

1. COATED ELECTRODES FOR MANUAL WELDING

Coated electrodes for welding non-alloyed and fine-grain steels



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST 6012 (RED) General-purpose electrode for welding steel constructions, in particular small-sized with thin walls. Recommended for welding in forced positions, including up-down. Applied for plants of low striking voltage $U_0 > 42V$. Rutile-cellulose coating.	PN-EN 2560-A-E: E 38 0 RC 11 AWS A5.1: E 6012			R_e [N/mm ²]=360 R_m [N/mm ²]=440-550 $A_5=22\%$ $KV=47$ J (0°C)	C=0,08 Si=0,3 Mn=0,5		2 mm: 06 30 601220 2,5 mm: 06 30 601225 3,25 mm: 06 30 601232 4 mm: 06 30 601240 5 mm: 06 30 601250
MOST 6013 (PINK) General-purpose medium coated rutile electrode for welding steel constructions open to static and dynamic load (steel or building constructions, rolling stocks). Recommended for assembly works. Has very good welding properties. Rutile coating.	PN-EN ISO 2560: E 38 0R 12 AWS A5.1: E 6013			R_e [N/mm ²]=355 R_m [N/mm ²]=410-570 $A_5=22\%$ $KV=47$ J (0°C)	C=0,09 Si=0,2 Mn=0,4	ABS, LR, GL, DNV, BV	2,5 mm: 06 30 601325 3,25 mm: 06 30 601332 4 mm: 06 30 601340 5 mm: 06 30 601350
MOST 346 (6020)(BLACK) Rutile-acid thick-coated electrode for welding steel of increased strength, boilers, containers and pipelines. Rutile-acidic coating.	PN-EN 2560-A-E: E 38 2 RA 13 AWS A5.1: E 6020			R_e [N/mm ²]=360 R_m [N/mm ²]=450-550 $A_5=24\%$ $KV=47$ J (0°C)	C=0,08 Si=0,2 Mn=0,6		2 mm: 06 30 602020 2,5 mm: 06 30 602025 3,25 mm: 06 30 602032 4 mm: 06 30 602040 5 mm: 06 30 602050
MOST 246 (GREEN) Thick-coated for welding steel constructions statically and dynamically loaded (ship constructions, rolling stocks, building machinery, etc.). Recommended for welding containers and pipelines. Rutile-basic coating.	PN-EN 2560-A-E: E 35 2 RB 12 AWS A5.1: E 6013			R_e [N/mm ²]=360 R_m [N/mm ²]=440-540 $A_5=24\%$ $KV=47$ J (0°C)	C=0,1 Si=0,2 Mn=0,5		2 mm: 06 30 624620 2,5 mm: 06 30 624625 3,25 mm: 06 30 624632 4 mm: 06 30 624640 5 mm: 06 30 624650
MOST 7018 (ORANGE) Basic coating electrode with very good welding parameters. Recommended for welding of constructions steel and other materials with higher resistance especially in shipyard industry, machine-building, rail-way construction. Excellent parameters in welding constructions with dynamic load.	PN-EN ISO 2560: E 42 4B 32H5 AWS A5.1: E 7018			R_e [N/mm ²]>420 R_m [N/mm ²]>500-540 $A_5>20\%$ $KV>47$ J (-40°C)	C = 0,08 Si = 0,5 Mn = 1,0	ABS, LR, GL, DNV, BV	2,5 mm: 3,25 mm: 4 mm: 5 mm: 6 mm:

Coated electrodes for welding high-alloyed steels



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST 20/10 BC Electrode for welding high-alloyed steels of grades 18 Cr and 8 Ni. Rutile coating.	PN-EN 1600: E 19 9 L R AWS A5.4: E 308 L-16 Werkstoff nr: 1.4316			R_e [N/mm ²]>360 R_m [N/mm ²]>540-610 $A_5>32\%$ $KV>80$ J (20°C)	C<0,03; Si<0,9 Ni=9-11 Mn=0,9 Cr=18-21 FN=8		2,0 mm: 07 25 601202 2,5 mm: 07 25 601252 3,2 mm: 07 25 601325 4,0 mm: 07 25 601403 5,0 mm: 07 25 601503
MOST INOX 347 Electrodes with content of Nb or Ti for welding high-alloyed steels. Rutile coating.	PN-EN 1600: E 19 9 Nb R AWS A5.4: E 347-16 Werkstoff nr: 1.4551			R_e [N/mm ²]>350 R_m [N/mm ²]>550-610 $A_5>30\%$ $KV>60$ J (20°C)	C<0,03; Si<0,9 Ni=9-11; Mn=0,8 Cr=18-21 Nb=0,3 FN=8		2,0 mm: 07 25 604202 2,5 mm: 07 25 604252 3,2 mm: 07 25 604323 4,0 mm: 07 25 604403 5,0 mm: 07 25 604503



Coated electrodes for welding high-alloyed steels

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST 20/10 MBC Electrode with content of Mo for welding high-alloyed steels of grades 18 Cr, 8 Ni, 3 Mo. Rutile coating.	PN-EN 1600: E 19 12 3 L R AWS A5.4: E 316 L - 16 Werkstoff nr: 1.4430			R_e [N/mm ²] >400 R_m [N/mm ²] >560-650 A_5 >32% KV >70 J (20°C)	C < 0,03; Si < 0,9 Ni = 11-13 Mn = 0,85 Cr = 18-20 Mo = 2,5-3 FN = 8		1,6 mm: 07 25 605161 2,0 mm: 07 25 605202 2,5 mm: 07 25 605252 3,2 mm: 07 25 605323 4,0 mm: 07 25 605403 5,0 mm: 07 25 605503
MOST 316 HR High capacity electrode for welding high-alloyed steels of grades 316 - 18Cr / 8Ni / 3Mo. Rutile coating.	PN-EN 1600: E 19 12 3 L R AWS A5.4: E 316 L - 16 Werkstoff nr: 1.4430			R_e [N/mm ²] >400 R_m [N/mm ²] >560 A_5 >32% KV >60 J (20°C)	C < 0,04; Si < 0,9 Ni = 11-13; Mn = 0,85 Cr = 18-20 Mo = 2,5-3 FN = 8		1,6 mm: 07 25 607161 2,0 mm: 07 25 607203 2,5 mm: 07 25 607253 3,2 mm: 07 25 607323 4,0 mm: 07 25 607405
MOST INOX 318 Electrodes designed for high-alloyed steels of grade 318 with addition of Nb or Ti. Rutile coating.	PN-EN 1600: E 19 12 3 Nb R AWS A5.4: E 318 - 16 Werkstoff nr: 1.4576			R_e [N/mm ²] >350 R_m [N/mm ²] >550-610 A_5 >30% KV >70 J (+20°C)	C < 0,03; Si < 0,75 Ni = 12-14 Nb = 0,3 Cr = 17-20 Mo = 2,5-3		2,0 mm: 07 25 609202 2,5 mm: 07 25 609252 3,2 mm: 07 25 609323 4,0 mm: 07 25 609403 5,0 mm: 07 25 609503
MOST 25/20 B Electrode for welding heat-resistant steels (1150°C) of grade 310. Rutile coating.	PN-EN 1600: E 25 20 B AWS A5.4: E 310 - 15 Werkstoff nr: 1.4842			R_e [N/mm ²] >400 R_m [N/mm ²] >550 A_5 >30% KV >70 J (20°C)	C < 0,1 Si < 0,5 Ni = 19-21 Mn = 2,5 Cr = 24-26		2,0 mm: 07 25 612202 2,5 mm: 07 25 612252 3,2 mm: 07 25 612323 4,0 mm: 07 25 612403 5,0 mm: 07 25 612503
MOST 29/9 Special-purpose electrode for hard-to-weld steel joints and joints of materials of different poles. Rutile coating.	PN-EN 1600: E 29 9 R AWS A5.4: E 312 - 16 Werkstoff nr: 1.4337			R_e [N/mm ²] >500 R_m [N/mm ²] >700-800 A_5 >20% Hardness: 240 HB	C = 0,1 Si = 0,9-1,2 Ni = 8-10 Mn = 1,0 Cr = 28-30 Mo = 0,5		2,0 mm: 07 25 614202 2,5 mm: 07 25 614252 3,2 mm: 07 25 614323 4,0 mm: 07 25 614403 5,0 mm: 07 25 614503
MOST 24/12 S Electrode with low C content for welding high-alloyed steels of grade 309 L and joints of materials of different poles. Rutile coating.	PN-EN 1600: E 23 12 L R AWS A5.4: E 309 L - 16 Werkstoff nr: 1.4332			R_e [N/mm ²] = 400 R_m [N/mm ²] = 550-660 A_5 >35% KV >60 J (20°C)	C < 0,03; Si < 0,8 Ni = 12-13 Mn = 1,0 Cr = 23-24 Fe = 15		2,0 mm: 07 25 618202 2,5 mm: 07 25 618252 3,2 mm: 07 25 618323 4,0 mm: 07 25 618403 5,0 mm: 07 25 618503
MOST 24/12 Mo Electrode with low C content for welding high-alloyed steels of grade 309 L and joints of materials of different poles. Brings austenitic filler metal. Rutile coating.	PN-EN 1600: E 23 12 L R AWS A5.4: E 309 L Mo - 16 Werkstoff nr: 1.4332 Mo			R_e [N/mm ²] >450 R_m [N/mm ²] = 580-680 A_5 >35% KV >60 J (20°C)	C = 0,03; Si = 0,8 Ni = 12-13 Mn = 0,9 Cr = 22-23 Mo = 2,3-3		2,0 mm: 07 25 620202 2,5 mm: 07 25 620252 3,2 mm: 07 25 620323 4,0 mm: 07 25 620403 5,0 mm: 07 25 620503
MOST 18/8 Mn High capacity (160%) electrode for welding and pad welding high-alloyed steels of increased content of Mn. Rutile coating.	PN-EN 1600: E 18 8 Mn R AWS A5.4: E 307 - 16 Werkstoff nr: 1.4370			R_e [N/mm ²] >400 R_m [N/mm ²] = 600-690 A_5 >30% KV >75 J (20°C)	C < 0,1 Si = 0,8 Ni = 8-10 Mn = 6,0 Cr = 19-21		2,5 mm: 07 25 621253 3,2 mm: 07 25 621323 4,0 mm: 07 25 621405
MOST 307 R Electrode for welding and pad welding of stainless steels of increased content of Mn. Rutile coating.	PN-EN 1600: E 18 8 Mn R AWS A5.4: ~E 307 - 16 Werkstoff nr: 1.4370			R_e [N/mm ²] >400 R_m [N/mm ²] >600 A_5 >30% KV >80 J (20°C)	C = 0,1 Si = 1,2 Mn = 4,5 Cr = 18,0 Ni = 8,0		2,5 mm: 07 25 622252 3,2 mm: 07 25 622323 4,0 mm: 07 25 622403
MOST 307 B Electrodes for welding and pad welding and regeneration of stainless steels of increased content of Mn. Basic coating.	PN-EN 1600: E 18 8 B AWS A5.4: ~E 307 - 15 Werkstoff nr: 1.4370			R_e [N/mm ²] >400 R_m [N/mm ²] = 600-750 A_5 >35% KV >90 J (20°C)	C = 0,1 Si = 0,4 Ni = 8,0 Mn = 6,0 Cr = 18,0		2,5 mm: 07 25 623252 3,2 mm: 07 25 623323 4,0 mm: 07 25 623403 5,0 mm: 07 25 623503

MOST INOX 308 B Electrode for welding stainless steels of grade 18/8. Basic coating.	PN-EN 1600: E 19 9 L B AWS A5.4: E 308 L - 15 Werkstoff nr: 1.4316			R_e [N/mm ²] >380 R_m [N/mm ²] =560 A_5 >35% KV >90 J (20°C) >30 J (-196°C)	C <0,04 Si =0,4 Mn =1,6 Cr =19,0 Ni =9,5 FN = -8	2,5 mm: 07 25 602252 3,2 mm: 07 25 602323 4,0 mm: 07 25 602403
MOST 308 HR High capacity (160%) electrode for welding stainless steels of grade 308L. Rutile coating.	PN-EN 1600: E 19 9 L R AWS A5.4: E 308 L - 26 Werkstoff nr: 1.4316			R_e [N/mm ²] >360 R_m [N/mm ²] >550 A_5 >35% KV =60 J (20°C)	C <0,04; Si =0,9 Mn =0,7 Cr =19,0 Ni =9,5 FN =5	2,0 mm: 07 25 603203 2,5 mm: 07 25 603253 3,2 mm: 07 25 603323 4,0 mm: 07 25 603405
MOST INOX 316 B Electrode for welding and regeneration of Cr/Ni/Mo stainless steels of grade 316L. Basic coating.	PN-EN 1600: E 19 12 3 L B AWS A5.4: E 316 L - 15 Werkstoff nr: 1.4430			R_e [N/mm ²] ≥380 R_m [N/mm ²] ≥560 A_5 ≥35% KV >80 J (+20°C) >50 J (-120°C)	C <0,04; Si =0,4 Mn =1,6 Cr =18,0 Ni =12,0 Mo =2,7 FN =8	2,5 mm: 07 25 606252 3,2 mm: 07 25 606323 4,0 mm: 07 25 606403
MOST 316 VD Electrode for welding and regeneration of Cr/Ni/Mo stainless steels, also in vertical-downwards position. Rutile-basic coating.	PN-EN 1600: E 19 12 3 L R AWS A5.4: E 316 L - 16 Werkstoff nr: 1.4430			R_e [N/mm ²] >400 R_m [N/mm ²] >560 A_5 >30% KV >60 J (20°C)	C <0,03; Mn =0,7 Si =0,8 Ni =11,5 Cr =18,0 Mo =2,5	2,0 mm: 07 25 608202 2,5 mm: 07 25 608252 3,2 mm: 07 25 608323
MOST 309 HR High capacity (160%) electrodes for making buffer layers. Designed for welding steels of various chemical compositions. Rutile coating.	PN-EN 1600: E 23 12 R AWS A5.4: E 309 - 26 Werkstoff nr: 1.4332			R_e [N/mm ²] >400 R_m [N/mm ²] >560 A_5 >35% KV >50 J (20°C)	C <0,04 Si =0,9 Mn =0,7 Cr =22,5 Ni =12,5	2,0 mm: 07 25 619203 2,5 mm: 07 25 619253 3,2 mm: 07 25 619323 4,0 mm: 07 25 619405
MOST 25/20 R Electrode for welding heat-resistant steels (1200°C). Rutile coating.	PN-EN 1600: E 25 20 LR AWS A5.4: E 310 - 16 Werkstoff nr: 1.4842			R_e [N/mm ²] >400 R_m [N/mm ²] >550 A_5 >30% KV >60 J (20°C)	C =0,01 Si =0,9 Mn =2,0 Cr =25,5 Ni =20,5	2,0 mm: 07 25 613202 2,5 mm: 07 25 613252 3,2 mm: 07 25 613323 4,0 mm: 07 25 613403 5,0 mm: 07 25 613503
MOST 312 HR High capacity electrode (160%) for welding, regeneration and pad welding of stainless steels. Provides high crack-resistant of a joint. Rutile coating.	PN-EN 1600: E 29 9 R AWS A5.4: ~E 312 - 26 Werkstoff nr: 1.4337			R_e [N/mm ²] >550 R_m [N/mm ²] >700 A_5 >25% Hardness: 240 HB	C =0,06; Si =1,1 Mn =1,0; Cr =26,5 Ni =9,5 Mo =0,2 Fe =rest	2,5 mm: 07 25 615253 3,2 mm: 07 25 615323 4,0 mm: 07 25 615405
MOST INOX 13/4 Electrodes for pad welding and martensitic regeneration of Cr/Ni steels and casts. Post-welding heat treatment at 580°C for 8 h. Basic coating.	PN-EN 1600: E 13 4 B AWS A5.4: E 410 NiMo - 15 Werkstoff nr: 1.4351			R_e [N/mm ²] >630 R_m [N/mm ²] >830 A_5 >15% KV >50 J (20°C)	C =0,04; Si =0,3 Mn =0,6; Cr =12,0 Ni =4,2 Mo =0,5 Fe =rest	2,5 mm: 07 25 610253 3,2 mm: 07 25 610323 4,0 mm: 07 25 610405
MOST INOX 17/4 Mo Electrode for welding, pad welding and regeneration of stainless steel, type 17Cr/5Ni/1Mo. Post-welding heat treatment at 580°C for 8 h. Basic coating.	PN-EN 1600 Z 16 5 1 B			R_e [N/mm ²] >550 R_m [N/mm ²] >700 A_5 >25% KV >40 J (20°C)	C =0,04; Si =0,3 Mn =0,6; Cr =16,0 Ni =5,0 Mo =1,0 Fe =rest	2,5 mm: 07 25 611252 3,2 mm: 07 25 611323 4,0 mm: 07 25 611405
MOST INOX 385 Electrode for welding steels according to PN-EN 100 88: x1 CrNiMo N 25-25-2, x2 NiCrMoCu 25-20-5. Rutile coating.	PN-EN 1600: E 20 25 LC R AWS A5.4: E 385 - 16 Werkstoff nr: 1.4519			R_e [N/mm ²] >370 R_m [N/mm ²] >570 A_5 >35% KV >70 J (20°C)	C <0,03; Si =0,8 Mn =1,4; Cr =20,5 Ni =25,0; Cu =1,5 Mo =4,5 Fe =rest	2,5 mm: 07 25 624252 3,2 mm: 07 25 624323 4,0 mm: 07 25 624403
MOST INOX 2209 Electrode for welding and regeneration of stainless steels of Duplex type. Rutile coating.	PN-EN 1600: E 29 9 3 L R AWS A5.4: E 2209 - 17 Werkstoff nr: 1.4462			R_e [N/mm ²] >540 R_m [N/mm ²] >680 A_5 >35% KV >50 J (20°C) >37 J (-40°C)	C <0,03; Si =0,9 Mn =0,9; Cr =22,5 Ni =9,0 Mo =3,0 N =0,18 Fe =rest	2,5 mm: 07 25 625252 3,2 mm: 07 25 625323 4,0 mm: 07 25 625403



Coated electrodes for pad welding and regeneration

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL-HARD 300 Undercoat layer at hardening pad welding of heavy elements. Abrasion- and stroke-resistant. Padding weld is mechanically workable. <i>Applications: rolls, rails, blades, wheels, bearing journals etc.</i>	DIN 8555: E 1-UM-300-P			Hardness: 275-325 HB	C=0,2 Mn=1,5 Mo=0,6 V=0,2		3,2 mm: 05 51 100032 4,0 mm: 05 51 100040 5,0 mm: 05 51 100050
MOST EL-HARD 350 Reconstruction and pad welding of elements open to abrasive wear and strokes. Non cracked padding, mechanically workable. <i>Applications: wheels, parts of earth-working machines, chain runners, etc.</i>	DIN 8555: E 1-UM-350-P			Hardness: 350-400 HB	C=0,1 Mn=1,0 Cr=3,0		3,2 mm: 05 51 100132 4,0 mm: 05 51 100140 5,0 mm: 05 51 100150
MOST Mn/Cr Electrode of high manganese and chromium content, increased resistance to abrasion and cavitation. Gets hardened under influence of cold work. Can be applied as a undercoat layer for hardening pad welding of elements open to stresses. <i>Applications: mining, quarries (crushers), railway engineering (turnouts and scissors crossovers).</i>	DIN 8555: E 7-UM-200-500-KP			Hardness: 250 HB (after pad welding); 55 HRC (after cold work)	C=0,7 Mn=17,0 Cr=14,0		2,5 mm: 05 51 071925 3,2 mm: 05 51 071932 4,0 mm: 05 51 071940 5,0 mm: 05 51 071950
MOST EL-HARD 600 Abrasion- and stroke-resistant padding weld, mechanically unworkable. <i>Applications: earth-working machinery, steel and forge industry, gears of gearwheels, breakers, crusher jaws, etc.</i>	DIN 8555: E 6-UM-60			Hardness: 58-61 HRC	C=0,5 Mn=0,4 Cr=9,0 Mo=1,0 V=1,5		3,2 mm: 05 51 100332 4,0 mm: 05 51 100340 5,0 mm: 05 51 100350
MOST EL-HARD 63 Perfectly abrasion-resistant padding weld, additionally resistant to moderate strokes. <i>Applications: crushing and abrasive machinery, concrete montejeses, displacing presses worms, ploughshares etc.</i>	DIN 8555: E 10-UM-60 GR			Hardness: 61-63 HRC	C=4,5 Cr=34,0		3,2 mm: 05 51 101032 4,0 mm: 05 51 101040 5,0 mm: 05 51 101050
MOST EL-HARD 64 Resistant to mineral abrasive wear and moderate strokes padding weld. Besides chromium carbide padding weld contains inclusions of Mo, Nb, W and V carbides, which increase abrasion-resistance at high temperatures. <i>Applications: valves, mixers, firmers, worms of conveyors and presses, disk rippers, minerals crushers, etc.</i>	DIN 8555: E 10-UM-65 Z			Hardness: 63-65 HRC; 45 HRC (400°C)	C=5,0 Cr=22,0 Mo=3,5 V=1,0 W=2,0 Nb=3,5		3,2 mm: 05 51 101132 4,0 mm: 05 51 101140 5,0 mm: 05 51 101150
MOST EL-HARD 70 Resistant to extreme abrasive wear and moderate strokes at high temperatures padding weld. Content of boron increases abrasion-resistance. <i>Applications: rollers, chutes, crushers, sieves, platform augers, etc.</i>	DIN 8555: E 10-UM-70 GRZC			Hardness: 66-67 HRC; 60 HRC (600°C)	C=5,0 Cr=38,0 B=3,5		3,2 mm: 05 51 102032 4,0 mm: 05 51 102040 5,0 mm: 05 51 102050
MOST HRT 68 Core electrode for pad welding elements open to extreme abrasive wear and strokes. Maximal hardness is achieved after first layer. <i>Applications: crushers, mixers, sieves, pumps, platform augers, agriculture equipment, etc.</i>				Hardness: 64-68 HRC	C=5,5 Cr=22,0 W=25,0		6,0 mm: 07 53 120603
MOST Lastek 211 High efficient electrode with a core of carbides sintered in special-purpose coating, which guarantees thin and smooth padding weld of extraordinary resistance to abrasive wear. Single electrode (ø4,0 mm) will cover an area of ca. 10000 mm² at continuous pad welding for ca. 6 minutes. <i>Applications: screw conveyors, mixers blades, ploughshares, concrete industry, mining, etc.</i>							3,0 mm: 05 58 030530 4,0 mm: 05 58 030540



















MOST EL-TOOL 47 Regeneration and pad welding hot-working tools. Padding weld is mechanically workable. <i>Applications: drop forging dies, pressure moulds, mandrels, etc.</i>	DIN 8555: E 3-UM-50 T			Hardness: 48–50 HRC; after tempering 50–52 HRC	C=0,25 Mn=0,8 Cr=2,5 W=4,5 V=0,6		2,5 mm: 05 51 080325 3,2 mm: 05 51 080332 4,0 mm: 05 51 080340 5,0 mm: 05 51 080350
MOST EL-TOOL 55 Resistant to abrasive wear of metal-to-metal character padding weld, mainly designed for regeneration of cold-working tools. Workable only by means of grinding. <i>Applications: cutting edges, dies, etc.</i>	DIN 8555: E 2-UM-55			Hardness: 55 HRC	C=0,25 Cr=2,6 Ni=1,0 Mo=0,4 Mn=1,0		3,2 mm: 05 51 080232 4,0 mm: 05 51 080240 5,0 mm: 05 51 080250
MOST EL-TOOL 62 Padding weld, resistant to metal-to-metal abrasive wear combined with strokes. Regeneration and pad welding of high-speed steel. <i>Applications: tools for cutting, scrapers, punching and trimming tools, moulds, extruding dies, shears, milling cutters, shapes, tools for wood-working, dies, etc.</i>	DIN 8555: E 4-UM-60 T			Hardness: 59–62 HRC; after tempering 62–65 HRC	C=0,9 Cr=4,5 Mo=8,0 V=1,5 W=2,0		2,5 mm: 05 51 080425 3,2 mm: 05 51 080432 4,0 mm: 05 51 080440 5,0 mm: 05 51 080450
MOST Alloy Co Regeneration and pad welding of cold and hot working tools. Padding weld is cold-work hardenable. Efficiency: 170%. <i>Applications: drop forging dies, shears, knives, pumps sealing, hot-cutting and hot-piercing tools, etc.</i>	DIN 8555: E 23-UM-250 CNKPTZ			Hardness: 220 HB; after hardening 400 HB	C=0,06; Cr=16,5 W=4,5; Mo=17,0 Fe<7,0 Co=2,5 Ni-rest		2,5 mm: 05 51 081525 3,2 mm: 05 51 081532 4,0 mm: 05 51 081540 5,0 mm: 05 51 081550
MOST EL-Co 1 Cobalt-based electrode. Padding weld resistant to extreme metal-to-metal abrasive wear up to 950°C. <i>Applications: holes, shafts, pumps, rolls, cutting blades, etc.</i>	DIN 8555: E 20-UM-55 CTZ			Hardness: 53–58 HRC (20°C); 42–45 HRC (600°C)	C=2,5; Si=1,0 Ni=max 2,5 Fe=max 2,5; Mn=1,0 Cr=33,0; W=12,0 Co-rest		3,2 mm: 05 53 100432 4,0 mm: 05 53 100440 5,0 mm: 05 53 100450
MOST EL-Co 6 Cobalt-based electrode. Padding weld resistant to extreme metal-to-metal abrasive wear and pressure up to temperature of 950°C. Very good resistance to thermal and mechanical shocks. <i>Applications: hot-cutting blades, rolls, industrial fittings, engine valves, hot working tools, etc.</i>	DIN 8555: E 20-UM-45 CRTZ			Hardness: 40–45 HRC (20°C); 30 HRC (600°C)	C=1,1; Si=1,0 Ni=max 3,0 Fe=max 2,5; Mn=1,0 Cr=28,0; W=5,0 Co-rest		2,5 mm: 05 53 100525 3,2 mm: 05 53 100532 4,0 mm: 05 53 100540 5,0 mm: 05 53 100550
MOST EL-Co 12 Cobalt-based electrode. Padding weld resistant to extreme abrasive wear up to temperature of 900°C. <i>Applications: extruder dies, saw blades, runners, etc.</i>	DIN 8555: E 20-UM-50 CTZ			Hardness: 49–51 HRC (20°C); 38–40 HRC (600°C)	C=1,8; Si=1,0 Ni=max 2,5 Fe=max 2,5; Mn=1,0 Cr=29,0; W=9,0 Co-rest		3,2 mm: 05 53 100632 4,0 mm: 05 53 100640 5,0 mm: 05 53 100650
MOST EL-Co 21 Cobalt-based electrode. Padding weld resistant to extreme metal-to-metal abrasive wear and pressure up to temperature of 950°C. Padding weld is stroke-hardening. <i>Application: Tools for both hot and cold forging and shaping, parts of gas turbines, etc.</i>	DIN 8555: E 20-UM-350 CKTZ			Hardness: 32–38 HRC (20°C); 38–40 HRC (600°C); 42–45 HRC (after cold work)	C=0,25; Si=1,0 Ni=2,5; Fe=max 3,0 Mn=1,0; Mo=5,5 Cr=27,0 Co-rest		3,2 mm: 05 53 100732 4,0 mm: 05 53 100740 5,0 mm: 05 53 100750
MOST EL-4370 Undercoat for cold-hardening pad welding. Material for joints of different poles. Padding weld is resistant to corrosion and temperatures up to 850°C.	DIN 8555: E 18 8 Mn R 26			Hardness: after cold work up to 350 HB A ₅ >35%	C=0,1; Mn=6,0 Si=0,9 Cr=19,0 Ni=9,0		2,5 mm: 05 53 014425 3,2 mm: 05 53 014432 4,0 mm: 05 53 014440 5,0 mm: 05 53 014450
MOST EL-29/9 Electrode providing austenitic-ferrite padding metal designed for welding carbon steels and steels which chemical composition is not known. Welding steels of different poles (corrosion-resistant with low-carbon steels) and hard-to-weld steels (manganese, spring and tool steels, etc). Padding weld perfectly resistant to cracking and acids influence. Can be used as an undercoat for hardening pad welding.	DIN 8555: E 29 9 R 23			Hardness: after cold work up to 430 HB A ₅ >20%	C=0,1 Mn=1,0 Si=0,9 Cr=29,0 Ni=9,0		2,0 mm: 05 53 040320 2,5 mm: 05 53 040325 3,2 mm: 05 53 040332 4,0 mm: 05 53 040340 5,0 mm: 05 53 040350
MOST EL-182 Electrode for repairing and joining nickel alloys. Used for joining monomial and of different poles materials at temperature between –196°C and 550°C (e.g. stainless steel – low-alloy steel, stainless steel – nickel alloys) and for hard-to-weld steels. Padding metal is resistant to cracking, acid- salt- and hydroxide-solutions, and to fused salts in oxidising and carbonising atmospheres. Undercoat layer for hardening pad welding. <i>Applications: welding of heat-resisting plates in cement industry, furnaces elements, torches, moulds, tanks, storage and transportation of liquid gases, glass, chemical and petrochemical industry, etc.</i>	DIN 8555: EL-NiCr 16 FeMn			A ₅ >35%	C<0,05; Si=0,6 Mn=6,0 Cr=16,0 Nb=2,0 Mo=1,0 Ni = >65,0		2,5 mm: 05 51 060125 3,2 mm: 05 51 060132 4,0 mm: 05 51 060140 5,0 mm: 05 51 060150



Coated electrodes for welding cast iron

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST FONTE Ni-2 Nickel electrode for welding, regeneration and pad welding of grey cast iron. Basic coating.	AWS A5.15: E Ni-CI DIN 8573: E Ni BG 12			R_m [N/mm ²] >300 Hardness: ~180 HB	C=1,0 Si<1,2 Fe<2,0 Ni>95		2,5 mm: 07 26 702253 3,2 mm: 07 26 702323 4,0 mm: 07 26 702403
MOST Fe-Ni/Cu Electrode made of iron-nickel alloy for welding, regeneration and pad welding of all types of cast iron. Basic coating.	AWS A5.15: E NiFe-CI DIN 8573: E Ni Fe-1BG13			R_m [N/mm ²] >400 Hardness: ~200 HB	C=1,1; Si=1,5 Fe – rest Ni=53 Cu=6		2,5 mm: 07 26 703253 3,2 mm: 07 26 703323 4,0 mm: 07 26 703403
MOST BIMETAL NiFe Electrode for welding, regeneration and pad welding of cast iron. Graphite-basic coating.	AWS A5.15: E NiFe-CI DIN 8573: E NiFe-1 BG 21			R_e [N/mm ²] >300 R_m [N/mm ²] >450–550 A_5 >15% Hardness: ~220 HB	C=1,0 Si<1,5 Fe – rest Ni=55 Mn<1,0		2,5 mm: 07 26 705253 3,2 mm: 07 26 705323 4,0 mm: 07 26 705403
MOST FONTE Fe Electrode for welding, regeneration and pad welding of old and contaminated cast iron. Mechanical working only by grinding.	AWS A5.15: ESt DIN 8573: E Fe-1			Hardness: ~350 HB	C=0,13 Si=0,9 Fe – rest Mn=0,5		2,5 mm: 07 26 706253 3,2 mm: 07 26 706323 4,0 mm: 07 26 706405
MOST FONTE - Ni Electrode made of pure Ni for welding, regeneration and pad welding of cast iron. Graphite-basic coating.	AWS A5.15: E Ni-CI DIN 8573: E Ni BG 13			R_e [N/mm ²] >200 R_m [N/mm ²] >300–400 Hardness: 150 HB	C<1,0; Si<2,0 Fe<2,0 Ni – rest (95% min.) Mn<1,0		2,5 mm: 07 26 701253 3,2 mm: 07 26 701323 4,0 mm: 07 26 701403 5,0 mm: 07 26 701505
MOST FERRO - Ni High capacity electrode made of iron-nickel alloy for welding, regeneration and pad welding of cast iron and for welding cast iron with steel. Graphite-basic coating.	AWS A5.15: E-NiFe-CI DIN 8573: E Ni FeBG 13			R_e [N/mm ²] >300 R_m [N/mm ²] >450–550 Hardness: ~200 HB	C<1,0 Mn<1,0 Si=2,0 Ni=58–60 Fe – rest		2,5 mm: 07 26 704253 3,2 mm: 07 26 704323 4,0 mm: 07 26 704403 5,0 mm: 07 26 704503
MOST Lastek 40E Nickel electrode designed for welding grey and malleable cast iron. Enables welding cast iron which is polluted with oil or lubricant. Padding weld characterized by perfect mechanical workability, with no blowholes or crackings. Applications: cold-welding of cast iron, cracked engines blocks, pumps casings, gearwheels, valves clamping, etc.				R_m [N/mm ²] >320 A_5 >18% Hardness: 130–160 HB			2,5 mm: 05 58 040225 3,2 mm: 05 58 040232 4,0 mm: 05 58 040240
MOST Lastek 41E Iron-nickel electrode for welding grey, ductile and alloy cast iron. For higher resistance and plasticity, than nickel electrode, it is fit for executing more loaded joints. Applications: regeneration of grey and alloy cast iron, machines bases, engines blocks, gearwheels, cast iron tools, pumps, refilling of foundry defects (good consistence of colours), etc.				R_m [N/mm ²] >400 A_5 >120% Hardness: 150–180 HB			2,5 mm: 05 58 040425 3,2 mm: 05 58 040432 4,0 mm: 05 58 040440
MOST Lastek 43 An electrode enabling welding cast iron in case if nickel electrode does not bring satisfactory results. It enables obtaining smooth padding weld of a perfect fusion, even on oxidized cast iron. For absorption of carbon from cast iron the padding weld is mechanically unworkable. The electrode should be used alongside with an electrode MOST Lastek 1900 as an undercoater before welding with electrodes MOST Lastek 40E or 41E. Applications: oxidized parts of furnaces, defects repairs, undercoat layers on bad-quality cast iron, etc.				R_m [N/mm ²] >390			3,2 mm: 05 58 040632 4,0 mm: 05 58 040640

Coated electrodes for welding nickel and nickel alloys

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL-182 / MOST 182 Electrode for welding nickel alloys, hard-to-weld steels and joints. Basic coating.	AWS A5.11: E NiCrFe-3 Werkstoff nr: 2.4620 DIN 1736: EL-NiCr 16 FeMn			R_e [N/mm ²] >380 R_m [N/mm ²] >620 A_5 >35% KV >80 J (20°C) >65 J (-196°C)	C < 0,04; Si = 0,4 Mn = 6,0 Cr = 16,5 Nb = 2,0 Fe = 6,0 Ni - rest (>60)		2,5 mm: 05 51 060125 3,2 mm: 05 51 060132 4,0 mm: 05 51 060140
MOST EL-190 / MOST 190 Electrode for welding, regeneration and pad welding of alloys, Monel Cu-Ni type. High corrosion resistance. Basic coating.	AWS A5.11: E NiCu-7 Werkstoff nr: 2.4366 DIN 1736: EL-NiCu 30Mn			R_e [N/mm ²] >300 R_m [N/mm ²] >480 A_5 >30% KV >80 J (20°C)	C < 0,05; Si = 0,7 Mn = 3,2 Cu = 29,0 Ti = 0,5 Fe = 1,2 Ni - rest (>60)		2,5 mm: 05 57 110225 3,2 mm: 05 57 110232 4,0 mm: 05 57 110240
MOST EL-C 276 / MOST 276 Electrode for welding Ni-based alloys and some special-purpose stainless steels. Basic coating.	AWS A5.11: E NiCrMo-4 Werkstoff nr: 2.4887 DIN 1736: EL-NiMo 15Cr 15 W			R_e [N/mm ²] >450 R_m [N/mm ²] >720 A_5 >30% KV >70 J (20°C)	C < 0,02; Si = 0,2 Mn = 0,6; Cr = 16,5 Mo = 16,0 Fe = 5,0 Ni - rest W = 4,0		2,5 mm: 05 57 110725 3,2 mm: 05 57 110732 4,0 mm: 05 57 110740
MOST EL-625 / MOST 625 Electrode for welding corrosion-resistant nickel-based alloys. Basic coating.	AWS A5.11: E NiCrMo-3 Werkstoff nr: 2.4631 DIN 1736: EL-NiCr 20Mo9Nb			R_e [N/mm ²] >450 R_m [N/mm ²] >760 A_5 >30% KV >70 J (20°C)	C < 0,04; Si = 0,4 Mn = 0,6; Cr = 22,0 Nb = 3,4 Fe = 3,0 Ni - rest Mo = 9,0		2,5 mm: 05 57 110825 3,2 mm: 05 57 110832 4,0 mm: 05 57 110840
MOST EL-Ni Ti 3 / MOST Ni Ti 3 Electrode with 2.5% addition of Ti for welding pure nickel. Basic coating.	AWS A5.11: E Ni-1 Werkstoff nr: 2.4156 DIN 1736: EL-NiTi3			R_e [N/mm ²] >300 R_m [N/mm ²] >430 A_5 >28% KV >160 J (20°C) >130 J (-196°C)	C < 0,03 Si = 0,8 Mn = 0,3 Al = 0,3 Ti = 2,2 Ni - rest (>94)		2,5 mm: 05 57 111025 3,2 mm: 05 57 111032 4,0 mm: 05 57 111040
MOST EL-Alloy C / MOST NiC Electrode for welding and pad welding of steels operating at temperatures up to 800°C and alloys of INCONEL type.	AWS A5.11: E NiCrMo-5 Werkstoff nr: 2.4887 DIN 8555: E 23-UM-200-CKTZ DIN 1736: ELNiMo 15Cr15W			Hardness of a weld: 220 HB; after hardening: 450 HB	C = 0,1; Si = 0,8 Mn = 1,0; W = 4,0 V = 0,2; Fe = 4,5 Ni - rest Mo = 16,0 Cr = 16,0		2,5 mm: 05 57 110625 3,2 mm: 05 57 110632 4,0 mm: 05 57 110640
MOST EL-182 A / MOST B90 Inconel type electrode for welding, regeneration and pad welding of Ni-based alloys. Basic coating.	AWS A5.11: E NiCrFe-3 Werkstoff nr: 2.4807 DIN 1736: EL NiCr 15 Fe Mn			R_e [N/mm ²] >390 R_m [N/mm ²] >550 A_5 >30% KV >60 J (20°C)	C < 0,10; Si < 0,5 Mn = 7-8,5 Cr = 15-16 Nb = 1,5-2,5 Fe < 10,0 Ni - rest (>60)		2,5 mm: 05 57 110325 3,2 mm: 05 57 110332 4,0 mm: 05 57 110340 5,0 mm: 05 57 110350
MOST EL-82 Nickel based electrode designed for repairing and welding hard-to-weld steels. Padding weld resistant to high temperature and corrosion. <i>Application: castings, rolls, elements for transportation of liquid gases etc.</i>	AWS A5.11: E NiCrFe-2/MOD. DIN 1736: EL-NiCr19Nb Werkstoff nr: 2.4648			R_e [N/mm ²] >420 R_m [N/mm ²] >700 A_5 >42%	C < 0,04; Mn = 3,5; Cr = 19,0 Nb = 2,0 Fe < 4,0 Ni - rest Mo = 1,0	TÜV	2,5 mm: 05 57 110425 3,2 mm: 05 57 110432 4,0 mm: 05 57 110440
MOST B91 Electrode for nickel alloy steel in type and INCONEL 600, INCONEL 650 and others. Rutile-basic coating	AWS A5.11: E NiCrMo-3 DIN 1736: EL-NiCr20Mo9Nb			R_e [N/mm ²] >450 R_m [N/mm ²] >760 A_5 >30% Hardness: ~240 HB	C < 0,04 Si = 0,50 Mn = 0,8 Cr = 21,0 Nb = 3,3 Fe = 4,0 Mo = 8,5 Ni = rest		2,5 mm: 07 26 802253 3,2 mm: 07 26 802323 4,0 mm: 07 26 802403



Coated electrodes for welding copper and copper alloys

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST Cu 114 Electrode for welding and pad welding of copper alloys, including tin bronze.	AWS A5.6 : E Cu Sn-A DIN 1733 : EL-Cu Sn7			Hardness: ~100 HB	Sn=6,0 Mn=0,8 Cu - rest		2,5 mm: 07 28 902253 3,2 mm: 07 28 902323 4,0 mm: 07 28 902403
MOST Cu 116 Electrode for welding and regeneration of copper alloys and aluminium bronze.	AWS A5.6 : E CuAl-A2 DIN 1733 : EL-CuAl9			R_e [N/mm ²] > 180 R_m [N/mm ²] > 420 A_5 > 20% Hardness: 130 HB	Al=8,0 Fe=0,7 Mn=1,0 Cu - rest		2,5 mm: 07 28 903253 3,2 mm: 07 28 903323 4,0 mm: 07 28 903403
MOST Cu 118 Electrode for welding and pad welding of copper alloys, including aluminium bronze and cast iron.	AWS A5.6 : E CuMnNiAl Werkstoff nr: 2.1368 DIN 1733 : EL-CuMn14Al			R_e [N/mm ²] > 380 R_m [N/mm ²] > 600 A_5 > 20% Hardness: ~200 HB	Ni=2,6 Fe=2,6 Al=6,5 Mn=12,5 Cu - rest		2,5 mm: 07 28 904253 3,2 mm: 07 28 904323 4,0 mm: 07 28 904403

Coated electrodes for welding aluminium and aluminium alloys



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL - AISi 5 Electrode for repairing castings made of aluminium alloys.	AWS A5.3: E 4043 Werkstoff nr: 3.2245 DIN 1736: EL-AISi5			R_e [N/mm ²] > 70-100 R_m [N/mm ²] > 110-130 A_5 > 20% Hardness: ~60 HB	Si=5,0 Mn<0,5 Fe<0,5 Al - rest		2,5 mm: 07 29 105253 3,2 mm: 07 29 105323 4,0 mm: 07 29 105403
MOST EL - AISi 12 Electrode for repairing castings made of aluminium alloys.	DIN 1732: EL-AISi12			R_e [N/mm ²] = 80 R_m [N/mm ²] = 200 A_5 = 8%	Si = 12,0 Mn < 0,5 Fe = 0,5 Al - rest		2,5 mm: 3,25 mm: 4,0 mm: 5,0 mm:

2. WIRES AND RODS FOR MIG/MAG AND TIG WELDING

Wires and rods for welding non-alloyed and fine-grained steels



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST SG 2 Copper-coated, manganese-silicon-alloyed solid wire for the MAG welding of low-carbon steels, such as structural, boiler and ship steels, as well as fine-grained carbon-manganese steels. Can be used on high currents for spraying arc and low currents for upset metal transfer. Available packaging: K200 – plastic reel, K300 – basket spool, barrel. Shielding gas: CO ₂ , Ar+CO ₂ . Welding method: MAG.	PN-EN 440: G3 Si 1 AWS A5.18: ER70S-6 Werkstoff nr: 1.5125			Ar+20%CO ₂ : R _e [N/mm ²]=450 R _m [N/mm ²]>590 A ₅ >25% KV ≥100 J (0°C) 80 J (-20°C)	C=0,1 Si=0,9 Mn=1,5 coating Cu		0,6 mm: 11 30 170062 0,8 mm: 11 30 170073 1,0 mm: 11 30 170113 1,2 mm: 11 30 170133 1,6 mm: 11 30 170173
MOST SG 3 Copper-coated, manganese-silicon-alloyed solid wire for the MAG welding of low-carbon steels, such as structural, boiler and ship steels, as well as fine-grained carbon-manganese steels. It has higher content of Si-Mn components, which provide higher strength of weld metal and resistance to surface impurities. Available packaging: K300 – basket spool, barrel. Shielding gas: CO ₂ , Ar+CO ₂ . Welding method: MAG.	PN-EN 440: G4 Si1 AWS A5.18: ER70S-7 Werkstoff nr: 1.5130			Ar+20%CO ₂ : R _e [N/mm ²]=450 R _m [N/mm ²]=560 A ₅ >28% KV ≥80 J (-20°C)	C=0,1 Si=1,0 Mn=1,7 coating Cu		0,8 mm: 11 30 280083 1,0 mm: 11 30 280113 1,2 mm: 11 30 280133 1,6 mm: 11 30 280173
GOLD G3 Si1 Copper-coated, manganese-silicon-alloyed solid wire for the MAG welding of low-carbon steels, such as structural, boiler and ship steels, as well as fine-grained carbon-manganese steels. Can be used on high currents for spraying arc and low currents for metal transfer. Available packaging: D200, D300 – plastic spool, K300 – basket spool, barrel. Shielding gas: CO ₂ , Ar+CO ₂ . Welding method: MAG.	PN-EN 440: G3 Si1 AWS A5.18: ER70S-6 DIN 8559 SG2 Werkstoff nr: 1.5125			Ar+20%CO ₂ : R _e [N/mm ²]=490 R _m [N/mm ²]=590 A ₅ >25% KV ≥100 J (-10°C) 80 J (-20°C)	C=0,1 S=0,9 Mn=1,5 coating Cu	TUV, DB, LR, ABS, DNV, CE	1,2 mm: 11 50 170123
GOLD G4 Si1 Copper-coated, manganese-silicon-alloyed solid wire for the MAG welding of low-carbon steels, such as structural, boiler and ship steels, as well as fine-grained carbon-manganese steels. It has higher content of Si-Mn components, which provide higher strength of weld metal and resistance to surface impurities. Available packaging: K300 – basket spool, barrel. Shielding gas: CO ₂ , Ar+CO ₂ . Welding method: MAG.	PN-EN 440: G4 Si1 AWS A5.18: ER70S-7 Werkstoff no: 1.5130			Ar+20%CO ₂ . R _e [N/mm ²] = 450 R _m [N/mm ²]>560 A ₅ >28% KV≥80J (-20°C)	C=0,1 Si=1,0 Mn=1,7 coating Cu		0,8 mm: 1,0 mm: 1,2 mm: 1,6 mm

Wires and rods for welding non-alloyed and fine-grained steels

Type and description	Classification	Type and description	Classification
MOST Mo	PN-EN 440/12070: G2Mo/GMoSi; AWS A5.28: ER 80 S-G; Werkstoff no: 1.5424	MOST NiMoCr	AWS A5.28: ~ER 100 S-1
MOST NiMo	PN-EN 440: G424CG0; AWS A5.28: ~ ER 80 S-G	MOST NiMoCr90	AWS A5.28: ~ER 100 S-G
























Wires and rods for welding heat-resistant steels

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST CrMo 1 Steels designed for work at higher temperatures. Shielding gas: Ar+CO ₂ . Welding method: MAG.	PN-EN 12070: G CrMo1Si AWS A5.28:ER 80 S-G Werkstoff nr: 1.7339			Ar+CO ₂ R _e [N/mm ²] >450 R _m [N/mm ²] >500 A>20%; KV>90 J (20°C)	C=0,1 Si=0,6 Mn=1,0 Mo=0,5 Cr=1,15		1,2 mm: 11 00 41123
MOST CrMo 2 Steels designed for work at higher temperatures. Shielding gas: Ar+CO ₂ . Welding method: MAG.	PN-EN 12070: G CrMo2Si AWS A5.28:ER 90 S-G Werkstoff nr: 1.7384			Ar+CO ₂ R _e [N/mm ²] >420 R _m [N/mm ²] >520 A>20%; KV>90 J (20°C)	C=0,06 Si=0,6 Mn=1,1 Mo=1,0 Cr=2,8		1,2 mm: 11 00 412123

Wires and rods for welding high-alloyed steels





















Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST 308 L Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG	PN-EN 12072: G 19 9 L Si (W 19 9 L Si) AWS A5.9: ER 308 L Si Werkstoff nr: 1.4316	MAG TIG 		R _e [N/mm ²] >390 R _m [N/mm ²] >600 A ₅ >34% KV>120 J (20°C)	C>0,025 Si=0,4 Mn=1,8 Cr=20,0 Ni=10,0 N<0,06	TÜV	Wire diameter: 1,2 mm: 17 20 504123 Rod diameter: 2,0 mm: 17 21 504207
MOST 309 L Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 23 12 L Si (W 23 12 L Si) AWS A5.9: ER 309 L Si Werkstoff nr: 1.4332	MAG TIG 		R _e [N/mm ²] >410 R _m [N/mm ²] >600 A ₅ >41% KV>120 J (20°C)	C>0,025 Si=0,4 Mn=1,7 Cr=24,5 Ni=12,5 N<0,05		Wire diameter: 1,2 mm: 17 20 506123 Rod diameter: 2,0 mm: 17 21 506207
MOST 312 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 29 9 AWS A5.9: ER 312 Werkstoff nr: 1.4337	MAG TIG 		R _e [N/mm ²] >520 R _m [N/mm ²] >730 A ₅ >25% KV>100 J (20°C)	C=0,1 Si=0,4 Mn=1,8 Cr=30,5 Ni=9,0 Mo<0,4 Cu<0,2 N<0,06		Wire diameter: 1,2 mm: 17 20 515123 Rod diameter: 2,0 mm: 17 21 515207

MOST 410 NiMo Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 134 AWS A5.9: ER 410 NiMo Werkstoff nr: 1.4351	MAG  TIG 		R_e [N/mm ²] >600 R_m [N/mm ²] >800 A_5 >15% KV >50 J (20°C)	C=0,03 Si=0,7 Mn=0,7 Cr=13,0 Ni=4,5 Mo=0,5		Wire diameter: 1,2 mm: 17 20 523123 Rod diameter: 2,0 mm: 17 21 523207
MOST 307 Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 18 8 (W 18 8) AWS A5.9: ER 307 L Si Werkstoff nr: 1.4370	MAG  TIG 		R_e [N/mm ²] >460 R_m [N/mm ²] >650 A_5 >41 % KV >140 J (20°C)	C=0,08 Si=0,9 Mn=7,0 Cr=18,0 Ni=8,0 Mo<0,5 Cu<0,1 N<0,06	TÜV	Wire diameter: 1,2 mm: 17 20 502123 Rod diameter: 2,0 mm: 17 21 502207
MOST 316 L Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 19 12 3 L Si (W 19 12 3 L Si) AWS A5.9: ER 316 L Si	MAG  TIG 		R_e [N/mm ²] >380 R_m [N/mm ²] >500 A_5 >35% KV >130 J (20°C)	C<0,025 Si=0,9 Mn=1,8 Cr=18,5 Ni=12,0 Mo=2,6 Cu<0,2 N=12,0	TÜV	Wire diameter: 1,2 mm: 17 20 512123 Rod diameter: 2,0 mm: 17 21 512207
MOST 1.4453 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	DIN 8556 : SG X3 CrNiMnMoN 19 16 Werkstoff nr: 1.4453	MAG  TIG 		R_e [N/mm ²] >400 R_m [N/mm ²] >600–750 A_5 >30% KV >70 J (20°C)	C<0,03 Si=0,2–0,7 Mn=5,0–7,0 Cr=19,0 Ni=17,0 Mo=4–4,3 N=0,17		Wire diameter: 1,2 mm: 17 20 526123 Rod diameter: 2,0 mm: 17 21 526207
MOST 1.4455 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 16 2 N L (W 16 2 N L) Werkstoff nr: 1.4455	MAG  TIG 		R_e [N/mm ²] >450 R_m [N/mm ²] >650 A_5 >30% KV >80 J (20°C)	C=0,02 Si=0,5 Mn=7,0 Cr=20,0 Ni=16,0 Mo=2,7 N=0,15		Wire diameter: 1,2 mm: 17 20 527123 Rod diameter: 2,0 mm: 17 21 527207
MOST 2209 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 22 9 3 L (W 22 9 3 L) AWS A5.9: ER 2209 Werkstoff nr: 1.4462	MAG  TIG 		R_e [N/mm ²] >600 R_m [N/mm ²] >750 A_5 >25% KV >160 J (20°C)	C<0,02 Si=0,5 Mn=1,6 Cr=23,0 Ni=9,0 Mo=3,2 N=0,16		Wire diameter: 1,2 mm: 17 20 519123 Rod diameter: 2,0 mm: 17 21 519207
MOST 430 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 17 (W 1 17) AWS A5.9: ER 430 Ti Werkstoff nr: 1.4502	MAG  TIG 		R_e [N/mm ²] >295 R_m [N/mm ²] >490 A_5 >20%	C=0,07 Si=0,7 Mn=0,3 Cr=17,5 Ti=0,6		Wire diameter: 1,2 mm: 17 20 521123 Rod diameter: 2,0 mm: 17 21 521207



Wires and rods for welding high-alloyed steels

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST 385 (904 L) Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 20 25 5 Cu (W 2025) AWS A5.9: ER 385 Werkstoff nr: 1.4519	MAG  TIG 		R _e [N/mm ²] >320 R _m [N/mm ²] >540 A ₅ >37% KV >120 J (20°C)	C < 0,02 Si = 0,4 Mn = 18,0 Cr = 20,0 Ni = 25,0 Mo = 4,5 Cu = 1,5 N < 0,06		Wire diameter: 1,2 mm: 17 20 524123 Rod diameter: 2,0 mm: 17 21 524207
MOST 347 Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 19 9 L Si (W 19 9 L Si) AWS A5.9: ER 347 Si Werkstoff nr: 1.4551	MAG  TIG 		R _e [N/mm ²] >400 R _m [N/mm ²] >610 A ₅ >35% KV >110 J (20°C)	C = 0,04 Si = 0,9 Mn = 1,2 Cr = 19,5 Ni = 10,0 Mo < 0,5 Cu < 0,2 N < 0,06		Wire diameter: 1,2 mm: 17 20 513123 Rod diameter: 2,0 mm: 17 21 513207
MOST 322 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 27 31 4 Cu L (W27 31 4 Cu L) AWS A5.9: ER 322 Werkstoff nr: 1.4563	MAG  TIG 		R _e [N/mm ²] >360 R _m [N/mm ²] >540 A ₅ >35% KV >100 J (20°C)	C < 0,02 Si = 0,2 Mn = 1,8 Cr = 27,0 Ni = 31,0 Mo = 3,5 Cu = 1,0 N < 0,06		Wire diameter: 1,2 mm: 17 20 525123 Rod diameter: 2,0 mm: 17 21 525207
MOST 318 Si Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 19 12 3 Nb Si (W 19 12 3 Nb Si) AWS A5.9: ER 318 Si Werkstoff nr: 1.4563	MAG  TIG 		R _e [N/mm ²] >400 R _m [N/mm ²] >610 A ₅ >36% KV >110 J (20°C)	C = 0,04 Si = 0,9 Mn = 1,2 Cr = 18,5 Ni = 12,5 Mo = 2,6 Cu < 0,2 N < 0,065		Wire diameter: 1,2 mm: 17 20 507123 Rod diameter: 2,0 mm: 17 21 507207
MOST 1.4820 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 25 4 H (W 25 4 H) Werkstoff nr: 1.4820	MAG  TIG 		R _e [N/mm ²] >400 R _m [N/mm ²] >630-780 A ₅ >15% KV >30 J (20°C)	C = 0,08 Si = 0,9 Mn = 1,2 Cr = 26,0 Ni = 4,5		Wire diameter: 1,2 mm: 17 20 522123 Rod diameter: 2,0 mm: 17 21 522207
MOST 310 Shielding gas: Ar+O ₂ (MAG), Ar (TIG). Welding method: MAG and TIG.	PN-EN 12072: G 25 20 (W 25 20) AWS A5.9: ER 310 Werkstoff nr: 1.4842	MAG  TIG 		R _e [N/mm ²] >390 R _m [N/mm ²] >590 A ₅ >43% KV >175 J (20°C)	C = 0,12 Si = 0,3 Mn = 1,8 Cr = 26,0 Ni = 21,0 Mo < 0,3 Cu < 0,1 Ni < 0,06		Wire diameter: 1,2 mm: 17 20 512123 Rod diameter: 2,0 mm: 17 21 512207

Wires and rods for pad welding and regeneration

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL-250 HB Solid wire for stroke-resistant padding weld. Low-alloyed solid wire designed for pad welding of parts open to wear. <i>Used for machine parts, rolls, rails etc.</i> Welding method: MIG/MAG, TIG.	DIN 8555: MSG 1-250 Werkstoff nr: 1.8401			Hardness: 225–275 HB	C=0,3 Si=0,45 Mn=1,1 Cr=1,0 Al=0,1 Ti=0,2		Wires diameter: 1,2 mm: 15 50 070112 0,8 mm; 1,0 mm; 1,6 mm Rods diameter: 2,0 mm: 1P 50 070120 1,6 mm; 2,4 mm; 3,2 mm
MOST EL-300 HB Solid wire for stroke-resistant padding weld. Welding method: MIG/MAG, TIG.	DIN 8555: MSG 1-GZ-300 Werkstoff nr: 1.8404			Hardness: 290–330 HB	C=0,12; Mo=0,5 Si=0,5 Mn=1,1 Cr=1,1 Ti=0,2		Wires diameter: 1,2 mm: 15 50 071212 0,8 mm; 1,0 mm; 1,6 mm Rod diameter: 2,0 mm: 1P 50 071220
MOST EL-350 HB Solid wire for stroke-resistant padding weld. Low-alloyed solid wire designed for pad welding parts exposed to wear. <i>Used for machine parts, rolls, rails etc.</i> Welding method: MIG/MAG, TIG.	DIN 8555: MSG 2-350 Werkstoff nr: 1.8405			Hardness: 370 HB	C=0,7 Si=0,45 Mn=2,0 Cr=1,0 Al=0,1 Ti=0,2		Wires diameter: 1,2 mm: 15 50 070212 0,8 mm; 1,0 mm; 1,6 mm Rods diameter: 2,0 mm: 1P 50 070220 1,0 mm; 1,6 mm 2,4 mm; 3,2 mm
MOST EL-500 HB Wire for stroke-resistant padding weld. Solid wire designed for pad welding parts exposed to wear and pressure, made of structural steels, cast steels and manganese steels. <i>Used for machine parts, rollers, shaft pins, rails etc.</i> Welding method: MIG/MAG, TIG.	DIN 8555: MSG 2-50 Werkstoff nr: 1.8425			Hardness: 47–52 HRC	C=1,1 Si=0,45 Mn=1,9 Cr=2,0 Al=0,1 Ti=0,2		Wires diameter: 1,2 mm: 15 50 070312 1,0 mm; 1,6 mm; Rods diameter: 2,0 mm: 1P 50 070320 1,0 mm; 1,6 mm 2,4 mm; 3,2 mm
MOST EL-600 HB Solid wire for stroke-resistant padding weld. Filler metal is a free of cracks, hard padding weld, stroke and abrasion resistant. When the base material is hard-to-weld preheating or undercoat is recommended. <i>Can be used for: crusher wheels, loader buckets parts and a final layer of pad welding manganese steels.</i> Structure: martensitic. Welding method: MIG/MAG, TIG.	DIN 8555: MSG 6-60 Werkstoff nr: 1.4718			Hardness: 59 HRC	C=0,5 Si=3,0 Mn=0,4 Cr=9,2		Wires diameter: 1,2 mm: 15 50 070412 0,8 mm; 1,0 mm; 1,6 mm Rods diameter: 2,0 mm: 1P 50 070420 1,0 mm; 1,6 mm 2,4 mm; 3,2 mm
MOST EL-650 HB Wire for stroke-resistant padding weld. Solid wire designed for pad welding hot-working parts, exposed to abrasive wear, strokes and temperatures up to 500°C. <i>Possible applications: parts of machines, dies, rollers etc.</i> Welding method: MIG/MAG, TIG.	DIN 8555: MSG 3-GZ-60T Werkstoff nr: 1.2606			Hardness: 57–59 HRC	C=0,35 Si=1,1 Mn=0,4 Cr=5,5 Mo=1,2 V=0,25 W=1,3		Wires diameter: 1,2 mm: 15 50 071012 0,8 mm; 1,0 mm; 1,6 mm Rods diameter: 2,0 mm: 1P 50 071020 1,0 mm; 1,6 mm; 2,4 mm
MOST W 45 Rod for tool steels. Rod designed for pad welding and regeneration of hot-working parts. Welding method: TIG.	DIN 8555: MSG 3-45T Werkstoff nr: 1.2567			Hardness: 44–50 HRC	C=0,2; Si=0,2 Mn=0,3 Cr=2,4 W=4,5 V=0,6		2,0 mm: 11 31 370120 1,6 mm; 2,4 mm
MOST W 60 Rod for tool steels. Rod designed for pad welding and regeneration of parts with characteristics of high speed steel. Welding method: TIG.	DIN 8555: MSG 4-60-S Werkstoff nr: 1.3348			Hardness: 58 HRC	C=1,0; Si=0,3 Mn=0,3; W=1,8 Mo=8,3 Cr=4,0 V=1,9		2,0 mm: 11 31 370220 1,6 mm; 2,4 mm; 3,2 mm



Wires and rods for pad welding and regeneration

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL-Co 1 Cobalt-based bond. Padding weld resistant to extreme metal-to-metal abrasive wear up to 950°C. <i>Application: holes, shafts, pumps, rolls, cutting blades, etc.</i>	DIN 8555: MF 20-55-CGTZ AWS A5.13-70: RCoCr-C			Hardness: 52-59 HRC (20°C) 42-45 HRC (600°C)	C=2,5 Si=0,8 Ni=max 3,0 Fe=max 3,0 Cr=30,0 W=13,0 Co - rest		Rods diameter: 2,5 mm: 1P 53 100425 3,2 mm: 1P 53 100432 4,0 mm: 1P 53 100440 5,0 mm: 1P 53 100450 Wire diameter: 1,2 mm: 15 53 100412 1,6 mm: 15 53 100416
MOST EL-Co 6 Cobalt-based bond. Padding weld resistant to extreme metal-to-metal abrasive wear and pressure up to 950°C. Very good resistance to thermal and mechanical shocks. <i>Application: hot-cutting blades, rolls, industrial fittings, engine valves, hot working tools, etc.</i>	DIN 8555: MF 20-45-CTZ AWS A5.13-70: RCoCr-A			Hardness: 39-46 HRC (20°C) 30 HRC (600°C)	C=1,1 Si=1,0 Ni=max 3,0 Fe=max 3,0 Cr=28,0 W=4,0 Co - rest		Rods diameter: 2,5 mm: 1P 53 100525 3,2 mm: 1P 53 100532 4,0 mm: 1P 53 100540 5,0 mm: 1P 53 100550 Wire diameter: 1,2 mm: 15 53 100512 1,6 mm: 15 53 100516
MOST EL-Co 12 Cobalt-based bond. Padding weld resistant to extreme abrasive wear up to 950°C. <i>Application: extruder dies, saw blades, runners, etc.</i>	DIN 8555: MF 20-50-CTZ AWS A5.13-70: RCoCr-B			Hardness: 46-52 HRC (20°C) 38-40 HRC (600°C)	C=1,4 Si=1,5 Ni=max 3,0 Fe=max 3,0 Cr=29,0; W=8,0 Co - rest		Rods diameter: 2,5 mm: 1P 53 100625 3,2 mm: 1P 53 100632 4,0 mm: 1P 53 100640 5,0 mm: 1P 53 100650 Wire diameter: 1,2 mm: 15 53 100612 1,6 mm: 15 53 100616
MOST EL-Co 21 Cobalt-based bond. Padding weld resistant to extreme metal-to-metal abrasive wear and pressure up to 950°C. Padding weld is stroke-hardening. <i>Application: Tools for both hot and cold forging and shaping, parts of gas turbines, etc.</i>	DIN 8555: MF 20-350-CKTZ AWS A5.13-70: RCoCr-E			Hardness: 32-38 HRC (20°C) 38-40 HRC (600°C) 42-45 HRC (after cold work)	C=2,5 Si=1,0 Ni=2,5 Fe=max 3,0 Mo=5,5 Cr=27,0 Co - rest		Rods diameter: 2,5 mm: 1P 53 100725 3,2 mm: 1P 53 100732 4,0 mm: 1P 53 100740 5,0 mm: 1P 53 100750 Wire diameter: 1,2 mm: 15 53 100712 1,6 mm: 15 53 100716

Wires and rods for welding cast iron



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST NiFe NiFe solid wire for welding cast iron and joining cast iron with steel. Can be used for: centrifugal cast iron, spheroidal graphite iron, malleable cast iron. Welding method: MIG, TIG.	Werkstoff nr: 2.4560				Ni=55,0 C=1,5 Fe=rest		Wires diameter: 1,2 mm: 11 30 701123 0,8 mm; 1,0 mm; 1,6 mm Rod diameter: 2,0 mm: 11 31 701207

Wires and rods for welding nickel and nickel alloys
















Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST EL-Ni Ti 3 Solid wire for welding nickel (up to 450°C) and nickel alloys and for joining nickel alloys with steel, cast steels and copper. Filler metal resistant to temperatures lower than -196°C. Welding method: MIG, TIG.	AWS A5.14 : ER Ni 1 Werkstoff nr: 2.4155			R_e [N/mm ²]=300 R_m [N/mm ²]=500 $A_5 > 35\%$	C=0,02 Si=0,4 Mn=0,4 Fe=0,2 Ti=3,0 Ni-rest		Wire diameter: 1,2 mm: 15 50 020512 2,0 mm; 3,2 mm Rods diameter: 2,0 mm: 1P 50 020520 3,25 mm; 4,0 mm 5,0 mm
MOST EL-Alloy C Corrosion-resistant wire for welding and repairing nickel alloys and high-temperature steels as well as for welding them with low- and high-alloyed steels and cast steels. Working temperature up to 400°C. The joint is resistant to temperatures not lower than -196°C. Welding method: MIG, TIG.	Werkstoff nr: 2.4886			R_e [N/mm ²]=470 R_m [N/mm ²]=780 $A_5 = 35\%$ KV=80 J (20°C); 60 J (-196°C)	C=0,01; Cr=15,5 Fe=5,0; Mn=0,5 Mo=16,0; Si=0,06 V=0,3 W=4,0 Ni-rest		Wire diameter: 1,2 mm: 15 50 020612 1,6 mm; 2,0 mm; 2,4 mm; 3,2 mm Rods diameter: 2,0 mm: 1P 50 020620 1,6 mm; 2,4 mm; 3,2 mm
MOST EL-NiCu-30 Wire for welding and repairing NiCu alloys and joints of copper alloys with steels. Working temperature up to 425°C. The joint is resistant to temperatures not lower than -196°C. Welding method: MIG, TIG.	Werkstoff nr: 2.4377 AWS A5.14 : ER NiCu 7			R_e [N/mm ²] >300 R_m [N/mm ²] >500 $A_5 > 35\%$ KV=150 J (20°C); 110 J (-196°C)	C=0,02; Si=0,2 Mn=3,3 Fe=1,0 Cu=30,0 Ti=2,0 Ni-rest		Wires diameter: 1,2 mm: 15 50 020212 1,0 mm; 1,6 mm; 2,0 mm; Rods diameter: 2,0 mm: 1P 50 020220 1,6 mm; 2,4 mm; 3,2 mm
MOST EL-82 Corrosion- and heat-resistant wire for welding and repairing nickel alloys, high-temperature steels and austenitic-ferrite joints at temperatures up to 550°C. The joint is resistant to temperatures between -269°C and 900°C. Welding method: MIG, TIG.	Werkstoff nr: 2.4806 AWS A5.14 : ER NiCr 3			R_e [N/mm ²] >400 R_m [N/mm ²] >680 $A_5 > 40\%$ KV=150 J (20°C)	C=0,02; Si=0,2 Mn=3,0; Fe=1,0 Ti=0,5 Cr=20,0 Nb+Ta=2,5 Ni-rest		Wires diameter: 1,2 mm: 15 51 020112 1,0 mm; 1,6 mm; 2,0 mm; Rods diameter: 2,0 mm: 1P 51 020120 1,6 mm; 2,4 mm; 3,2 mm
MOST EL-625/IG Highly corrosion-resistant wire designed for joining and pad welding of similar, corrosion- and high temperature-resistant materials, cryogenic steels, nickel alloys and austenitic-ferrite joints at the temperatures up to 550°C. The joint is resistant to temperatures between -196°C and 1100°C. Welding method: MIG, TIG.	Werkstoff nr: 2.4831 AWS A5.14 : ER NiCr Mo 3			R_e [N/mm ²] >420 R_m [N/mm ²] >800 $A_5 > 35\%$ KV=110 J (20°C); 85 J (-196°C)	C=0,02; Si=0,2 Mn=0,2; Fe=1,5 Mo=9,0 Cr=22,0 Nb+Ta=3,3 Ni-rest		Wires diameter: 1,2 mm: 15 51 020412 0,8 mm; 1,6 mm; 2,0 mm; 2,4 mm; 3,2 mm Rods diameter: 2,0 mm: 1P 51 020420 1,6 mm; 2,4 mm; 3,2 mm



Wires and rods for welding copper and copper alloys

















Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST CuAl 8 Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuAl-A1 Werkstoff nr: 2.0921			R_e [N/mm ²] > 200 R_m [N/mm ²] > 430 A_5 > 40% KV > 100 J (20°C)	Cu > 90,0 Al = 8,0		Wire diameter: 1,2 mm: 11 30 813123 Rod diameter: 2,0 mm: 11 31 813207
MOST CuSn Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER Cu Werkstoff nr: 2.1006			R_e [N/mm ²] > 100 R_m [N/mm ²] > 210–240 A_5 = 30% KV > 80 J (20°C)	Si = 0,3 Mn = 0,3 Cu > 98,0 Sn = 0,8		Wire diameter: 1,2 mm: 11 30 811123 Rod diameter: 2,0 mm: 11 31 811207
MOST CuSn 6 Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuSn-A Werkstoff nr: 2.1022			R_e [N/mm ²] > 150 R_m [N/mm ²] > 220–360 A_5 = 20% KV > 80 J (20°C)	Cu > 92,0 Sn = 6,4		Wire diameter: 1,2 mm: 11 30 812123 Rod diameter: 2,0 mm: 11 31 812207
MOST CuSi 3 Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuSi-A Werkstoff nr: 2.1461			R_e [N/mm ²] > 120 R_m [N/mm ²] > 350 A_5 > 40% KV > 60 J (20°C)	Si = 3,0; Mn = 1,0 Cu > 94,0 Fe = 0,07 Zn = 0,1 Sn = 0,1		Wire diameter: 1,2 mm: 11 30 815123 Rod diameter: 2,0 mm: 11 31 815207
MOST CuNi 30 Fe Shielding gas: Ar, Ar+He, He. Welding method: MIG and TIG.	AWS A5.7: ER CuAl-Ni Werkstoff nr: 2.0837			R_e [N/mm ²] > 250 R_m [N/mm ²] > 400 A_5 > 30% KV > 100 J (20°C)	C > 0,05; Mn = 1,0 Cu - rest Ti = 0,3 Ni = 30,0 Fe = 0,6		Wire diameter: 1,2 mm: 11 30 817123 Rod diameter: 2,0 mm: 11 31 817207

Wires and rods for welding aluminium and aluminium alloys

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST Al 99,5 (IA 1050) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 1050 Werkstoff nr: 3.0259	MIG  TIG 		R_e [N/mm ²]=39–59 R_m [N/mm ²]=68–88 A_5 =25–35%	Al>99,5 Si<0,4 Cu=0,05 Zn=0,07 Fe<0,3 Ti=0,05	TÜV, DB, DB-Ü	Wires diameter: 0,8 mm: 11 40 901082 1,0 mm: 11 40 901102 1,2 mm: 11 40 901122 1,6 mm: 11 40 901162 Rods diameter: 1,6 mm: 11 41 901167 2,0 mm: 11 41 901207 3,2 mm: 11 41 901327 4,0 mm: 11 41 901407
MOST Al 99,5 Ti (IA 1450) Shielding gas: Ar. Welding method: MIG and TIG.	DIN 1732 : SG Al 99.5 Ti Werkstoff nr: 3.0805	MIG  TIG 		R_e [N/mm ²]=40–60 R_m [N/mm ²]=70–90 A_5 =25–35%	Al>99,5 Si<0,25 Mn>0,05 Mg=0,05 Cu=0,05 Zn=0,1 Fe<0,4 Ti<0,15		Wires diameter: 0,8 mm: 11 40 902082 1,0 mm: 11 40 902102 1,2 mm: 11 40 902122 1,6 mm: 11 40 902162 Rods diameter: 1,6 mm: 11 41 902167 2,0 mm: 11 41 902207 3,2 mm: 11 41 902327 4,0 mm: 11 41 902407
MOST Al 99,8 (IA 1080) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 1080 Werkstoff nr: 3.0286	MIG  TIG 		R_e [N/mm ²]=40–60 R_m [N/mm ²]=60–80 A_5 =25–35%	Al>99,8 Si<0,15 Cu=0,02 Zn=0,06 Fe<0,15 Ti=0,03		Wires diameter: 0,8 mm: 11 40 903082 1,0 mm: 11 40 903102 1,2 mm: 11 40 903122 1,6 mm: 11 40 903162 Rods diameter: 1,6 mm: 11 41 903167 2,0 mm: 11 41 903207 3,2 mm: 11 41 903327 4,0 mm: 11 41 903407
MOST Al Mg 3 (IA 5754) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 5754 Werkstoff nr: 3.3536	MIG  TIG 		R_e [N/mm ²]=80–100 R_m [N/mm ²]=175–205 A_5 =15–20%	Si=0,4 Mn=0,1–0,6 Mg=2,6–3,6 Cr<0,3 Zn=0,02 Fe<0,15 Ti<0,25 Cu=0,05 Al – rest		Wires diameter: 0,8 mm: 11 40 906082 1,0 mm: 11 40 906102 1,2 mm: 11 40 906122 1,6 mm: 11 40 906162 Rods diameter: 1,6 mm: 11 41 906167 2,0 mm: 11 41 906207 3,2 mm: 11 41 906327 4,0 mm: 11 41 906407
MOST Al Mg 5 (IA 5356) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 5356 Werkstoff nr: 3.3556	MIG  TIG 		R_e [N/mm ²]=100–135 R_m [N/mm ²]=220–260 A_5 =15–25%	Si<0,25 Mn<0,2 Mg=4,5–5,2 Cu=0,05 Zn=0,02 Fe<0,4 Ti=0,25 Cr<0,3 Al – rest	TÜV, DB, DB-Ü, ABS, BV, DNV, LR	Wires diameter: 0,8 mm: 11 40 908082 1,0 mm: 11 40 908102 1,2 mm: 11 40 908122 1,6 mm: 11 40 908162 Rods diameter: 1,2 mm: 11 41 908127 2,0 mm: 11 41 908207 3,2 mm: 11 41 908327 4,0 mm: 11 41 908407



Wires and rods for welding aluminium and aluminium alloys

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST Al Mg 4.5 Mn (IA 5183) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 5183 Werkstoff nr: 3.3548	MIG  TIG 	 	$R_e [N/mm^2] = 110-150$ $R_m [N/mm^2] = 275-335$ $A_5 = 15-20\%$	$Si < 0,25$ $Mn = 0,6-1,0$ $Mg = 4,3-5,2$ $Cu = 0,05$ $Zn = 0,25$ $Fe < 0,4$ $Ti < 0,25$ $Cr < 0,25$ Al - rest	TÜV, DB, DB-Ü, ABS, BV, DNV, LR	Wires diameter: 0,8 mm: 11 40 907082 1,0 mm: 11 40 907102 1,2 mm: 11 40 907122 1,6 mm: 11 40 907162 Rods diameter: 1,6 mm: 11 41 907167 2,0 mm: 11 41 907207 3,2 mm: 11 41 907327 4,0 mm: 11 41 907407
MOST Al Mg 4.5 Mn Zr (IA 5087) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 5183 Werkstoff nr: 3.3546	MIG  TIG 	 	$R_e [N/mm^2] = 110-150$ $R_m [N/mm^2] > 285$ $A_5 = 15-20\%$	$Si < 0,25$ $Mn = 0,6-1,0$ $Mg = 4,3-5,2$ $Cu = 0,05$ $Zn = 0,25$ $Fe < 0,4$ $Zr = 0,1$ $Cr < 0,25$ $Ti < 0,25$ Al - rest	DB, BV, DNV	Wires diameter: 0,8 mm: 11 40 910082 1,0 mm: 11 40 910102 1,2 mm: 11 40 910122 1,6 mm: 11 40 910162 Rods diameter: 1,6 mm: 11 41 910167 2,0 mm: 11 41 910207 3,2 mm: 11 41 910327 4,0 mm: 11 41 910407
MOST Al Si 5 (IA 4043) Shielding gas: Ar. Welding method: MIG and TIG.	AWS A5.10: ER 4043 Werkstoff nr: 3.2245	MIG  TIG 	 	$R_e [N/mm^2] > 50$ $R_m [N/mm^2] = 120-150$ $A_5 = 10-18\%$	$Si = 4,5-5,5$ $Mn = 0,1$ $Mg = 0,1$ $Cu = 0,05$ $Fe < 0,4$ $Ti < 0,25$ Al - rest	DB	Wires diameter: 0,8 mm: 11 40 904082 1,0 mm: 11 40 904110 1,2 mm: 11 40 904112 1,6 mm: 11 40 904116 Rod diameter: 1,6 mm: 11 41 904167
MOST Al Si 12 (IA 4047) Shielding gas: Ar, Ar+He. Welding method: MIG and TIG.	AWS A5.10: ER 4047 Werkstoff nr: 3.2885	MIG  TIG 	 	$R_e [N/mm^2] > 70$ $R_m [N/mm^2] > 160-190$ $A_5 = 10-15\%$	$Si = 11-13,5$ $Mn > 0,5$ $Mg = 0,05$ $Cu = 0,05$ $Zn = 0,1$ $Fe < 0,6$ $Ti < 0,15$ Al - rest		Wires diameter: 0,8 mm: 11 40 905082 1,0 mm: 11 40 905102 1,2 mm: 11 40 905122 1,6 mm: 11 40 905162 Rods diameter: 1,6 mm: 11 41 905167 2,0 mm: 11 41 905207 3,2 mm: 11 41 905327 4,0 mm: 11 41 905407

3. FLUX CORED WIRES FOR ARC WELDING

Flux cored wires for pad welding and regeneration



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST F-200 K Resistant to corrosion, temperature and thermal shocks up to 850°C padding weld. For notable elongation (40%) it is fit for applications as undercoat layer before pad hardening welding and for joining hard-to-weld and of different poles metals. <i>Possible applications: scissors crossovers, parts of crushers, rolls, rails, beaters, etc.</i>	DIN 8555: MF 8-200-CKNPZ			Hardness: 180-200/400 HB	C=0,1 Si=0,4 Mn=6,0 Cr=19,0 Ni=8,5 Fe- rest		1,6 mm: 15 55 010116 2,4 mm: 15 55 010124
MOST F-240 K It is fit for welding elements of manganese steel (of "Hadfield" type) open to powerful strokes. Padding weld is non-magnetic, crack-free and gets hardened under influence of cold work. <i>Possible applications: crusher jaws, elements of railway tracks, excavators buckets, elements of manganese steel, etc.</i>	DIN 8555: MF 7-200-KNP			Hardness: 200-230/450 HB	C=1,0 Si=0,4 Mn=14,0 Cr=4,0 Ni=0,6 Fe- rest		1,6 mm: 15 55 010216 2,4 mm: 15 55 010224
MOST F-250 K High-manganese and high-chromium, corrosion-resistant, non-magnetic padding weld of notable plasticity. Applied as undercoat layer at hardening pad welding (particularly in case of repeated regeneration of used elements). Padding weld resistant to squeezing, stress and strokes.	DIN 8555: MF 7-250-KNP			Hardness: 220-250/500 HB	C=0,4 Si=0,4 Mn=16,0 Cr=14,0 Ni=1,2 Mo=0,6 V=0,2; Fe- rest		1,6 mm: 15 55 010316 2,4 mm: 15 55 010324
MOST F-300 Low-alloyed, ductile, crack-free padding weld, designed for reconstructions, particularly in cases when there are many layers required. <i>Possible applications: tractors wheels, shafts, transmission gears, rotational suspension pins in rail joints, etc.</i>	DIN 8555: MF 1-300-P			Hardness: 280-325 HB	C=0,1 Si=0,5 Mn=2,0 Cr=1,5 Mo=0,4 Fe- rest		1,6 mm: 15 55 020216 2,4 mm: 15 55 020224
MOST F-450 Workable, low-alloyed padding weld for multi-layer pad welding. In case of domestic material, with large content of carbon undercoat layer of heating is required. <i>Possible applications: wheel rims, chain links, bucket chains, etc.</i>	DIN 8555: MF 3-45-PT			Hardness: 42-45 HRC	C=0,2 Cr=4,5 Mo=0,3 V=0,2 Fe- rest		1,6 mm: 15 55 021116 2,4 mm: 15 55 021124
MOST F-601 Padding weld of high resistance to abrasive wear and strokes, keeping high hardness at temperature of up to 550°C. It can be heat treated with increase of hardness in view. <i>Possible applications: hammers, rolls of rollers, bucket teeth, etc.</i>	DIN 8555: MF 6-60-PT			Hardness: 55-58 HRC	C=0,5; Si=1,0 Mn=3,0; Cr=6,0 Mo=1,6; V=1,5 W=1,0 Fe- rest		1,6 mm: 15 55 021516 2,4 mm: 15 55 021524
MOST F-WZ 50 Padding weld designed for regenerations and reconstructions of hot-working tools. Workable, possible to heat treated; keeps high hardness at temperature of up to 550°C. <i>Possible applications: mandrels, drop forging dies, heat-cutting knives, etc.</i>	DIN 8555: MF 3-50-ST			Hardness: 48-50 HRC	C=0,3 Cr=2,5 V=0,6 W=4,5 Fe- rest		1,2 mm: 15 55 040112 1,6 mm: 15 55 040116 2,4 mm: 15 55 040124
MOST F-WZ 59 Resistant to abrasion and high temperature padding weld of high-speed steel character designed for regeneration and manufacture of cold- and hot working tools. <i>Possible applications: punches, dies, etc.</i>	DIN 8555: MF 4-55-ST			Hardness: 57-59 HRC	C=0,6 Cr=4,0 Mo=3,5 W=3,5 Fe- rest		1,2 mm: 15 55 040312 1,6 mm: 15 55 040316 2,4 mm: 15 55 040324
MOST F-59 Strongly resistant to abrasion and moderate strokes padding weld with high content of chromium carbides. <i>Possible applications: agricultural tools, excavators, screw conveyors, etc.</i>	DIN 8555: MF 10-60-GR			Hardness: 59-61 HRC	C=5,0 Si=1,5 Cr=32,0 Fe-rest		1,6 mm: 15 55 040716 2,0 mm: 15 55 040720 2,4 mm: 15 55 040724 2,8 mm: 15 55 040728 3,2 mm: 15 55 040732



Flux cored wires for pad welding and regeneration

Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST F-64 Resistant to large mineral wear at high temperatures padding weld of hard martensitic microstructure with carbides. Can be applied for single-layer pad welding with no notable loss of hardness. <i>Possible applications: concrete and mineral industries, brickyards, etc.</i>	DIN 8555: MF 10-65-GZ			Hardness: 62-64 HRC	C=3,8; Cr=22,0; V=0,8; W=0,8; Fe - rest; So=B 1,0		1,2 mm: 15 55 041112 1,6 mm: 15 55 041116 2,0 mm: 15 55 041120 2,4 mm: 15 55 041124 2,8 mm: 15 55 041128 3,2 mm: 15 55 041132
MOST F-65 Padding weld with content of extremely hard carbides. Designed for repairs of elements open to high mineral wear at temperature of up to 650°C. <i>Possible applications: great furnace cones, sintering plants, screw conveyors, etc.</i>	DIN 8555: MF 10-65-GZ			Hardness: 63-65 HRC	C=5,2; Cr=21,0; Mo=7,0; Nb=7,0; V=1,0; W=2,0; Fe - rest		1,6 mm: 15 55 041216 2,0 mm: 15 55 041220 2,4 mm: 15 55 041224 3,2 mm: 15 55 041232

Flux cored wires for cast iron



Type and description	Classification	Welding current	Welding position	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST F-NiFe 36 Core wire for welding cast iron and joining steels with cast iron. Padding weld is workable, distinguished by extremely low coefficient of thermal expansion.	Werkstoff nr: 1.3912			Hardness: 140-160 HB	Mn=3,0 Ni=36,0 Fe - rest		1,6 mm: 15 55 050916 2,0 mm: 15 55 050920 2,4 mm: 15 55 050924 2,8 mm: 15 55 050928
MOST F-NiFe 60/40 NiFe solid wire for welding cast iron and joining cast iron with steel. Available also as solid wire. Can be used for: centrifugal cast iron, GGG cast iron, malleable cast iron.	DIN 8555: MF NiFe-2			Hardness: 160-190 HB	Mn=4,0 Fe=40,0 Ni - rest Cu+		1,6 mm: 15 55 051016 2,0 mm: 15 55 051020 2,4 mm: 15 55 051024 2,8 mm: 15 55 051028

4. OTHER WELDING CONSUMABLES

Electrodes for cutting and grooving



Type and description	Classification	Welding current	Characteristics	Chemical composition [%]	Approvals	Diameter and index
CARBON ELECTRODE MOST Carbon electrodes are used for: <ul style="list-style-type: none"> welding steels and non-iron materials arc grooving and cutting removing old welds, finishing of welds cleaning and repairing cast-iron and non-iron castings underwater cutting of metals. 			Example size selection for round electrodes: <ul style="list-style-type: none"> width of groove: electrodes diameter x 1,4/1,5 mm depth of groove: electrodes diameter x 0,7/0,8 mm arc amperage: electrodes diameter x (40-50) A 	C=98		6,0 mm: 03 77 257062 8,0 mm: 03 77 257082 10,0 mm: 03 77 257102

Special-purpose electrodes



Type and description	Classification	Welding current	Characteristics	Chemical composition [%]	Approvals	Diameter and index
MOST Lastek 1000 Cutting of all materials without compressed air (stainless steel, aluminium, cast-iron, bronze, copper, etc.). in case of cutting stainless steels edges will not be carbonated. <i>Application: removal of passes, rivets, cutting out of wholes, demolitions, etc.</i>						2,5 mm: 05 58 090125 3,2 mm: 05 58 090132 4,0 mm: 05 58 090140 5,0 mm: 05 58 090150
MOST Lastek 1001 Point-heating and preheating of metals, without padding weld. <i>Application: art and ornamental works, removal of machine parts, preheating of joints before peening of a weld, etc.</i>						3,2 mm: 05 58 090232 4,0 mm: 05 58 090240
MOST Lastek 1008 Electrode for underwater welding. <i>Application: drilling rigs, ship repairs, harbour works, etc.</i>						3,2 mm: 05 58 090332 4,0 mm: 05 58 090340 5,0 mm: 05 58 090350
MOST Lastek 1010 Electrode for point-heating seal of metals, which is an alternative to welder. Suitable for joining steel sheets of total thickness up to 10mm (e.g. 5mm + 5mm) with total penetration as well as for sealing (riveting) steel sheets up to 10mm thick with larger parts (without total penetration). <i>Application: chemical industry (sealing stainless steels with profiles), workshop activities, etc.</i>						1,5 mm: 05 58 090415 2,0 mm: 05 58 090420 2,5 mm: 05 58 090425 3,2 mm: 05 58 090432 4,0 mm: 05 58 090440
MOST Lastek 1900 Electrode for cutting and grooving of all metals, to be used in all positions. <i>Application: preparation of surfaces for hardfacing, removal of old padding welds before rebuilding, scarfing of edges, removal of riser head in foundries, etc.</i>						2,5 mm: 05 58 090525 3,2 mm: 05 58 090532 4,0 mm: 05 58 090540 5,0 mm: 05 58 090550