiCr20Mn3Nb)	5.11	≈ENiCrFe-3	<0.05	<0.4	4.0	19.5	Bal.	–	Fe = <4.0; Nb = 2.0
Nicro 82	GTAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 82	GMAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe = <2.0; Nb = 2.5
Nicro 182	SMAW	2.4620	• 14172	E Ni 6182 (NiCr15Fe6Mn)	5.11	ENiCrFe-3	<0.05	<0.5	6.5	16.0	Bal.	–	Fe = <6.0; Nb = 2.0
19/15 H	SMAW	1.4455	1600	E 20 16 3 Mn N L B 22	–	–	<0.04	<0.5	6.0	20.0	16.5	3.0	N = 0.18
19/15 H	GTAW	1.4455	12072	W 20 16 3 Mn N L	5.9	≈ER316L	0.03	0.5	7.5	20.5	15.5	3.0	N = 0.18
625	SMAW	2.4621	• 14172	E Ni 6625 (NiCr22Mo9Nb)	5.11	ENiCrMo-3	<0.04	<0.7	<1.0	21.5	Bal.	9.5	Nb = 3.3; Fe = <2.0
625	GTAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb = 3.6; Fe = 1.5
625	GMAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb = 3.6; Fe = <1.5
625	SAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb = 3.6; Fe = <1.5

Для сварки немагнитных сталей (AMAGNIT) / литых сталей

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
18/17 E	GTAW	1.4440	12072	W 18 16 5 N L	5.9	≈ER317L	0.03	0.3	3.4	18.5	17.5	4.5	N = 0.15
18/17 E	GMAW	1.4440	12072	G 18 16 5 N L	5.9	≈ER317L	0.03	0.3	3.4	18.5	17.5	4.5	N = 0.15
19/15 H	SMAW	1.4455	1600	E 20 16 3 Mn N L B 22	–	–	<0.04	<0.5	6.0	20.0	16.5	3.0	N = 0.18
19/15 H	GTAW	1.4455	12072	W 20 16 3 Mn L	5.9	≈ER316L	0.03	0.5	7.5	20.5	15.5	3.0	N = 0.18

Thermanit сварочные присадочные материалы

Для сварки высоколегированных жаропрочных сталей /
литых сталей и никелевых сплавов

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту			Химический состав %							
			EN / EN ISO •	AWS A...	C	Si	Mn	Cr	Ni	Mo	Другие		
ATS 4	GTAW	1.4948	12072	W 19 9 H	5.9	≈ER308H	0.05	0.3	1.8	18.8	9.3	–	
ATS 4	GMAW	1.4948	12072	G 19 9 H	5.9	≈ER308H	0.05	0.3	1.8	18.8	9.3	–	
ATS 4	SAW	1.4948	12072	S 19 9 H	5.9	≈ER308H	<0.05	<0.5	1.6	18.8	9.3	–	
Chromo 9V	SMAW	–	1599	E CrMo 9 I B 42 H 5	5.5	E9015-B9	0.09	0.2	0.6	9.0	0.8	1.1	V=0.2; Nb=0.05
Chromo T 91	SMAW	–	1599	E CrMo 9 I B 42 H 5	5.5	E9015-B9	0.09	0.2	0.6	9.0	0.8	1.1	V=0.2; Nb=0.05
MTS 3	SMAW	1.4903	1599	E CrMo 9 I B 42 H 5	5.5	E9015-B9	0.09	0.2	0.6	9.0	0.8	1.1	V=0.2; Nb=0.05
MTS 3	GTAW	1.4903	12070	W Cr Mo 91	5.28	ER90S-B9	0.10	0.3	0.5	9.0	0.7	1.0	V=0.2; Nb=0.06
MTS 3	SAW	1.4903	12070	S Cr Mo 91	5.23	ER90S-B9	0.10	0.3	0.5	9.0	0.7	1.0	V=0.2; Nb=0.06
MTS 616	SMAW	–	1599	EZ CrMoWVNb 9 0.5 2 B 42 H5	5.5	E9015-G	0.11	0.25	0.6	8.8	0.7	0.5	W=1.6; V=0.2; Nb=0.05
MTS 616	GTAW	–	12070	WZ CrMoWVNb 9 0.5 1.5	5.28	ER90S-G	0.1	0.38	0.45	8.8	0.6	0.4	W=1.6; V=0.2; Nb=0.06; N=0.04
MTS 616	GMAW	–	12070	GZ CrMoWVNb 9 0.5 1.5	5.28	ER90S-G	0.1	0.38	0.45	8.8	0.6	0.4	W=1.6; V=0.2; Nb=0.06; N=0.04
MTS 616	SAW	–	12070	SZ CrMoWVNb 9 0.5 1.5	5.23	EG	0.1	0.38	0.45	8.8	0.6	0.4	W=1.6; V=0.2; Nb=0.06; N=0.04
Nicro 82	SMAW	2.4648	• 14172	E Ni 6082 (NiCr20Mn3Nb)	5.11	≈ENiCrFe-3	<0.05	<0.4	4.0	19.5	Bal.	–	Fe=<4.0; Nb=2.0
Nicro 82	GTAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe=<2.0; Nb=2.5
Nicro 82	GMAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	0.02	0.2	2.8	19.5	Bal.	–	Fe=<2.0; Nb=2.5
Nicro 82	SAW	2.4806	• 18274	S Ni 6082 (NiCr20Mn3Nb)	5.14	ERNiCr-3	≤0.02	<0.2	3.2	20.5	Bal.	–	Fe=<2.0; Nb=2.6
617	SMAW	2.4628	• 14172	E Ni 6617 (NiCr22Co12Mo)	5.11	≈ENiCrCoMo-I	<0.08	0.7	<0.5	21.0	Bal.	9.0	Al=1.0; Ti=0.5; Co=12.0
617	GTAW	2.4627	• 18274	S Ni 6617 (NiCr22Co12Mo9)	5.14	ERNiCrCoMo-I	0.05	0.2	0.2	21.0	Bal.	9.0	Al=1.0; Ti=0.5; Co=12.0; Fe=2.8
617	GMAW	2.4627	• 18274	S Ni 6617 (NiCr22Co12Mo9)	5.14	ERNiCrCoMo-I	0.05	0.2	0.2	21.0	Bal.	9.0	Al=1.0; Ti=0.5; Co=12.0; Fe=2.0
625	SMAW	2.4621	• 14172	E Ni 6625 (NiCr22Mo9Nb)	5.11	ENiCrMo-3	0.03	0.7	<1.0	21.5	Bal.	9.5	Nb=3.3; Fe=<2.0
625	GTAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb=3.6; Fe=<1.5
625	GMAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb=3.6; Fe=<1.5
625	SAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Nb=3.6; Fe=<1.5

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Thermanit сварочные присадочные материалы

Для сварки жаропрочных сталей / литых сталей и сплавов

Thermanit	Вид-сварки	W.-Nr.	Обозначение по стандарту				Химический состав %						
			EN / EN ISO •		AWS A...		C	Si	Mn	Cr	Ni	Mo	Другие
21/33	SMAW	≈1.4850	1600	EZ 21 33 Nb B 22	–	–	0.15	0.4	2.8	22.0	33.0	–	Nb = 1.2
21/33	GTAW	≈1.4850	12072	WZ 21 33 Nb	–	–	0.20	0.2	2.3	22.0	33.0	–	Nb = 1.7
21/33	GMAW	≈1.4850	12072	GZ 21 33 Nb	–	–	0.20	0.2	2.3	22.0	33.0	–	Nb = 1.7
21/33 So	SMAW	≈1.4850	1600	EZ 21 33 Mn Nb B 22	–	–	0.12	0.2	4.6	21.0	32.0	–	Nb = 1.2
21/33 So	GTAW	≈1.4850	12072	WZ 21 33 Mn Nb	–	–	0.12	0.2	4.8	22.0	33.0	–	Nb = 1.2
25/35 R	SMAW	1.4853	1600	EZ 25 35 Nb B 22	–	–	0.40	1.0	1.8	25.0	35.0	–	Nb = 1.3
25/35 R	GTAW	1.4853	12072	WZ 25 35	–	–	0.42	1.0	1.7	26.0	35.0	–	Nb = 1.3
25/35 R	GMAW	1.4853	12072	GZ 25 35	–	–	0.42	1.2	1.8	26.0	35.0	–	Nb = 1.3
35/45 Nb	SMAW	–	• 14172	E Ni Z (NiCr36Fe7Nb0,8)	–	–	0.45	1.4	1.0	35.0	49.5	–	Nb = 0.8
35/45 Nb	GTAW	–	12072	WZ 35 45 Nb H	–	–	0.40	1.5	1.0	35.0	45.0	–	Nb = 0.8
35/45 Nb	GMAW	–	12072	GZ 35 45 Nb H	–	–	0.40	1.5	1.0	35.0	45.0	–	Nb = 0.8
617	SMAW	2.4628	• 14172	E Ni 6617 (NiCr22Co12Mo)	5.11	≈ENiCrCoMo-I	≤0.08	0.7	<0.5	21.0	Bal.	9.0	Co = 12.0; Al = 1.0; Ti = 0.5
617	GTAW	2.4627	• 18274	S Ni 6617 (NiCr22Co12Mo9)	5.14	ERNiCrCoMo-I	≤0.05	0.1	0.1	21.0	Bal.	9.0	Co = 11.0; Al = 1.0; Ti = 0.4; Fe = 2.0
617	GMAW	2.4627	• 18274	S Ni 6617 (NiCr22Co12Mo9)	5.14	ERNiCrCoMo-I	≤0.05	0.2	0.2	21.0	Bal.	9.0	Co = 12.0; Al = 1.0; Ti = 0.5; Fe = 2.0
625	SMAW	2.4621	• 14172	E Ni 6617 (NiCr22Co12Mo)	5.11	≈ENiCrMo-3	<0.04	<0.7	<1.0	21.5	Bal.	9.5	Fe = <0.2; Nb = 3.3
625	GTAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Fe = 1.5; Nb = 3.6
625	GMAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Fe = <1.5; Nb = 3.6
625	SAW	2.4831	• 18274	S Ni 6625 (NiCr22Mo9Nb)	5.14	ERNiCrMo-3	0.03	0.2	0.2	22.0	Bal.	9.0	Fe = <1.5; Nb = 3.6

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