

Aluminium

MIG	Page 100	TIG	Page 106	GAS	Page 106-112	Brazing	Page 106-112	ARC	Page 116
SIFMIG 1050		SIFALUMIN No 14		SIFALUMIN No 14		SIFALUMIN No 16		HILCO ALUMINIL SI5	
SIFMIG 4043		SIFALUMIN No 15		SIFALUMIN No 15		SIF 555 AL SOLDER		HILCO ALUMINIL SI12	
SIFMIG 4047		SIFALUMIN No 16		SIF FLUXCORE ALUMINIUM					
SIFMIG 5356		SIFALUMIN No 27							
SIFMIG 5183		SIFALUMIN No 28							
SIFMIG 5556		SIFALUMIN No 37							

Brass/Bronze

MIG	Page 101	TIG	Page 107	Brazing	Page 110	ARC	Page 116
SIFMIG 8		SIFPHOSPHOR BRONZE No 8		SIFCUPRON No 17-2Ag		HILCO BRONSIL	
SIFMIG 328		SIFPHOSPHOR BRONZE No 82		SIFCUPRON No 17-15Ag			
SIFMIG 968		SIFSILCOPPER No 968		SIF SILVER SOLDER No 38/39/43			

Cast Iron

MIG	Page 101	TIG	Page 107	GAS	Page 112	Brazing	Page 111	ARC	Page 114-116
SIFMIG 8		SIFPHOSPHOR BRONZE No 8		SUPER SILICON No 9		SIFBRONZE No 1		HILCO PURE NICKEL	
SIGMIG 328				SUPER SG CAST IRON				HILCO NICKEL IRON	
								SIFTRODE CAST IRON	

Copper

MIG	Page 101	TIG	Page 107	GAS	Page 112	Brazing	Page 110	ARC	Page 116
SIFMIG 985		SIFSILCOPPER No 985		SIFSILCOPPER No 7		SIFCUPRON No 17		HILCO BRONSIL	
SIFMIG 968		SIFSILCOPPER No 968				SIFCUPRON No 17-2Ag			
SIFMIG 8		SIFPHOSPHOR BRONZE No 8				SIFCUPRON No 17-5Ag			
SIFMIG 328		SIFPHOSPHOR BRONZE No 82				SIFCUPRON No 17-15Ag			
SIFMIG 44		SIFALBRONZE No 32				SIF SILVER SOLDER No 38/39/43			
		SIFALBRONZE No 44				SIFSILVERCOTE No 43			

Magnesium

TIG	Page 106	Brazing	Page 114+120
SIF MAGNESIUM No 23			

Stainless

MIG	Page 103	TIG	Page 104-108	GAS	Page 108	Brazing	Page 110-119	ARC	Page 114-117
SIFMIG 308LSI		SIFSTEEL STAINLESS 308L		SIFSTEEL STAINLESS 308L		SIFBRONZE No 2		HILCHROME 308 R	
SIFMIG 316LSI		SIFSTEEL STAINLESS 316LSI		SIFSTEEL STAINLESS 316LSI		SIF SILVER SOLDER No 43		HILCHROME 316 R	
SIFMIG 347		SIFSTEEL STAINLESS 347		SIFSTEEL STAINLESS 347		SIFSILVERCOTE No 43		HILCHROME 309 R	
SIFMIG 309LSI		SIFSTEEL STAINLESS 309L						HILCHROME 309Mo R	
SIFMIG 312		SIFSTEEL STAINLESS 312						HILCHROME 312 R	
		SIFSTEEL STAINLESS 310						SIFTRODE STAINLESS 316	
		SIFSTEEL DUPLEX						SIFTRODE STAINLESS 312	
		SIFSTEEL SUPER DUPLEX							

Steel


MIG	Page 102-103	TIG	Page 109	GAS	Page 113	Brazing	Page 106-112	ARC	Page 114-115
SIFMIG SG2		SIFSTEEL A15		SIFSTEEL No 11		SIFBRONZE No 1		HILCO RED EXTRA	
SIFMIG SG3		SIFSTEEL A17		SIFSTEEL No 22		SIFBRONZE No 2		HILCO VELVETA	
SIFMIG A15		SIFSTEEL A18				SIF AUTOBRONZE		HILCO VELORA	
SIFMIG A32		SIFSTEEL A31				SIFBRONZE No 101		HILCO REGINA 160	
SIFMIG HF600		SIFSTEEL A32				SIFREDICOTE No 1		HILCO BASIC SUPER	
FLUX CORED WIRES		SIFSTEEL A33				SIFREDICOTE No 2		HILCO BASIC 55	
SIFMIG GASLESS		SIFSTEEL HF6						HILCO HARDMELT 600	
SIFCORED E71T-1								SIFTRODE 6013	
HILCORD 600								SIFTRODE 7018	

Aluminium AL

SIFMIG 1050

A pure aluminium (99.5% min) shaved wire which produces a ductile weld equal in strength to that of the base metal.

EN ISO 18273 - S Al 1070 (AI99.7), BS: 2901 1050A, (GIB) (NG3)



Dia mm	Art #	6.5kg Spl
0.8	WO140865	115.75
1.0	WO141065	96.70
1.2	WO141265	94.50
1.6	WO141665	92.10

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	90	15	118

SIFMIG 4043

An Aluminium alloy with 5% silicon giving excellent flow characteristics and penetration. Suitable for welding duralumin, cast and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised.

EN ISO 18273 S Al 4043A (AISi5), BS: 2901 4043A, (NG21)

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
0.8	WO150805	★10.45	WO150820	53.25	WO150865	★84.25
1.0	WO151005	★10.10	WO151020	47.35	WO151065	★75.70
1.2	WO151205	★9.85	WO151220	45.05	WO151265	★71.30
1.6					WO151665	★68.80

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Si Bal Al	635	120	40	118

SIFMIG 4047

Aluminium alloy containing 12% Silicon, for high silicon alloys and automotive work.

EN ISO 18273 S Al 4047A (AISi12), BS: 2901 4047A, (NG2)

Dia mm	Art #	2.0kg Spl	Art #	6.5kg Spl
1.0	WO161020	50.95	WO161065	★92.50
1.2			WO161265	★85.85
1.6			WO161665	★83.65

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
12 Si, Bal Al	585	130	50	118

SIFMIG 5356

A general purpose aluminium wire with 5% magnesium that has excellent corrosion resistance and high strength. Suitable for welding magnesium bearing aluminium alloys such as 5251 (N4), 5154 (N5), 5454 (N51) and also heat treatable alloys 6063 (H9), 6061 (H20) and 6082 (H30)

EN ISO 18273 S Al 5356 (AlMg5), BS: 2901 5356, (NG6)

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
0.8	WO270805	★10.65	WO270820	54.15	WO270865	★85.60
1.0	WO271005	★10.20	WO271020	48.45	WO271065	★77.10
1.2	WO271205	★10.00	WO271220	45.80	WO271265	★72.35
1.6					WO271665	★70.70

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Mg Bal Al	640	250	60	118

SIFMIG 5183

Special aluminium alloy containing 5% Magnesium and 0.75% Manganese, for improved weld strength.

EN ISO 18273 S Al 5183 (AlMg4.5Mn0.7), BS: 2901 5183

Dia mm	Art #	6.5kg Spl
1.0	WO281065	110.40
1.2	WO281265	102.45

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Mg, 0.75 Mn, Bal Al	640	275	65	118

SIFMIG 5556

Aluminium alloy containing 5.3% Magnesium: all elements are closely controlled for optimum weld strength. Normally used on 5083 (N8) and for military applications

EN ISO 18273 S Al 5556A (AlMg5Mn), BS: 2901 5556

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
1.0					WO371065	★96.55
1.2	WO371205	13.00	WO371220	48.55	WO371265	★90.60
1.6					WO371665	★89.50

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5.3 Mg, 0.8 Mn, 0.1Cr, 0.1Ti, Bal Al	640	300	70	118

Copper & MIG Brazing **CU**

SIFMIG 8

This phosphor bronze wire contains 7% tin and is suitable for fusion welding of phosphor bronze castings and copper alloys (brass). It is also used for MIG brazing on ferrous and dissimilar metals or for applying a bearing surface.

ISO 24373 Cu 5180A (CuSn6P),
BS: 2901 C11

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO080807	48.35	WO080840	229.05	WO080812	530.80
1.0	WO081007	45.60	WO081040	212.85	WO081012	493.95
1.2	WO081207	43.40	WO081240	206.40	WO081212	477.90
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
7 Sn, Bal Cu		900-1050	260	80	124 & 125	

SIFMIG 328

This is a 92/8 aluminium bronze wire suitable for welding materials of a similar composition and copper alloys. It is ideal for MIG Brazing, dissimilar metal joints and maintenance applications.

ISO 24373 Cu 6100 (CuAl17),
BS: 2901 C28

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl	
0.8	WO320840A	254.50	WO320812A	579.15	
1.0	WO321040A	247.65	WO321012A	564.05	
1.2	WO321240A	235.80	WO321212A	536.40	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
8 Al, Bal Cu		1030	430	85	

SIFMIG 44

Nickel aluminium bronze for AB2 material and marine/corrosive applications.

ISO 24373 Cu 6328 (CuAl9Ni5Fe3Mn2),
BS: 2901 C20/C26

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl	
0.8			WO440812	1,323.90	
1.2	WO441240	490.90	WO441212	1,203.15	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
83 Cu, 9 Al, 3 Fe, 4 Ni, 1 Mn		1050	700	290	

SIFMIG 968

A copper wire containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for MIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications.

ISO 24373 Cu 6560 (CuSi3Mn1),
BS: 2901 C9

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO960807	41.70	WO960840	176.65	WO960812	★398.00
1.0	WO961007	39.50	WO961040	168.10	WO961012	★373.65
1.2			WO961240	163.90	WO961212	★368.30
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
1 Mn, 3 Si, Bal Cu		980-1020	350	90	120	

SIFMIG 985

High quality wire containing a minimum of 98.5% copper with deoxidizing elements. It is ideal for MIG welding of copper.

ISO 24373 Cu 1898 (CuSn1)
BS: 2901 C7

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl	
0.8	WO980840	235.35	WO980812	505.80	
1.0	WO981040	209.50	WO981012	490.90	
1.2	WO981240	203.30	WO981212	474.20	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.25 Mn, 0.25 Si, Bal Cu		1025	220	70	124

Surcharge Info



Due to metal market volatility, it may be necessary to add a surcharge to the detailed prices from time to time. Please note that we have indicated appropriate icons for each product sector i.e.

- AL** - aluminium
- CU** - brazing and copper alloys
- NI** - nickel bearing
- SS** - stainless steel, by grade
- STL** - steel



Test Certificates



All Sif and Hilco consumables are manufactured to controlled specifications.

Test Certificates are available for each product, and can be supplied - on request - with your orders. Test Certificates can also be re-produced for up to 3 months following your order. Test Certificate requests beyond 3 months will incur a charge of £25.00 to cover administration costs.

Distributors can obtain Test Certificates from our website eCommerce system 24/7.

Steels, Flux cored wire & Anti Spatter STL

SIFMIG SG2

Copper coated mild steel MIG wire for welding mild and medium tensile steels, for impact toughness down to -20C

EN ISO 14341-A G3Si1

EN 440 G3Si1, (BS 2901: A18) (Din SG2)

Dia mm	Art #	0.7kg Spl	Art #	5.0kg Spl	Art #	15kg Spl	Art #	250kg Spl
0.6	WA180607	4.90	WA180650	20.95	WA180615	68.80		
0.8	WA180807	4.15	WA180850	19.60	WA180815	45.65	WA1808250	675.00
1.0			WA181050	17.20	WA181015	42.85	WA1810250	643.75
1.2					WA181215	42.15	WA1812250	637.50
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.1 C, 0.8 Si, 1.3 Mn		1450		400		120		126

SIFMIG SG3

Copper coated steel MIG wire with increased silicon and manganese for improved UTS.

EN ISO 14341-A G4Si1

EN 440: G4Si1, (Din SG3)

Dia mm	Art #	15kg Spl						
0.8	WG030815	52.20						
1.0	WG031015	49.70						
1.2	WG031215	47.85						
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.1C, 1.0Si, 1.75Mn		1450		600		120		136

SIFMIG A15

Triple deoxidised mild steel MIG wire.

EN ISO 636-A W2Ti

BS: 2901 A15



Dia mm	Art #	15kg Spl						
0.8	WA150815	108.80						
1.0	WA151015	103.65						
1.2	WA151215	97.05						
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.1 C, 0.6 Si, 1.3 Mn, 0.2 Al		1450		440		120		136

SIFMIG A32

A copper coated, alloy steel wire containing 1.0% chromium and 0.5% molybdenum. It is ideal for low alloy and creep resistant steels.

EN ISO 21952-A G CrMo1Si (1CM)

BS: 2901 A32

Dia mm	Art #	15kg Spl						
0.8	WA320815	162.70						
1.0	WA321015	147.15						
1.2	WA321215	136.25						
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 1.3 Cr, 0.5 Mo		1450		500		180		136

SIFCORED E71T-1

Rutile flux cored wire for welding thin sheet steels or low alloyed structural steels in all positions. Argon/CO2 shielding gas.

AWS: E71T-1

Dia mm	Art #	15kg Spl						
1.0	WO711015 ★	87.25						
1.2	WO711215 ★	69.50						
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.05C, 0.6Si, 1.3Mn		1450		520		120		

SIFMIG GASLESS

Self shielding steel MIG wire; ideal for DIY use

AWS: E71T-GS



Dia mm	Art #	0.45kg Spl	Art #	0.9kg Spl	Art #	4.55kg Spl		
0.8	WG180805 ★	10.80	WG180809	18.00	WG180845	97.65		
% Metal Composition		Melting°C		U.T.S. N/mm ²		Hardness BHN		SIF TIPS Page
0.25 C, 0.4 Si, 0.7Mn, 2.4 Al		1450		400		120		

SIF TIP DIP

Anti-spatter paste to protect MIG welding torches, jigs and fixtures. It is odourless, non-toxic, non flammable and does not contain silicones.

Art #	225g	Art #	500g
FXTIPDIP22	6.45 (20 tins per carton)	FXTIPDIP50 ★	9.20 (10 tins per carton)

Hardfacing & Stainless STL SS

SIFCORED 600

Metal cored wire for wear resistant surfacing parts of steel, cast steel and high Mn steel, subject to abrasion, metal to metal wear, impact and/or compression stresses.

Din 8555: MSG6-4Z-60

Dia mm	Art #	5.0kg Spl	Art #	15kg Spl	
1.0			WO601015	471.35	
1.2	WO601250	148.10	WO601215	341.80	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.5C, 0.6Si, 1.5Mn, 5.5Cr, 0.6Mo		n/a	n/a	600	

SIFMIG HF600

Solid hard facing MIG wire, for high wear resistance.

Din 8555: MSG6-GZ-60

Dia mm	Art #	5.0kg Spl	Art #	15kg Spl	
1.0	WF601050	216.20	WF601015	498.75	
1.2	WF601250	156.70	WF601215	361.75	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.45 C, 3 Si, 0.4 Mn, 9 Cr		1450	n/a	570-650	

SIFMIG 347

Stainless steel wire, niobium stabilised to prevent weld decay, giving excellent corrosion resistance. Suitable for use on 18/8 type stainless steel, Nb and Ti stabilised, such as 304, 321 and where the weld is subjected to temperatures above 400°C.

EN ISO 14343: 19 9 NbSi,
BS: 2901 347 S96

Dia mm	Art #	12.5/15kg Spl			
0.8	WO200815	192.35			
1.0	WO201015	172.05			
1.2	WO201215	160.75			
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.04 C, 0.8 Si, 1.5 Mn, 10 Ni, 20 Cr, 0.6 Nb		1440	650	180	125

SIFMIG 316LSI

A molybdenum bearing, stainless steel with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steels.

EN ISO 14343: 19 12 3 LSi,
BS: 2901 316 S93,
AWS A5.9 : ER316LSi (0.7kg)

Dia mm	Art #	0.7kg Spl	Art #	3.75kg Spl	Art #	12.5/15kg Spl
0.6	WO210607	18.80	WO210640	81.35	WO210612	182.35
0.8	WO210807	15.60	WO210840	63.25	WO210815	★120.05
1.0	WO211007	14.40	WO211040	57.30	WO211015	★114.60
1.2	WO211207	14.30	WO211240	53.90	WO211215	★113.55
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.8 Si, 1.5 Mn, 12 Ni, 19 Cr, 2 Mo		1440	650	180	125	

SIFMIG 308LSI

Stainless steel filler wire suitable for welding 18/8 (304) austenitic stainless steels, providing good corrosion and wear resistance.

EN ISO 14343: 19 9 LSi,
BS: 2901 308 S93

Dia mm	Art #	0.7kg Spl	Art #	3.75kg Spl	Art #	12.5/15kg Spl
0.8	WO330807	15.40	WO330840	61.05	WO330815	★125.35
1.0	WO331007	14.40	WO331040	59.65	WO331015	★117.30
1.2	WO331207	14.30	WO331240	58.80	WO331215	★115.70
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.8 Si, 1.5 Mn, 10 Ni, 21 Cr		1440	650	180	125	

SIFMIG 309LSI

This stainless steel wire contains higher chromium and Nickel. It can be used for joining material of similar composition and also dissimilar stainless steels.

EN ISO 14343: 23 12 LSi,
BS: 2901 309 S93

Dia mm	Art #	3.75kg Spl	Art #	12kg Spl	Art #	15kg Spl
0.8	WO340840	98.15	WO340812	171.40	WO340815	205.70
1.0	WO341040	88.85			WO341015	193.10
1.2	WO341240	85.10			WO341215	190.75
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.1 C, 0.4 Si, 1.5 Mn, 13 Ni, 26 Cr		1440	650	180	125	

SIFMIG 312

This is a 29.9 stainless MIG wire, suitable for difficult-to-weld steels (Mn steels, tool and spring steels), also dissimilar materials. High resistance to weld metal cracking.

EN ISO 14343: 29 9, BS: 2901 312S94

Dia mm	Art #	3.75kg Spl	Art #	15kg Spl	
0.8			WO350840	97.15	
1.0			WO351040	92.00	
1.2			WO351215	278.30	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1 C, 0.4 Si, 1.7 Mn, 9 Ni, 30 Cr, 0.1 Mo		1440	750	200	125

Low-Alloy MIG STL

SIFMIG 120S-G

A low-alloy MIG wire with Cr, Mo and Ni for high-strength steel applications such as earth-moving equipment and crane manufacture.

EN ISO 16834-A: G 89 4 M (Mn4Ni2CrMo),
AWS A5.28 ER120S-G

Dia mm	Art #	15kg Spl		
0.8	WG120815	174.00		
1.0	WG121015	164.90		
1.2	WG121215	160.00		
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.9Mn, 2.1Ni, 0.5Mo, 0.4Cr		690		

SIFMIG Ni2

A fine-gained low-alloy steel with 2% nickel for low-temperature applications requiring good toughness, such as offshore platform and pipeline construction.

Dia mm	Art #	15kg Spl		
1.0	WG721015	148.00		
1.2	WG721215	137.30		
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 2.1Ni, 1.0Mn		620		

CERAMIGUARD SPRAY

A protective ceramic spray specifically designed to prolong tip and shroud life in industrial MIG fabrication. In many applications, CeraMIGuard need only be applied once per shift, removing the need for regular anti-spatter application or the use of reaming stations. This results in increased efficiency & torch parts savings. Can also be applied to jigs, fixtures & cables to protect them from spatter adhesion.

Art #	400ml
EG5001	25.20



SIFLITE Helmet

SIFLITE

SIFlite is a variable-shade, auto darkening welding helmet, with adjustable sensitivity and delay, for MIG, Arc and TIG >50amps. It is comfortable to wear with a large viewing area.

CE: EN379, EN175, ANSI Z87.1

Art #	4 Helmets per Carton
FXADF913	89.75



Spare lens

5 x Inner Protection Lens for SIFlite

Art #	Pkt
EH228000	7.25

Spare lens

Outer Protection Lens for SIFlite (each)

Art #	Pkt
EH288420	0.96



TIG PROCESS

Additional Metal Surcharge(s) May Apply

TIG Special Alloys STL AL NI CU SS

SIFSTEEL STAINLESS 310

A solid corrosion-resistant, chromium-nickel rod for TIG welding heat-resistant austenitic steels with high 25% Cr / 20% Ni contents. Offers good general oxidation resistance - especially at high temperatures - and is therefore common in industrial furnaces and heat exchangers. Fully austenitic therefore sensitive to hot cracking.

EN ISO 14343 G 25 20,
AWS A5.9 ER310

Dia mm	Art #	2.5kg Ctn		
1.2	RT701225	588.40		
1.6	RT701625	560.60		
2.4	RT702425	530.60		
3.2	RT703225	507.10		
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 1.8Mn, 26Cr, 21Ni	1440	590	200	

SIFSTEEL Ni2

A fine-grained low-alloy TIG rod with 2% Nickel for applications such as pipeline and offshore platform construction, where good fracture-toughness is required at low temperatures (eg -60°C).

EN ISO 636-A W2Ni2,
AWS A5.28 ER80S-Ni2

Dia mm	Art #	5.0kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT721650	49.30	0.1C, 2.1Ni, 1.0Mn	620			
2.4	RT722450	46.40					
3.2	RT723250	44.90					

SIFALLOY No73

A copper-nickel-ferrous rod with 30% nickel particularly suitable for highly-stressed corrosion-resistant weld surfacing on cast iron and on unalloyed and low-alloyed steel in applications such as plant engineering. Also used in joining similar copper-nickel alloys, or providing seawater resistance.

ISO 24373 Cu7158 (CuNi30)

Dia mm	Art #	5.0kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT731650	350.20	30.7Ni, 0.5Fe, Cu Bal	1180	420	115	
2.4	RT732450	309.10					
3.2	RT733250	295.50					

SIFALLOY No79

A copper-nickel-ferrous rod with 10% nickel particularly suitable for highly-stressed corrosion-resistant weld surfacing on cast iron and on unalloyed and low-alloyed steel in applications such as plant engineering. Also used in joining similar copper-nickel alloys, or providing seawater resistance.

ISO 24373 Cu7061 (CuNi10)

Dia mm	Art #	5.0kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT791650	322.90	10.2Ni, 0.5Fe, Cu Bal	1120	300	80	
2.4	RT792450	281.70					
3.2	RT793250	274.90					

SIFALLOY No75

One of the most widely used titanium alloys. Its high strength, ability to be heat treated, weldability, excellent fatigue strength and hardness make this alloy excellent for industrial fans, pressure vessels, aircraft components, compressor blades, automotive and jet engine parts.

AMS 4954, AWS A5.16 ERTi-5

Dia mm	Art #	2.5kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT751625	961.50	0.5C, 5.8Al, Ti Bal			35	
2.4	RT752425	903.50					

SIFALLOY No76

A chromium-nickel-molybdenum alloy with niobium addition to provide high strength without heat-treatment. Highly corrosion-resistant and specified in aerospace, sour work (eg chemical pipeline) and nuclear applications.

EN ISO 18274 SNI6625
(NiCr22Mo9Nb)

Dia mm	Art #	2.5kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.2	RT761225	596.40	58Ni, 21Cr, 5Fe, 9Mo	1290	930	190	
1.6	RT761625	546.80					
2.4	RT762425	518.60					
3.2	RT763225	495.70					

SIFSTEEL STAINLESS DUPLEX

A 2209 duplex rod for welding austenitic-ferritic stainless alloys where a high resistance to general corrosion, intergranular corrosion, pitting and stress corrosion is required. Increasingly popular in sour pipeline and offshore work.

EN 12072 W 22 9 3 N L
AWS A5.9 ER2209

Dia mm	Art #	5.0kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT741650	414.20	1.7Mn, 22.5Cr, 8.5Ni, 3.3Mo		765	240	
2.4	RT742450	385.30					
3.2	RT743250	377.10					

SIFSTEEL STAINLESS SUPER DUPLEX

A 2594 super duplex rod for welding austenitic-ferritic stainless alloys where a high corrosion resistance is required. Increasingly popular in the pulp & paper industry, and in the offshore oil and gas pipeline sector.

EN 12072 W 25 9 4 N L
AWS A5.9 ER2594

Dia mm	Art #	5.0kg Ctn	% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.6	RT781650	713.30	0.4Mn, 25.0Cr, 9.8Ni, 4.0Mo		850	250	
2.4	RT782450	661.90					
3.2	RT783250	643.00					

Aluminium AL

SIFALUMIN No 14

A pure aluminium (99.5% min) shaved rod which produces a ductile weld equal in strength to that of the base metal. The weld is capable of being hammered, stretched and drawn into shape without fracture.

EN ISO 18273 - S Al 1070 (AI99.7), BS: 2901 1050A, (GIB) (NG3)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO141601	22.80	RO141625	38.00
2.4	RO142401	19.20	RO142425	32.00
3.2	RO143201	18.40	RO143225	30.65
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	90	15	118

SIFALUMIN No 15

An Aluminium alloy with 5% silicon giving excellent flow characteristics and penetration. Suitable for welding duralumin, cast (LM25) and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised.

EN ISO 18273 S Al 4043A (AlSi5), BS: 2901 4043A, (NG21)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO151601	17.20	RO151625	★ 27.90
2.4	RO152401	16.15	RO152425	★ 25.30
3.2	RO153201	15.25	RO153225	★ 24.90
5.0			RO155025	31.05
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Si, Bal Al	635	120	40	118

SIFALUMIN No 16

Aluminium rod containing 12% silicon. It has good mechanical properties, excellent corrosion resistance. Suitable for silicon bearing cast aluminium alloys and wrought alloys. Do not use if fabrication is to be anodised.

EN ISO 18273 S Al 4047A (AlSi12), BS: 2901 4047A, (NG2)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO161601	28.05	RO161625	★ 46.70
2.4	RO162401	23.85	RO162425	★ 39.70
3.2	RO163201	22.85	RO163225	★ 38.05
5.0			RO165025	44.20
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
12 Si, Bal Al	585	150	50	118

SIFALUMIN No 27

A general purpose aluminium rod containing 5% magnesium that has excellent corrosion resistance and high strength. Suitable for welding magnesium bearing aluminium alloys such as 5251 (N4), 5154 (N5), 5454 (N51) and also heat treatable alloys 6063 (H9), 6061 (H20) and 6082 (H30).

EN ISO 18273 S Al 5356 (AlMg5), BS: 2901 5356, (NG6)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO271601	17.85	RO271625	★ 28.85
2.4	RO272401	15.80	RO272425	★ 25.65
3.2	RO273201	14.75	RO273225	★ 25.25
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Mg, Bal Al	640	250	60	118

SIFALUMIN No 28

Special aluminium alloy containing 5% Magnesium and 0.75% Manganese, for improved weld strength.

EN ISO 18273 S Al 5183 (AlMg4.5Mn0.7), BS: 2901 5183

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO281601	27.30	RO281625	45.45
2.4	RO282401	23.10	RO282425	38.45
3.2	RO283201	22.05	RO283225	36.75
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Mg, 0.75 Mn, Bal Al	640	275	65	118

SIFALUMIN No 37

Aluminium alloy containing 5.3% Magnesium: all elements are closely controlled for optimum weld strength. Normally used on 5083 (N8) and for military applications.

EN ISO 18273 S Al 5556A (AlMg5Mn), BS: 2901 5556

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO371601	27.30	RO371625	★ 45.45
2.4	RO372401	23.10	RO372425	★ 38.45
3.2	RO373201	22.05	RO373225	★ 36.75
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5.3Mg, 0.8Mn, 0.1Cr, 0.1Ti, Bal Al	640	300	70	118

SIF MAGNESIUM No 23

Magnesium rod with 6% Aluminium suitable for welding magnesium aluminium alloy castings of similar composition, crankcases, gearboxes, sumps, wheels etc.

AZ61A

Dia mm	Art #	12 rod/packet	Art #	1kg Pkt
3.0	RO233212	70.40	RO233201	277.65
% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
6 Al, 0.6 Zn, 0.3Mn, Bal Mg	610	280	N/A	

Copper & Tig Brazing CU

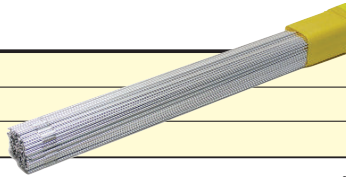
SIFSILCOPPER No 7 HQ

Refined especially for TIG applications, with an improved surface finish, No7 HQ is an easy-flowing, porosity-free rod for deoxidised copper. Suitable for copper tanks, pipe, sheet and bar. For standard No7 (for oxy/fuel) see page 120.

EN ISO 24373 Cu 1897 (CuAg1), BS 1453 C1

Dia mm	Art #	5.0kg Ctn
1.6	RO071650HQ	298.00
2.4	RO072450HQ	269.30
3.2	RO073250HQ	251.00

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1 Ag, Bal Cu	1060	200	75	124



SIFPHOSPHOR BRONZE No 8

The phosphor bronze rod contains 7% tin and is suitable for fusion welding of phosphor bronze castings and copper alloys (brass). It is also used for TIG brazing on ferrous and dissimilar metals.

ISO 24373 Cu 5180A (CuSn6P), BS: 2901 C11

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO081201	76.70	RO081225	141.30	RO081250	255.45
1.6	RO081601	72.90	RO081625	130.65	RO081650	243.00
2.4	RO082401	61.75	RO082425	110.55	RO082450	205.60
3.2	RO083201	59.90	RO083225	107.15	RO083250	199.55

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
7 Sn, Bal Cu	900-1050	260	80	121

SIFPHOSPHOR BRONZE No 82

Phosphor bronze rod with 12% Tin, for improved colour match on brass and bronze.

ISO 24373 Cu 5410 (CuSn12P), BS: 2901 C27

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO821601	111.50	RO821625	200.00	RO821650	371.50
2.4	RO822401	89.10	RO822425	157.00	RO822450	296.95

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
12 Sn, 0.2 P, Bal Cu	850-1000	320	120	124

SIFALBRONZE No 32

This is a 90/10 aluminium bronze rod suitable for welding materials of a similar composition. It is used for surfacing and dissimilar metal joints, also TIG brazing on ferrous and dissimilar metals.

ISO 24373 Cu 6180 (CuAl10Fe), BS: 2901 C.13

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO321601	87.70	RO321625	157.50	RO321650	292.25
2.4	RO322401	80.70	RO322425	144.45	RO322450	268.95
3.2	RO323201	76.15	RO323225	136.80	RO323250	253.85

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
10 Al, 1 Fe, Bal Cu	1030	500	95	121

SIFALBRONZE No 44

Nickel aluminium bronze for AB2 material and marine/corrosive applications.

ISO 24373 Cu 6328 (CuAl9Ni5Fe3Mn2), BS: 2901 C20/C26

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RO442401	109.70	RO442425	197.05	RO442450	365.55

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
83 Cu, 9 Al, 3 Fe, 4 Ni, 1 Mn	1050	700	290	

SIFSILCOPPER No 968

A copper rod, containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for TIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications.

ISO 24373 Cu 6560 (CuSi3Mn1), BS: 2901 C9

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO961201	56.40	RO961225	101.70	RO961250	187.90
1.6	RO961601	52.45	RO961625	97.30	RO961650	★175.90
2.4	RO962401	45.75	RO962425	82.15	RO962450	★149.00
3.2	RO963201	42.85	RO963225	76.75	RO963250	★139.65

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1 Mn, 3 Si, Bal Cu	980-120	350	90	121

SIFSILCOPPER No 985

High quality rod containing a minimum of 98.5% copper with deoxidizing elements. It is ideal for TIG welding of copper.

ISO 24373 Cu 1898 (CuSn1) BS: 2901 C7

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO981201	72.20	RO981225	124.55	RO981250	240.60
1.6	RO981601	69.35	RO981625	121.10	RO981650	231.00
2.4	RO982401	59.05	RO982425	106.05	RO982450	196.55
3.2	RO983201	57.30	RO983225	102.00	RO983250	189.60

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.25 Mn, 0.25 Si, Bal Cu	1025	220	70	124

Stainless & Pickling Paste SS

SIFSTEEL STAINLESS 347

Stainless steel filler rod, niobium stabilised to prevent weld decay, giving excellent corrosion resistance. Suitable for use on 18/8 type stainless steel, Nb and Ti stabilised, such as 304, 321 and where the weld is subjected to temperatures above 400°C

EN ISO 14343: 19 9 Nb,
BS: 2901 347S96

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.0	RO201001	28.35	RO201025	50.35	RO201050	97.70
1.2	RO201201	24.90	RO201225	44.60	RO201250	86.45
1.6	RO201601	21.95	RO201625	36.00	RO201650	69.80
2.4	RO202401	21.60	RO202425	33.35	RO202450	64.70
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.04 C, 0.4 Si, 1.5 Mn, 10 Ni, 20 Cr 0.6 Nb		1440	650	180	125	

SIFSTEEL STAINLESS 316L

A molybdenum bearing, stainless steel filler rod with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steels.

EN ISO 14343: 19 12 3 L,
BS: 2901 316S92

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
0.8	RO210801	35.05	RO210825	56.10		
1.0	RO211001	29.85	RO211025	47.50	RO211050	★ 83.90
1.2	RO211201	27.70	RO211225	41.70	RO211250	★ 72.00
1.6	RO211601	20.90	RO211625	30.50	RO211650	★ 43.70
2.4	RO212401	20.55	RO212425	30.00	RO212450	★ 42.90
3.2	RO213201	19.90	RO213225	28.80	RO213250	★ 41.40
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.4 Si, 1.5 Mn, 12 Ni, 19 Cr, 2 Mo		1440	650	180	125	

SIFSTEEL STAINLESS 308L

Stainless steel filler rod suitable for welding 18/8 (304) austenitic stainless steels, providing good corrosion and wear resistance.

EN ISO 14343: 19 9 L,
BS: 2901 308S92

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.6	RO331601	20.00	RO331625	32.40	RO331650	★ 57.15
2.4	RO332401	19.45	RO332425	31.55	RO332450	★ 55.70
3.2	RO333201	18.70	RO333225	30.10	RO333250	★ 53.15
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.4 Si, 1.5 Mn, 10 Ni, 21 Cr		1440	650	180	125	

SIFSTEEL STAINLESS 309LSI

This stainless rod contains higher chromium and nickel. It can be used for joining material of similar composition and also dissimilar stainless steels.

EN ISO 14343: 23 12 LSi,
BS: 2901 309S93

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.6	RO341601	22.65	RO341625	37.30	RO341650	★ 64.60
2.4	RO342401	20.35	RO342425	33.50	RO342450	★ 58.50
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.7 Si, 1.8 Mn, 13 Ni, 23 Cr		1440	650	180	125	

SIFSTEEL STAINLESS 312

This is a 29.9 stainless TIG filler rod, suitable for difficult-to-weld steels (Mn steels, tool and spring steels), also dissimilar materials. High resistance to weld metal cracking.

EN ISO 14343: 29 9,
BS: 2901 312S94

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.0	RO351001	36.90	RO351025	75.70	RO351050	146.75
1.2	RO351201	34.20	RO351225	70.05	RO351250	135.95
1.6	RO351601	28.30	RO351625	57.30	RO351650	111.20
2.4	RO352401	27.35	RO352425	55.30	RO352450	107.25
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.1 C, 0.4 Si, 1.7 Mn, 9 Ni, 30 Cr, 0.1 Mo		1440	750	200	125	

SIF PICKLING PASTE & BRUSH

Pickling Paste is used to clean discoloration of the surface in the weld area and restore chrome oxide layer on the stainless.

Art #	2kg Jar	Art #
FXPICK20	51.45 (6 jars per carton)	FXBRUSH 12.25

£35.00 hazardous goods freight surcharge applies to all shipments.



NEUTRALISING PASTE

Used to neutralise any residual substance after using pickling paste.

Art #	2kg Jar
FXPICKNP	45.05

Steel **STL**

SIFSTEEL A15

A copper-coated triple deoxidised mild steel rod. Used with the TIG process it enables sound porosity free welds to be made on mild and low-alloy steels. Typical applications include pipe welding and root runs on heavy vessels.

EN ISO 636-A : 2008 W2Ti
BS: 2901 A15, AWS ER70S-2,
EN 1668: W2Ti

Dia mm	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.0	RA151025	44.25	RA151050	70.80
1.2	RA151225	35.30	RA151250	56.30
1.6	RA151625	25.75	RA151650	★40.55
2.4	RA152425	23.70	RA152450	★37.05
3.2	RA153225	22.05	RA153250	★35.90

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 0.6Si, 1.3Mn, 0.2Al	1450	440	120	126

SIFSTEEL A17

Low carbon, double deoxidised rod for TIG welding mild steel.
BS: 2901 A17

Dia mm	Art #	5.0kg Ctn
1.6	RA171650	67.60
2.4	RA172450	63.40

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 0.3 Si, 1 Mn	1450	400	120	126

SIFSTEEL A18

Copper coated deoxidised steel rod for TIG welding of mild steel.

EN ISO 636-A
W3Si1
BS: 2901 A18,
AWS ER70S-6



Dia mm	Art #	5.0kg Ctn
1.0	RA181050	64.40
1.2	RA181250	56.80
1.6	RA181650	51.85
2.4	RA182450	47.70
3.2	RA183250	44.30

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 1 Si, 1.3 Mn	1450	400	120	126

SIFSTEEL A31

A copper-coated alloy steel rod containing 0.5% molybdenum. Suitable for use on low temperature pressure vessel and pipe work applications.

EN ISO 14341-A G4Mo
BS: 2901 A31, AWS: ER 80S-D2

Dia mm	Art #	5.0kg Ctn
1.6	RA311650	69.15
2.4	RA312450	59.45

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1 C, 0.7 Si, 1.8 Mn, 0.5 Mo	1450	460	180	126

SIFSTEEL A32

A copper coated alloy steel rod containing 1.0% chromium, 0.5% molybdenum. Ideal for creep resistant steels of a similar composition.

EN ISO 21952-A W CrMo1Si (1CML)
BS: 2901 A32, AWS ER80S-B2

Dia mm	Art #	5.0kg Ctn
1.0	RA321050	127.95
1.2	RA321250	106.10
1.6	RA321650	100.30
2.4	RA322450	93.20

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 1.3 Cr, 0.5 Mo	1450	500	180	126

SIFSTEEL A33

A copper-coated alloy steel rod containing 2.5% chromium, 1.0% Molybdenum. It is suitable for high temperature and pressure applications on materials of similar composition.

EN ISO 21952-A W CrMo2Si (2C1M)
BS: 2901 A33, AWS ER90S-B3

Dia mm	Art #	5.0kg Ctn
1.6	RA331650	125.05
2.4	RA332450	114.65

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 2.4 Cr, 1 Mo	1450	525	200	126

SIFSTEEL HF6

Hard surfacing rod for metal to metal wear, such as wire guides, high speed steel, die and tool steel.

Dia mm	Art #	12 rod/Pkt	Art #	1.0kg Pkt
1.6	ROHF61612	50.10	ROHF61601	183.60
2.4	ROHF62412	94.00	ROHF62401	162.85

% Metal Composition	Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1 C, 0.5 Si, 0.3Mn, 4Cr, 8Mo, 2V, 1.5W	n/a	n/a	60 HRC	

Copper/Phosphorous & Silver Solder CU

SIFCUPRON No 17

This copper phosphorus alloy rod is self-fluxing on copper. Its good electrical conductivity and corrosion resistance make it ideal for copper tubing, switchgear, motors etc.

EN ISO 17672 CuP 180
EN 1044: CP201, BS: 1845 CP3

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.5	RO171501	49.70	RO171525	★88.30	RO171550	★165.55
2.4	RO172401	48.10	RO172425	★86.10	RO172450	★160.10
3.2	RO173201	46.75	RO173225	★85.30	RO173250	★155.65
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
7 P, Bal Cu		705-800	500	200	122	

SIFCUPRON No 17-2Ag

A copper phosphorus alloy with the addition of 2% silver to improve ductility and flowing characteristics. Highly resistant to corrosion and not subject to dezincification. It is ideal for hot water cylinders, electric motors and also general maintenance work.

EN ISO 17672 CuP 280
EN 1044: CP105, BS: 1845 CP2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO181601	91.95	RO181625	★177.20	RO181650	★328.30
2.4	RO182401	85.50	RO182425	★164.20	RO182450	★305.35
3.2	RO183201	82.70	RO183225	★159.50	RO183250	★295.25
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
2 Ag, 6 P, Bal Cu		645-740	430	195	122	

SIFCUPRON No 17-5Ag

Copper/Phosphorus alloy with 5% silver, having ductility and capillary flow characteristics between 17-2 AG and 17-15 AG.

EN ISO 17672 CuP 282
EN 1044: CP104, BS: 1845 CP4

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.5	RO1815015Ag	152.70	RO1815255Ag	289.80	RO1815505Ag	545.10
2.5	RO1825015Ag	151.25	RO1825255Ag	288.00	RO1825505Ag	540.15
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
5 Ag, 6 P, Bal Cu		645-730	600	190	122	

SIFCUPRON No 17-15Ag

Copper/Phosphorus alloy with 15% silver for stressed applications. Ideal for poor fitting joints.

EN ISO 17672 CuP 284
EN 1044: CP102, BS: 1845 CP1

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt		
1.5			RO181506	35.95		
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
15 Ag, 5 P, Bal Cu		645-700	640	185	122	

SIF SILVER SOLDER No 39

CADMIUM FREE silver solder suitable for use on all ferrous and non-ferrous metals, except aluminium. It can be used with a range of heat sources. Use SIF SILVER SOLDER flux.

EN ISO 17672 Ag 138

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt	Art #	1kg Pkt
1.5			RO391506	53.00	RX391500	POA
2.0					RX392000	POA
2.5	RO392504	80.70			RX392500	POA
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
38 Ag, 32 Cu, 28 Zn, 2 Sn		650-725	460	140	122	

SIF SILVER SOLDER No 40

A popular grade of Silver Solder offering good capillary action and ductility in many ferrous and non-ferrous applications. Use with SIF SILVER SOLDER flux.

EN ISO 17672 Ag 140

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt	Art #	1kg Pkt
1.5					RX401500	POA
2.0					RX402000	POA
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
40 Ag, 30 Cu, 28 Zn, 2 Sn		670-710	440	130	122	

SIF SILVER SOLDER No 43

CADMIUM FREE 55% Silver Solder, which is free flowing and ideal for close fitting capillary joints and for colour match on stainless. Use SIF SILVER SOLDER flux.

EN ISO 17672 Ag 155
EN 1044: AG 103, BS: 1845 AG14

Dia mm	Art #	6 rod/Pkt	Art #	1kg Pkt		
1.5	RO431506	70.20	RX431500	POA		
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
55 Ag, 21 Cu, 22 Zn, 2Sn		630-660	415	145	122	

SIF SILVERCOTE No 43

CADMIUM FREE Silver Solder No.43 with full flux coating.

EN ISO 17672 Ag 155
EN 1044: AG 103, BS: 1845 AG14

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt	Art #	1kg Pkt
1.5			RR431506	89.35	RR431501	POA
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
55 Ag, 21 Cu, 22 Zn, 2Sn		630-660	415	145	122	

For SIF Silver Solder bulk 1kg; nett prices available on application.

General Brazing (Silicon Bronze), Nickel Bronze CU

SIFBRONZE No 1

Original multi-purpose Sifbronze low temperature rod for brazing and bronze welding of steels, cast iron, copper and its alloys. Ideally suited for general mild steel work, galvanised steel and dissimilar metal applications. Use SIFBRONZE flux.

EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO011601	32.80	RO011625	★ 62.85	RO011650	★ 117.25
2.4	RO012401	29.50	RO012425	★ 56.75	RO012450	★ 105.40
3.2	RO013201	27.15	RO013225	★ 52.15	RO013250	★ 96.95
4.8					RO014850	96.95
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	122 & 123	

SIFREDICOTE No 1

This rod is Sifbronze No.1 with a full flux coating providing the added benefit of faster, continuous brazing through not having to flux-dip. It is ideally suited for general mild steel work, galvanised steel and dissimilar metal applications.

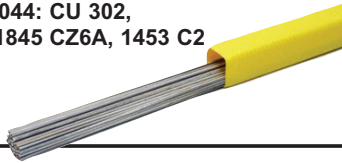
EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RR011601	57.50	RR011625	★ 108.85		
2.4	RR012401	39.70	RR012425	★ 75.55	RR012450	★ 140.70
3.2	RR013201	32.85	RR013225	★ 63.85	RR013250	★ 118.25
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	122	

SIF AUTOBRONZE

Free flowing flux impregnated brazing rod, ideal for brazing clean mild steel.

EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2



Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RS412401	44.05	RS412425	85.20	RS412450	165.60
3.2	RS413201	40.90	RS413225	80.45	RS413250	153.70
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	122	

SIFBRONZE No 101

A special brazing rod containing specific additions of Manganese and Tin, giving it free flowing characteristics. It is particularly suitable for use with 'gas flux'.

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.5	RO101501	37.15	RO101525	72.00	RO101550	134.40
2.0	RO102001	34.25	RO102025	66.30	RO102050	122.40
2.5	RO102501	32.40	RO102525	62.15	RO102550	115.65
3.0	RO103001	30.65	RO103025	58.30	RO103050	109.60
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
60 Cu, 0.2 Mn, 0.1 Si, 0.1 Sn, Bal Zn		870-890	460	130	122 & 123	

SIFBRONZE No 2

Brazing rod containing 9% nickel, for use on cast iron, copper alloys, stainless and alloy steels. It has excellent wearing properties and high strength making it ideal for tubular structures, brazing cutting tips and as a general maintenance alloy. Use SIFBRONZE or SIF TOOL TIP/BRAZE STAINLESS flux.

EN ISO 17672 Cu773
EN 1044: CU305,
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO021601	78.55	RO021625	150.70	RO021650	280.40
2.4	RO022401	68.40	RO022425	131.15	RO022450	244.05
3.2	RO023201	63.25	RO023225	121.15	RO023250	225.80
4.8					RO024850	225.80
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
48 Cu, 10 Ni, 0.3 Si, Bal Zn		920-980	540	200	122 & 123	

SIFREDICOTE No 2

This rod is Sifbronze No.2 with a full flux coating and with similar characteristics. The UTS is approximately 25% greater than Sifredicote No.1 and is ideal for high strength production and maintenance applications.

EN ISO 17672 Cu773
EN 1044: CU305,
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RR022401	87.25	RR022425	167.60	RR022450	311.65
3.2	RR023201	72.85	RR023225	139.40	RR023250	259.50
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
48 Cu, 10 Ni, 0.3 Si, Bal Zn		920-980	540	200	122	

Aluminium, Cast Iron, Copper, Stainless **AL** **NI** **CU** **SS****SIF FLUXCORE ALUMINIUM**

Flux cored 5% Silicon Aluminium rod: ideal for oxy/acetylene general repair work.

Dia mm	Art #	1kg Pkt			
3.0	RO153001F	76.40			
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5 Si, Bal Al		635	120	40	118

SIF 555 AL SOLDER

Self fluxing solder for use on Aluminium and its alloys. Separate instruction sheet available.

Dia mm	Art #	12 rod/Pkt	Art #	1kg Pkt	Art #	2.5kgCtn
3.0	RO553212	23.55	RO553201	68.40	RO553225	140.40
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
93 Zn, 4 Al, 3 Cu		380	200	100	119	

SIFALUMIN No 16

A rod for brazing aluminium that enables strong, neat joints to be easily produced. Difficulties can occur on alloys containing magnesium in excess of 2% and high silicon alloys. Use SIF ALUMINIUM flux.

EN ISO 17672 Al 112
EN ISO 18273 S Al 4047A (AlSi12),
BS: 2901 4047A, (NG2)

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn		
1.6	RO161601	28.05	RO161625	★46.70		
2.4	RO162401	23.85	RO162425	★39.70		
3.2	RO163201	22.85	RO163225	★38.05		
5.0			RO165025	44.20		
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
12 Si, Bal Al		585	150	50	119	

SIFSILCOPPER No 7

An easy flowing, high quality copper rod for full fusion welding of deoxidised copper. Suitable for fabrication and repairs to copper pipes, tanks etc. Use SIFSILCOPPER flux.

EN 14640 Cu 1897 (CuAg1),
BS:1453 C1

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO071601	77.85	RO071625	139.70	RO071650	259.10
2.4	RO072401	70.25	RO072425	125.85	RO072450	234.20
3.2	RO073201	65.50	RO073225	118.55	RO073250	218.25
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
1 Ag, Bal Cu		1060	200	75	124	

SUPER SILICON No 9

The rod is suitable for full fusion welding of cast iron, providing a high strength weld metal which is easily machinable. It gives an excellent colour match and has the same structure as grey cast iron. Use SIF CAST IRON flux.

Dia mm	Art #	1kg Pkt			
4.0	RO094001	31.80		Art #	5.0kg Ctn
5.0				RO094050	128.35
6.0				RO095050	118.90
10.0				RO096050	100.60
				RO091050	78.30
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
3.3 C, 3.0 Si, 0.7 Mn, 0.1 S, 0.5 P		1250	200	180	126

SIF SUPER SG CAST IRON

This rod is suitable for full fusion oxy-acetylene welding of Spheroidal Graphite cast iron, providing a machinable weld.

Use SIF CAST IRON flux.

Dia mm	Art #	1kg Pkt			
6.0	RO296001	26.70		Art #	5.0kg Ctn
10.0				RO296050	113.05
				RO291050	85.90
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
3.7 C, 2.5 Si, 0.1 Mn		1250	400	190	126

SIFSTEEL STAINLESS 308L

Stainless steel filler rod suitable for welding 18/8 (304) austenitic stainless steels. For gas welding use SIF STAINLESS flux.

EN ISO 14343: 19 9 L,
BS: 2901 308S92

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO331601	20.00	RO331625	32.40	RO331650	★57.15
2.4	RO332401	19.45	RO332425	31.55	RO332450	★55.70
3.2	RO333201	18.70	RO333225	30.10	RO333250	★53.15
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.02 C, 0.4 Si, 1.5 Mn, 10 Ni, 21 Cr		1440	650	180	125	

Steel

SIFSTEEL No 11

A low-carbon mild steel rod ideal for all types of mild steel and wrought iron welding. It is free-flowing and produces a high strength ductile weld. It is copper coated to ensure long shelf life. Particularly suitable for sheet metal panels, plates, tubes and fittings.

EN 12536 01
BS: 1453 A1, EN 12536: 01

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO111601	7.25	RO111625	15.85	RO111650	★ 25.50
2.4	RO112401	6.75	RO112425	14.90	RO112450	★ 23.40
3.2	RO113201	6.35	RO113225	13.80	RO113250	★ 22.35
4.8					RO114850	25.20
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page	
0.06 C, 0.4 Mn		1450	350	120	126	

SIFSTEEL No 22

A special alloy steel rod containing manganese for toughness. It provides a weld deposit of high strength and ductility. Recommended for oxy/acetylene welding of pipelines and pressure vessels.

EN 12536: 011, BS: 1453 A2

Dia mm	Art #	5.0kg Ctn			
1.6	RO221650	50.40			
2.5	RO222550	47.70			
3.0	RO223050	46.30			
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1 C, 0.1 Si, 1.1 Mn		1450	450	140	126

Flux powder & GasFlux

ALUMINIUM

Powder fluxes for gas welding and brazing aluminium and its alloys.
EN 1045 - FL10

Art #	500g Jar
FO140050	26.20 For brazing and low-melting point alloys
FO360050	34.25 For welding and higher-melting-point alloys

CAST IRON

Powder flux for fusion welding cast iron.
EN 1045 - FH20

Art #	500g Jar
FO090050	18.40

SIFBRONZE

Powder flux for general brazing work.
EN 1045 - FH10

Art #	225g Jar	Art #	500g Jar
FO010022	10.80	FO010050	★ 16.55

ECO FLUX PASTE

A pre-mixed paste at optimal liquidity free of boric acid and suitable for brazing of mild steel and copper alloys.
EN 1045 - FH10

Art #	350g Jar
FO050035	27.75

SIFSILCOPPER

Powder flux for brazing and welding copper alloys.
EN 1045 - FH11

Art #	500g Jar
FO070050	21.55

SILVER SOLDER

Powder flux for silver solder operations.
EN 1045 - FH10

Art #	500g Jar
FO380050	★ 44.15

TOOL TIP/BRAZE STAINLESS

Powder flux for Tool Tipping or brazing stainless with Sifbronze No 1 or No 2. Also for oxy/fuel welding of stainless.
EN 1045 - FH12

Art #	500g Jar
FO020050	27.30

SIF GASFLUX LIQUID

Specially formulated liquid of Methanol and trimethylborate, which allows fuel gas (acetylene) to absorb flux into the torch flame. It is a flammable liquid UN No 1993 and is supplied in 3 litre plastic containers.

EN 1045 - FH10 £35 hazardous goods freight surcharge applies to all shipments.

Art #	3L container	Qty	SIF TIPS page
FXGF3L	225.80	4 containers per ctn	123

GASFLUXER - MODEL 69-D

Gas fluxer unit with removeable filling tank.

Art #	SIF TIPS page
FXGF69D	1,229.15
	123



ROD LENGTH	Diameter mm	1.0	1.2	1.6	2.4	3.2	4.8
1000mm	Aluminium			200	90	48	20
	Brazing & Copper		105	60	28	15	7
	Flux Coated			42	25	14	
	Stainless & Steel	170	115	65	30	16	7

ROD LENGTH	Diameter mm	1.5	2.5	4.0	6.0	10.0
500mm	Cast Iron			16	7	3
	Silver Solder (bare)	119	44			
	Sil Sol flux coated	80				

SIFTRODE STL

SIFTRODE 6013

General purpose multi-positional rutile-coated mild steel electrode with stable arc and easy-lifting slag.

CE EN13479

AWS A5.1: E 6013
EN ISO 2560 E 42 0 RC 11



Dia mm	Art #	2.0kg Pkt	Art #	5.0kg Ctn	Pcs/Pkt
1.6	RE601602	★ 21.85			285
2.5			RE602550	★ 18.80	265
3.2			RE603250	★ 17.80	170
4.0			RE604050	★ 17.80	115

SIFTRODE 7018

Basic-coated low-hydrogen electrode with high efficiency and good mechanical properties.

AWS A5.1: E 7018
EN ISO 2560 E 42 4 B 42 H5

Dia mm	Art #	5.0kg Ctn	Pcs/Pkt
2.5	RE702550	★ 26.20	220
3.2	RE703250	★ 24.75	140
4.0	RE704050	★ 24.75	90

CE EN13479

SIFTRODE 7016 SPEZIAL

A vac-packed rutile-basic-coated spezial low-hydrogen electrode for all positions. Suitable for mild, medium/high-tensile and low-alloy steels and as a buffer layer.

EN 499 E 38 3 B 42 H10,
AWS A5.1 E 7016

Dia mm	Art #	5.0kg Vac
2.5	RE712550V	62.30
3.2	RE713250V	60.90
4.0	RE714050V	59.70

SIFTRODE 7024

An iron-powder rutile-coated electrode with about 150% efficiency. For butt & fillet welds on medium to thick plates in shipbuilding and structural steel.

EN ISO 2560-A: E 42 0 RR 54,
AWS A 5.1: E7024

Dia mm	Art #	5.0kg Ctn
2.5	RE723250	41.10
3.2	RE724050	37.10
4.0	RE725050	34.90

SIFTRODE 6010

A vac-packed cellulosic electrode for pipe welding, performing well in all positions, especially vertical down.

EN 499 E 42 3 C 25,
AWS A5.1 E 6010

Dia mm	Art #	5.0kg Tin
2.5	RE612550V	93.50
3.2	RE613250V	90.90
4.0	RE614050V	86.00

SIFCHROME 225

A stable, low-spatter electrode with 2.25% Cr and 1.0% Mo for creep- and heat-resistance (<600°C). Suited to pressure-vessel, power-plant and refinery applications.

AWS A5.5 E 8018-B3L

Dia mm	Art #	5.0kg Vac
2.5	RC222550V	131.10
3.2	RC223250V	130.00
4.0	RC224050V	127.30

SIFTRODE STAINLESS 316

A stainless electrode for austenitic CrNiMo steels. Good appearance.

AWS A5.4: E 316L-16

Dia mm	Art #	2.5kg Pkt	Pcs/Pkt
2.5	RE3162525	★ 69.60	120
3.2	RE3163225	★ 67.65	65

SIFTRODE STAINLESS 312

High Cr/Ni dissimilar electrode for welding of difficult-to-weld steels.

AWS A5.4: E 312-16

Dia mm	Art #	2.5kg Pkt	Pcs/Pkt
2.5	RE3122525	★ 89.65	125
3.2	RE3123225	★ 87.20	65

Hilco - Steel STL

HILCO RED EXTRA

Universal electrode for welding in all positions, including vertical downwards. Especially suitable for construction work where the use of one single type of electrode is permissible. Very attractive weld appearance. Suitable for both AC and DC current and will operate with low OCV, min 42v.

AWS: E6013,
EN ISO 2560: E 42 0 RC 11

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.0	H01013020H	4.1kg	390 ★	43.95	
2.5	H01013525H	5.0kg	275 ★	25.65	
3.2	H01013532H	5.0kg	173 ★	23.80	
4.0	H01013540H	5.0kg	112 ★	24.80	
5.0	H01013550H	5.0kg	71 ★	30.80	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.12C, 0.4Si, 0.6Mn		n/a	>500	n/a	126

HILCO VELVETA

Electrode for welding in all positions, especially vertical upwards. The quiet and easily controllable molten pool makes it suitable for pipe welding. Easy striking and restriking. Suitable for AC and DC current; will operate on low OCV, min 42v.

AWS: E6013,
EN ISO 2560: E 42 0 RR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H01033525P	4.8kg	250 ★	44.55	
3.2	H01033532P	5.0kg	160 ★	43.25	
4.0	H01033540P	4.6kg	100 ★	36.30	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 0.4Si, 0.6Mn		n/a	>510	n/a	126

HILCO VELORA

'Slow freezing' electrode for welding in all positions, except vertical down. The stable and easily controllable molten pool makes it suitable for thin sheet or pipe welding. Easy striking and restriking. Suitable for AC and DC current; will operate on low OCV, min 42v.

AWS: E6013,
EN ISO 2560: E 42 0 RR 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H01053525P	4.1kg	200 ★	37.55	
3.2	H01053532P	4.3kg	125 ★	37.30	
4.0	H01054540P	5.6kg	80 ★	46.00	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.08C, 0.4Si, 0.6Mn		n/a	>500	n/a	126

HILCO BASIC SUPER

Universal basic coated low hydrogen electrode suitable where high demands on impact value (even at low temperatures) are required. Excellent welding characteristics in all positions (except vertically downwards) on both AC/DC current. Suitable for pipe welding. Excellent X-ray quality. Smooth welding characteristics and an easy slag release.

AWS: E7018-1,
EN ISO 2560: E 46 4 B 32 H5

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H01193525P	4.1kg	200 ★	38.75	
3.2	H01193532P	4.1kg	110 ★	33.30	
4.0	H01194540P	5.8kg	90 ★	45.45	
5.0	H01194550P	5.9kg	60 ★	45.35	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.05C, 0.5Si, 1.0Mn		n/a	> 550	n/a	126

HILCO BASIC 55

Double coated basic electrode for welding in all positions (except vertically downwards) of unalloyed steels. Electrode has excellent weldability, good slag release and smooth weld appearance.

AWS: E7016,
EN ISO 2560: E42 2 RB 12 H10

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H01353525P	3.9kg	200 ★	52.95	
3.2	H01354532P	5.3kg	125 ★	59.25	
4.0	H01354540P	5.2kg	80 ★	53.75	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.06C, 0.7Si, 0.9Mn		n/a	>510	n/a	126

HILCO REGINA 160

Rutile electrode with a recovery of 160%. Especially suitable for fillet welding and the filling of V-butts. Excellent welding characteristics, self releasing slag. Due to the high recovery and excellent weldability Regina 160 is very economical in usage.

AWS: E7024,
EN ISO 2560: E 42 0 RR 53

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
3.2	H01124532P	5.9kg	90 ★	57.55	
4.0	H01124540P	5.7kg	55 ★	51.15	
5.0	H01124550P	5.4kg	35 ★	52.00	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 0.4Si, 0.6Mn		n/a	>510	n/a	126



Hilco - Hard Face, Cast Iron, Copper, Aluminium STL NI CU AL

HILCO HARDMELT 600

Basic coated electrode for wear resistant surfacing of steel, cast steel, and high Mn-steel, which are subjected to abrasion, metal to metal wear, impact and/or compression stresses.

EN 14700 E Fe6

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
3.2	H01423532P	4.5kg	130	61.75	
4.0	H01424540P	5.9kg	90	79.55	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.5C, 2.3Si, 0.4Mn, 9Cr		n/a	n/a	600	

HILCO CUTIL CUTTING

An electrode for cutting, gouging and piercing of all metals, including stainless, cast, and non-ferrous alloys, at a high cutting speed.

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
3.2	H07498132	4.0kg	80	65.85	
4.0	H07498340	4.0kg	72	65.45	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
		n/a	n/a	n/a	

HILCO PURE NICKEL

Electrode with a pure nickel core for welding grey cast iron, for joining cast irons to other ferrous or non-ferrous metals. Heat affected zone and weld metal easily machinable. Especially suitable for welding contaminated cast iron and repair work.

AWS: E Ni C1, DIN: E Ni BG 22

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H0290350125P	1.0kg	58	154.15	
3.2	H0290350132P	1.0kg	31	153.30	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.5C, 0.1Si, 0.2Mn, 2.3Fe, bal Ni		n/a	n/a		

HILCO NICKEL IRON

Electrode with a nickel iron core for repair welding and joining all types of cast iron. Weld metal and heat affected zone are both easily machinable. Especially recommended for joints in which severe demands are made on the strength of the weld.

AWS: E NiFeC1, DIN: E NiFe BG 22

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H0291350125P	1.0kg	54	71.50	
3.2	H0291350132P	1.0kg	32	68.95	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.9C, 0.7Si, 0.8Mn, 53Ni, bal Fe		n/a	n/a	n/a	

HILCO BRONSIL

Tin-bronze electrode for use on copper, copper alloy, phosphor and tin-bronzes. Also, minor repair work on cast iron and C/Mn steels. Preheat workpiece to approx. 250°C. Maintain workpiece temperature during welding.

AWS: E CuSn-C, DIN 1733: EL -CuSn7

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
3.2	H02013532P	2.0kg	58	203.85	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
1.5Mn, 0.5Si, 7.5Sn, 0.2Fe, 0.1P, bal Cu		n/a	>280	n/a	124

HILCO ALUMINIL S15

Aluminium electrode (5% Silicon) for welding, repairing and surfacing forged and cast Al-Si alloys and joining dissimilar aluminium alloys with max. 7% Si content.

AWS: E 4043, DIN 1732: EL AISi 5

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
3.2	H02033532T	2.0kg	152	105.40	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
5Si, 0.05Mn, 0.05Cu, bal Al		n/a	>160	n/a	118

HILCO ALUMINIL S112

Silicon alloyed aluminium electrode for welding of all types of aluminium castings and applications, where good colour matching with base materials is important.

AWS: E 4047, DIN 1732: EL-AISi 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H02023525T	2.0kg	227	134.90	
3.2	H02023532T	2.0kg	152	128.45	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
12Si, 0.1Mn, bal Al		n/a	>180	n/a	118

Hilchrome - Stainless **SS**

HILCHROME 308 R

Rutile coated electrode for welding austenitic stainless steel (304). Suitable for dairy and cold storage applications. Self-releasing slag and an excellent weld appearance.

AWS: E308L-17, EN 1600: E 19 9 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.0	H023083020T	3.6kg	320 ★	164.90	
2.5	H023083525T	3.5kg	200 ★	122.85	
3.2	H023083532T	4.0kg	120 ★	131.45	
4.0	H023083540T	4.3kg	85 ★	137.90	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.03C, 0.8 Si, 0.8Mn, 19.8 Cr, 10.2 Ni		n/a	>550	n/a	125

HILCHROME 316 R

Rutile coated electrode for welding molybdenum alloyed 18/12 and similar Cr/Ni/Mo steels. High resistance against general and intergranular corrosion. Self-releasing slag and an excellent weld appearance.

AWS: E316L-17, EN 1600: E 19 12 3 LR 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
1.5	H023162515	1.7kg	300 ★	133.50	
2.0	H023163020T	3.6kg	320 ★	182.55	
2.5	H023163525T	3.5kg	200 ★	123.95	
3.2	H023163532T	4.1kg	120 ★	134.90	
4.0	H023163540T	4.3kg	85 ★	154.70	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.03C, 0.8Si, 0.8Mn, 18.8Cr, 11.7Ni, 2.7Mo		n/a	>550	n/a	125

HILCHROME 309 R

Rutile coated electrode for welding corrosion resistant and heat resistant Cr/Ni steels, joining dissimilar metals and buffering. Self-releasing slag and an excellent weld appearance.

AWS: E309L-17, EN 1600: E 23 12 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H023093025T	3.6kg	200	156.05	
3.2	H023093532T	4.4kg	130	178.90	
4.0	H023093540T	4.6kg	90	185.45	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.02C, 0.7Si, 0.7Mn, 22.7Cr, 12.5Ni		n/a	>550	n/a	125

HILCHROME 309Mo R

Rutile coated electrode for joining similar and dissimilar stainless steels, buffering, joining hardenable and difficult-to-weld steels. Self-releasing slag and an excellent weld appearance.

AWS: E309 MoL-17, EN 1600: E 23 12 2 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H023093025MT	3.7kg	200	184.60	
3.2	H023093532MT	4.6kg	125	215.35	
4.0	H023093540MT	4.7kg	90	214.30	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.02C, 0.7Si, 0.8Mn, 23Cr, 12.5Ni, 2.7Mo		n/a	>750	n/a	125

HILCHROME 312 R

Rutile coated high Cr/Ni electrode for welding of difficult-to-weld steels like armour plate, austenitic Mn steel, high carbon steel and Cr/Ni steels. Self-releasing slag and an excellent weld appearance.

AWS: E312-17, EN 1600: E 29 9 R 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt	
2.5	H023123025T	3.5kg	200	181.75	
3.2	H023123532T	4.2kg	130	203.40	
4.0	H023123540T	4.3kg	90	198.15	
% Metal Composition		Melting°C	U.T.S. N/mm ²	Hardness BHN	SIF TIPS Page
0.1C, 1.2Si, 0.7Mn, 28.5Cr, 9.5Ni		n/a	>800	n/a	125

Over 90 years, Hilco has grown to be both an experienced and modern supplier of high quality welding consumables, covering the needs of welders in over 100 countries worldwide.

Their range of specialist arc electrodes are specified by many fabrication, marine and petrochemical welders for their consistent reliable performance.

