

|                                                   |  |  | Fülldraht-<br>elektroden                 |                       |   |   |   |   |   | Draht-Pulver-<br>Kombinationen (UP) |   |   |   |   |   |  |
|---------------------------------------------------|--|--|------------------------------------------|-----------------------|---|---|---|---|---|-------------------------------------|---|---|---|---|---|--|
| Werkstoffnummer                                   |  |  | -                                        | T 50 6 1Ni P M21 1 H5 |   |   |   |   |   | SA FB 1 55 AC H5                    |   |   |   |   |   |  |
| Typ / Kurzzeichen                                 |  |  | T 19 9 L R M21 3 / T19 9 L R C1 3        |                       |   |   |   |   |   | S 46 6 FB S3Si                      |   |   |   |   |   |  |
|                                                   |  |  | T 19 9 L P M21 2                         |                       |   |   |   |   |   | S 50 6 S3Ni1Mo0,2                   |   |   |   |   |   |  |
|                                                   |  |  | T 199 L M M21 2                          |                       |   |   |   |   |   | S 55 6 FB S3Ni1Mo                   |   |   |   |   |   |  |
|                                                   |  |  | T 19 12 3 L R M21 3 / T 19 12 3 L R C1 3 |                       |   |   |   |   |   | S 46 7 FB S2Ni2                     |   |   |   |   |   |  |
|                                                   |  |  | T 19 12 3 L P M21 2                      |                       |   |   |   |   |   | S 46 8 FB S2Ni3                     |   |   |   |   |   |  |
|                                                   |  |  | T 19 12 3 L M M21 2                      |                       |   |   |   |   |   | SA AF 2 DC                          |   |   |   |   |   |  |
|                                                   |  |  | T Ni 6625 P M21 2                        |                       |   |   |   |   |   | S 19 9 L                            |   |   |   |   |   |  |
| Schweißzusatz                                     |  |  | OK Tubrod 15,30                          |                       |   |   |   |   |   | S 19 12 3 L                         |   |   |   |   |   |  |
|                                                   |  |  | Shield-Bright 316L X-Ira                 |                       |   |   |   |   |   | SA AF 2 DC                          |   |   |   |   |   |  |
|                                                   |  |  | Shield-Bright 316L                       |                       |   |   |   |   |   | S Ni 6625 (NiCr22Mo9Nb)             |   |   |   |   |   |  |
|                                                   |  |  | OK Tubrod 15,31                          |                       |   |   |   |   |   | S Ni 6276 (NiCr15Mo16Fe6W4)         |   |   |   |   |   |  |
|                                                   |  |  | Shield-Bright NiCrMo-3                   |                       |   |   |   |   |   | S Ni 6059 (NiCr23Mo16)              |   |   |   |   |   |  |
|                                                   |  |  | OK Flux 10,62                            |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 12,32                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
| Beschreibung<br>Abschnitt / Seite                 |  |  | OK Autrod 13,24                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 13,40                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 13,27                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 13,49                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Flux 10,93                            |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 308L                           |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod 316L                           |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
| Tiefste Einsatz-<br>temperatur °C<br>ungeschweißt |  |  | OK Flux 10,90                            |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod NiCrMo-3                       |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod NiCrMo-4                       |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  | OK Autrod NiCrMo-13                      |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
| Tiefste Einsatz-<br>temperatur °C<br>geschweißt   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
|                                                   |  |  |                                          |                       |   |   |   |   |   |                                     |   |   |   |   |   |  |
| 1.8869                                            |  |  | P355QL2                                  | -60                   | ● |   |   |   |   |                                     |   |   |   |   |   |  |
| 1.8864                                            |  |  | P460QL2                                  | -60                   | ● |   |   |   | ● | ●                                   | ● |   |   |   |   |  |
| 1.8916                                            |  |  | S460QL1                                  | -60                   | ● |   |   |   | ● | ●                                   | ● | ● |   |   |   |  |
| 1.6212                                            |  |  | 11MnNi5-3                                | -60                   | ● |   |   |   | ● | ●                                   | ● | ● |   |   |   |  |
| 1.6217                                            |  |  | 13MnNi6-3                                | -60                   | ● |   |   |   | ● | ●                                   | ● | ● |   |   |   |  |
| 1.5636                                            |  |  | G9Ni10                                   | -70                   |   |   |   |   |   | ●                                   | ● | ● |   |   |   |  |
| 1.6228                                            |  |  | 15NiMn6                                  | -80                   |   |   |   |   |   | ●                                   | ● | ● |   |   |   |  |
| 1.5638                                            |  |  | G9Ni15                                   | -90                   |   |   |   |   |   | ○                                   | ● | ● |   |   |   |  |
| 1.5637                                            |  |  | 12Ni14                                   | -105                  |   |   |   |   |   |                                     | ● |   |   |   |   |  |
| 1.5680                                            |  |  | X12Ni5                                   | -120                  |   |   |   |   |   |                                     |   |   |   | ● | ● |  |
| 1.5662                                            |  |  | X8Ni9                                    | -200                  |   |   |   |   |   |                                     |   |   |   | ● | ● |  |
| 1.5663                                            |  |  | X7Ni9                                    | -200                  |   |   |   |   |   |                                     |   |   |   | ● | ● |  |
| 1.5682                                            |  |  | X10Ni9                                   | -200                  |   |   |   |   |   |                                     |   |   |   | ● | ● |  |
| 1.4301                                            |  |  | X5CrNi18-10                              | -200                  |   | ● | ● | ● | ● | ○                                   | ○ |   |   | ● | ● |  |
| 1.4306                                            |  |  | X2CrNi19-11                              | -270                  |   | ● | ● | ● | ● | ○                                   | ○ |   | ● | ● | ● |  |
| 1.4311                                            |  |  | X2CrNiN18-10                             | -270                  |   | ● | ● | ● | ● | ○                                   | ○ |   | ● | ● | ● |  |
| 1.4401                                            |  |  | X5CrNiMo17-12-2                          | -200                  |   |   |   |   |   | ●                                   | ● | ● | ● | ● | ● |  |
| 1.4404                                            |  |  | X2CrNiMo17-12-2                          | -200                  |   |   |   |   |   | ●                                   | ● | ● | ● | ● | ● |  |
| 1.4406                                            |  |  | X2CrNiMoN17-11-2                         | -270                  |   |   |   |   |   | ●                                   | ● | ● | ● | ● | ● |  |
| 1.4429                                            |  |  | X2CrNiMoN17-13-3                         | -270                  |   |   |   |   |   | ●                                   | ● | ● | ● | ● | ● |  |
| 1.4541                                            |  |  | X8CrNiTi18-10                            | -270                  |   | ● | ● | ● | ○ | ○                                   | ○ |   | ● | ● | ● |  |
| 1.4571                                            |  |  | X6CrNiMoTi17-12-2                        | -270                  |   |   |   | ● | ● | ●                                   | ● |   | ● | ● | ● |  |

- = sehr gut geeigneter Schweißzusatz; Einsatzbereich und erforderlichen Zulassungsumfang beachten
- = bedingt geeigneter Schweißzusatz, Einsatzbereich im Bedarfsfall erfragen;  
Einsatztemperatur und erforderlichen Zulassungsumfang beachten