

APPLICATION	PROCEDE				
	TIG OK Tigrod	Electrode enrobée	MIG/MAG OK Autrod	Fil Fourré OK Tubrod	Arc submergé OK Autrod/OK Flux
SOUDEGE DES ACIERS COURANTS					
Tôles fines	OK 12.60	OK 46.44 OK 46.27	OK 12.51 / OK 12.50	OK 14.12 OK 14.13	Fils Flux OK 12.10 OK 10.81
Emploi general	OK 12.60	OK 46.08 / OK 46.27 OK 48.00 OK 48.04 OK 48.05 OK 48.10 OK 55.00 OK 48.68	OK 12.51 / OK 12.50 OK 12.51 Marathon OK 12.58 OK 12.58 Marathon OK 12.64	OK 14.13 OK 15.18 OK 15.14 OK 15.12 OK 15.00 OK 15.17	OK 12.10 OK 10.71 OK 12.20 OK 10.71
Soudage d'angle à plat et fortes épaisseur		OK 33.60 OK 33.80 OK 38.65	OK 12.51	OK 15.18 OK 15.12 OK 14.13	OK 12.20 OK 10.81
Soudage des pipelines		OK Pipeweld 6010 OK Pipeweld 7010 OK Pipeweld 8010	OK 12.66	OK 15.14	
Tôles galvanisées		OK 46.00	OK 19.40 / OK 19.30		
Aciers patinables (Corten)		OK 73.08	OK 13.26	OK 14.01	OK 13.36 OK 10.71
SOUDEGE DES ACIERS A HAUTES LIMITE ELASTIQUE					
Limites d'élasticité :					
- Re> 500 MPa		OK 74.78	OK 13.08	OK 14.02	OK 13.40 OK 10.62
- Re> 620 MPa		OK 75.75	OK 13.29	OK 14.03	OK 13.43 OK 10.62
- Re> 890 MPa		OK 78.16			
SOUDEGE DES ACIERS POUR EMPLOI A TEMPERATURE ELEVEE (>400°C)					
Température de service :					
0,5 Mo	OK 13.09	OK 74.46	OK 13.09	OK 14.02	OK 12.24 OK 10.71
1,25 Cr - 0,5 Mo	OK 13.12	OK 76.18 L	OK 13.12	OK 15.20	OK 13.10 OK 10.62
2,25 Cr - 1,0 Mo	OK 13.22	OK 76.28	OK 13.22	OK 15.22	OK 13.20 OK 10.62
5 Cr - 0,5 Mo		OK 76.35			
9 Cr - 1,0 Mo		OK 76.96			
Inox 25/20	OK 16.70	OK 67.13 OK 67.15	OK 16.70		
SOUDEGE DES ACIERS POUR EMPLOI A BESSE TEMPERATURE					
Température de service :					
- 40°C	OK 13.28	OK 48.08	OK 13.17	OK 14.04 / OK 15.17	OK 13.27 OK 10.62
- 60°C	OK 13.28	OK 73.68	OK 13.27	OK 15.25	OK 13.27 OK 10.62
- 90°C	OK 19.85	OK 73.79	OK 19.85		OK 19.85 OK 10.16
- 105°C	OK 19.85	OK 92.26	OK 19.85		OK 19.85 OK 10.16
- 196°C	OK 19.82	OK 92.45 OK 92.55	OK 19.82		OK 19.82 OK 10.16
SOUDEGE DES ACIERS SPECIAUX OU DIFFICILEMENT SOUDABLE					
		OK 67.45 OK 67.52 OK 68.82 OK 67.70	OK 16.95 OK 16.75	OK 14.71	
SOUDEGE DES FONTES					
		OK 92.18 OK 92.58 OK 92.60		OK 15.66	

APPLACATION	PROCEDE				
	TIG OK Tigrod	Electrode enrobée	MIG/MAG OK Autrod	Fil Fourré OK Tubrod	Arc submerge OK Autrod/OK Flux
SOUDEAGE DES ALLIAGES D'ALLUMINIUM					
Alliages fonderies, reparatio		OK 4043	OK 96.50	OK 4043	
Alliages corroyés	OK 1070 OK 5356 OK 5183 OK 5556		OK 1070 OK 5356 OK 5183 OK 5553		
SOUDEAGE DES ALLIAGES CUIVREUX					
		OK 94.25 OK 94.55	OK 19.12 OK 19.14		
SOUDEAGE DES ACIER INOXYDABLE ET DES ALLIAGES RESISTANT A LA CORROSION SEVERE					
Aciers du type 18/8	OK 16.10	OK 61.30 / OK 61.35 OK 61.41	OK 16.12	OK 14.30 OK 14.20	OK 16.10 OK 10.92 OK 16.10 OK 10.93
Aciers du type 18/8 travaillant à > 400°C	OK 16.11	OK 61.80 OK 61.85	OK 16.11	OK 14.34	OK 16.21 OK 10.92 OK 16.21 OK 10.93
Aciers du type 18/8/3	OK 16.30	OK 63.30 / OK 63.35 OK 63.41 OK 63.34	OK 16.32	OK 14.31 OK 14.21	OK 16.30 OK 10.92 OK 16.30 OK 10.93
Aciers du type 18/8/3 travaillant à > 400°C	OK 16.31	OK 63.80 OK 63.85	OK 16.31		OK 16.41 OK 10.93
Aciers réfractaire 25/20	OK 16.70	OK 67.15 / OK 67.13			OK 16.70 OK 10.92
Aciers Duplex (ex. URANUS 45 N)	OK 16.86	OK 67.50 OK 67.55	OK 16.86	OK 14.27 OK 14.37	OK 16.86 OK 10.93
URANUS B6	OK 16.55	OK 69.33 OK 69.63	OK 16.55		
13% Cr (409)				OK 15.36	
13% Cr (410)		OK 68.15			
17.4.1		OK 68.37			
Résistance acide phosorique (317L)		OK 64.30			
Aciers blindage	OK 16.95	OK 63.35	OK 16.95		
Assemblage « hétérogène » (Acier Noir/Inox)	OK 16.53	OK 67.60 OK 67.62	OK 16.51	OK 14.22 OK 14.32	OK 16.53 OK 10.92 OK 16.53 OK 10.93
Inconel82-Incolony 800/801	OK 19.85	OK 92.26	OK 19.85		OK 19.85 OK 10.16
Inconel 625 Inconel 800	OK 19.82	OK 92.45	OK 19.82		OK 19.82 OK 10.16
PRODUITS DE RECHARGEMENT DUR					
Aciers 13% Mn		OK 86.08 OK 86.28 OK 86.20		OK 15.60 OK 15.65	
Aciers alliés au chrome (30 – 40 HRC)		OK 83.28 OK 83.30	OK 13.89	OK 15.40 OK 15.41 OK 15.43	OK 15.42 OK 10.71 OK 12.10 OK 10.96 OK 15.40 OK 1071
Aciers alliés au chrome (>50 HRC)		OK 83.50 OK 83.65	OK 13.91	OK 15.52 OK 15.50	
Carbure de Chrome Matrice Fer		OK 84.78 OK 84.40 OK 84.84		OK 14.70 OK 15.80	
Inox martensitiques		OK 84.42 OK 84.52		OK 15.76 OK 15.73 OK 15.70	
Aciers à outils		OK 85.65			
Carbure de Cr base Cobalt (Stellites)		OK 93.01 OK 93.06 OK 93.12			
DECOUPAGE – GOUGEAGE					
		OK 21.03			