

Pipe Mills

**AN
OERLIKON
MARKET
SOLUTION**





OERLIKON solutions for Pipe Mills

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Introduction



Air Liquide group, with its headquarters in Paris, France, is one of Europe's larger multinational companies with a consolidated turnover of 13,1 billion in 2008.

Air Liquide Welding, with a sales turnover of ~ 700 million, is represented throughout the world by individual ALW companies with a brand portfolio optimised locally to the needs of all types of customers. Oerlikon brand is an important part of this portfolio and has a long and distinguished history of innovation in welding products. These ALW companies are involved in many different areas of OERLIKON product design, development and application. The research and development centre, AL CTAS, is located in Paris and is the largest privately owned centre for welding R&D. This facilitates the rapid transfer and implementation of important innovations and advances in welding technology throughout the whole of the OERLIKON global network. The utilisation of the strengths and experience of this network enables OERLIKON to maintain its position and international reputation for innovative leadership at the forefront of advanced welding technology in both welding consumables and increasingly equipment and processes.

With this background, OERLIKON has generated a proven history of supplying welding consumables on an ongoing basis for the most demanding and critical applications, particularly in the energy sector to industries such as offshore oil and gas and nuclear power generation. OERLIKON has continued to work closely with owners, construction contractors and fabricators to supply customised solutions through performance and innovation by developing and supplying welding consumables and processes capable of meeting the stringent mechanical property specifications and increasingly the demands for enhanced welding productivity.

The results of this process of ongoing innovation and product development are demonstrated by the unrivalled range of OERLIKON welding consumables, specifically tailored for the high productivity pipe mill environment. OERLIKON welding consumables are now accompanied by extensive ranges of high quality arc welding and cutting equipment, manual through to fully automated installations, flame and workplace products.



OERLIKON and pipe mills



A commitment to technical excellence supported by a dedication to quality is regarded as fundamental to OERLIKON's success in high productivity fabrication.

Quality

OERLIKON has a total commitment to quality. The product ranges are manufactured in group production facilities, all of which are ISO certified. Detailed certification for welding consumables is supplied as a matter of routine and customers' special quality requirements for increased frequency of batch testing or specialised certification are also readily accommodated. This ensures the reliability and reproducibility fabricators need in the pipe fabrication industry.

Technical Service

OERLIKON's involvement with its products does not stop at manufacture. OERLIKON provides a close and detailed participation with the application of products, right from the initial selection to welding characteristics on site.

A team of highly qualified engineers is ready to respond in collaboration with the pipe mill, with the objective of providing technologically relevant and practical solutions.

A large information base is at the service of every customer to ensure the most cost effective selection of process and welding procedure to meet the needs of any application.

Flexibility

The OERLIKON product range is continuously developing in response to changing technological requirements. As new steel types are developed and used, as new more demanding applications are developed, so OERLIKON reacts to provide the right products, regularly meets engineering departments and major manufacturers at the design stage to ensure optimum welding solutions.

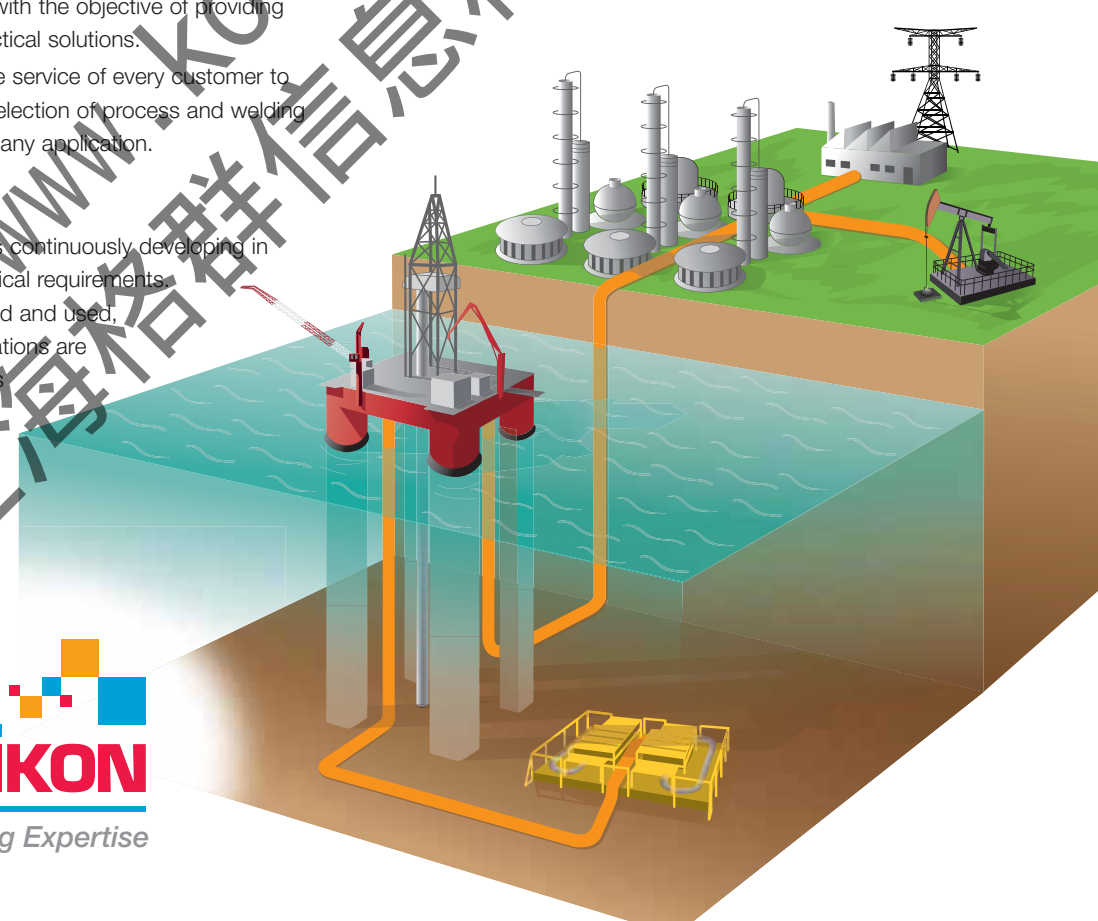
Information

All OERLIKON products are backed by a full technical information package, which is available in printed or electronic format, on the OERLIKON web sites. Product information is written to enable the professional welding engineer to select the correct OERLIKON product for the application.

In order to elaborate the technology of the product range in more detail, technical articles are available in the journal of OERLIKON's welding and cutting expertise, "Competence".

Track Record

OERLIKON is a technological innovator and major supplier of welding products to the pipe fabrication industry for significant projects. A track record of highly successful products combining quality and technology with technical service has been firmly established.



Demand the Welding Expertise

High Productivity Welding of Line Pipe



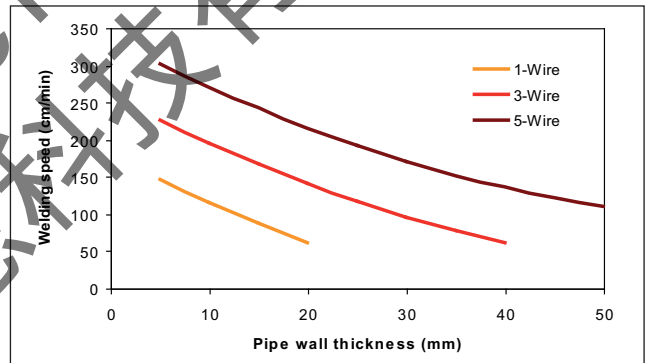
The drive for high productivity multiple wire submerged arc welding began in the late 1960s with the commercial industrialisation of tandem wire submerged arc welding. The deposition rate of the SAW process was increased to approximately 15 kg/hr. The advantages of adding additional wires in a pipe mill, highlighted the process difficulties in developing a sufficiently reactive method of controlling the current supply to each wire. This posed further challenges for consumable design in order to give effective slag characteristics and bead shape control at these higher welding speeds and heat inputs. By the late 1970s, 3 wire welding in pipe mills was commonplace and deposition rates of up to approximately 25 kg/hr were being achieved in pipe thicknesses up to 30 mm. By the mid 1980's, 5 wire welding was being introduced with full electronic control, achieving deposition rates of approximately 45 kg/hr for pipe ODs, for wall thicknesses in excess of 20 mm.

When OD longitudinal seam welding with 5 wires, the welding current is increased towards 5,000 A. To gain maximum productivity, welding speed must be as fast as possible (in excess of 2 m/min) consistent with reliable high speed wire feeding and the characteristics of the SAW flux. These are key

factors in determining the balance of heat input, penetration and bead shape.

OERLIKON submerged arc flux developments have been an important factor in achieving these increases in productivity as multi-wire systems were developed.

The current challenge is utilising these high levels of welding productivity to produce high toughness joints in higher strength grades of line pipe, X80 and X100, for high pressure gas transport.



Micro-Alloying with Titanium and Boron - the development of OERLIKON TIBOR solid SAW wires

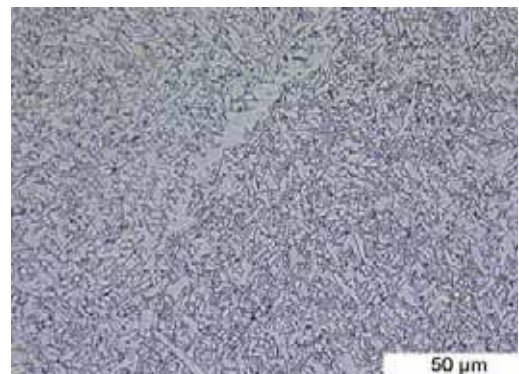
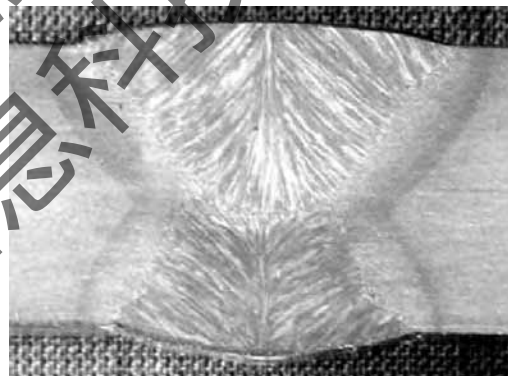


There are two principal approaches to achieving high toughness weld metal at low temperatures with modern pipe plate compositions. The first approach is to use the Mn-Mo alloying system and the second is to use the Mo-Ti-B system. The aim of both approaches is to achieve high levels of weld metal toughness through microstructural control. Correctly designed, these alloying systems delay transformation at the austenite grain boundaries during cooling of the weld metal, discouraging nucleation and growth of grain boundary ferrite allotromorphs and encouraging the nucleation and growth of acicular ferrite on inclusions in the intragranular regions. Both alloy systems require the use of semi- basic SAW fluxes, such as OERLIKON OP132, to control the oxygen content of the weld metal and hence the inclusion volume fraction and size distribution.

Improvements in weld toughness through welding consumable design are dependent on the variations in weld metal composition and inclusion characteristics as a result of dilution from the pipe plate, notably with the alloying elements nitrogen, aluminium, niobium and calcium. High productivity pipe welding is a high dilution process, where for example two pass welded joints can have 70% dilution of the weld bead from the pipe plate. Thus the steelmaking route and alloying regime of the pipe steel have a strong effect on the final weld metal chemistry and mechanical properties.

OERLIKON has pioneered the development of Ti/B type submerged arc welding consumables for demanding multi-wire, high speed, high arc energy longitudinal pipe welding applications. This led to the development of solid SAW wires based on the Mn-Mo-Ti-B system, firstly OE-TIBOR 22 and subsequently OE-TIBOR 33.

OERLIKON OE-TIBOR 33/OP 132 was specifically developed for the multi-wire, two pass, longitudinal seam welding of X65 pipe steels. High levels of CVM at -30 °C are achieved in the weld metal, while meeting X65 weld strength and requirements for hydrogen induced cracking (HIC) and sulphide stress corrosion cracking (SSCC).



Submerged arc wires and fluxes for pipe mill applications



OERLIKON's agglomerated submerged arc welding fluxes, in combination with the OERLIKON range of solid and Fluxocord wires, have achieved worldwide recognition as the first choice for quality submerged arc welding for a variety of reasons.

Technology

OERLIKON submerged arc wire specifications are designed to incorporate the state of the art technology and in combination with OERLIKON SAW fluxes, high levels of weld metal toughness are generated for specific alloy types. In addition, as new steels and applications are developed new OERLIKON wires are designed and introduced to the range.

Operating Characteristics

OERLIKON fluxes for pipe mill applications have stable high speed, multi-wire operation at high currents, together with excellent slag detachability.

Low Hydrogen Potential

OERLIKON SAW fluxes are designed and manufactured to give a low hydrogen potential in use. This minimises the risks of weld metal hydrogen (chevron) cracking in the welding of more hardenable pipe steels, even after recirculation. These flux characteristics are now enhanced by the OERLIKON DRYBAG packaging system, meaning that flux can be used with confidence, without reconditioning, in higher humidity conditions.



Toughness

Consistent CVN and CTOD at sub-zero temperatures in thicker wall pipe for fully sour service applications, through the right combination of wire and flux.

Reproducibility

Supporting the metallurgical rationale for OERLIKON agglomerated fluxes, the grain size distribution and agglomerate strength ensure reliable recirculation characteristics and consistent chemistry. This is most important when submerged arc welding.

Quality

All OERLIKON agglomerated fluxes and welding wires are produced in ISO certified group manufacturing plants, under the most stringent quality control systems.

Submerged arc wires and fluxes for pipe welding - Principal products



A selection of the most important welding consumable products for both longitudinal seam and spiral seam pipe welding are shown below, based on industry custom and practise. An overview of this product range selection is shown on page 12 or consult the OERLIKON Welding Consumables Product Data handbook or www.oerlikon-welding.com for full details.

OERLIKON SAW Wires

Product features

- Conformance to OERLIKON specifications and national standards where specified
- Optimised chemical alloying to maximise joint toughness
- Low levels of residual and impurity elements
- Closely controlled copper coating
- Consistent performance through control of:
 - Wire hardness
 - Cast
 - Helix
- High productivity bulk packaging options
- Full range of diameters available, 2.4 - 5.0mm

For details of the full range of FLUXOCORD wires, see "OERLIKON Welding Consumables Product Data" or www.oerlikon-welding.com

Solid wires

Type	AWS	EN	C	Mn	Si	S	P	Cr	Ni	Mo	
OE-S1	EL12	S1	0.1	0.5	0.1	<0.020	<0.020	--	--	--	
OE-S2	EM12K	S2	0.1	1	0.1	<0.020	<0.020	--	--	--	
OE-S2Mo	EA2	S2Mo	0.1	1	0.2	<0.020	<0.020	--	--	0.5	
OE-TIBOR 33	EA2TiB	SZ	0.07	1.2	0.3	<0.015	<0.015	--	--	0.5	+Ti,B
OE-SD3	EH12K	S3Si	0.1	1.7	0.3	<0.020	<0.020	--	--	--	
OE-SD3Mo	EA4	S3Mo	0.1	1.6	0.1	<0.020	<0.020	--	--	0.5	
OE-SD3 1Ni¼Mo	EG	SZ	0.1	1.5	0.25	<0.020	<0.020	--	1	0.3	
OE-SD3 1Ni½Mo	EF3	S3NiMo1	0.1	1.8	0.2	<0.020	<0.020	--	0.9	0.6	
OE-SD3 2NiCrMo	EG	S3Ni2.5CrMo	0.1	1.5	0.2	<0.020	<0.020	0.7	2.4	0.5	

Flux cored wires

Type	AWS A5.17	AWS A5.23	EN 756	C	Mn	Si	S	P	Cr	Ni	Mo
FLUXOCORD 31HD / OP 121TT(W)	F7AP8-EC1	-	S 35 6 FB T3	0.06	1.70	0.40	<0.020	<0.020	-	-	-
FLUXOCORD 41HD / OP 121TT(W)	-	F9AP8-EC-F3	S 50 6 FB T2Ni1Mo	0.05	1.30	0.20	<0.020	<0.020	-	0.90	0.50
FLUXOCORD 43.1 / OP 121TT(W)	-	-	-	0.05	1.40	0.10	<0.020	<0.020	-	1.80	0.35
FLUXOCORD 42 / OP 121TT(W)	-	F11A4-EC-F5	-	0.05	1.40	0.20	<0.020	<0.020	0.60	2.50	0.40
FLUXOCORD 83 / OP 121TT(W)	-	-	-	0.06	1.70	0.50	<0.020	<0.020	0.30	2.70	0.50

OERLIKON SAW Fluxes

The OERLIKON submerged arc fluxes most used in pipe mill applications are:

- **OP 119, OP 192P & OP 132.**
OP 119 is widely used for spiral seam welding
- **OP 192P & OP 132**
are used for both two pass longitudinal seam and spiral seam welding applications. These fluxes are optimised for high productivity performance in multi-wire, AC/DC, high welding speed pipe welding applications.
- **OP 121TT & OP121TTW**
are used in multi pass and special applications, particularly when maximum joint toughness at higher strength levels is required.

The OERLIKON range of submerged arc fluxes is very comprehensive and for specific pipe welding applications other SAW fluxes may be proposed by OERLIKON technical service, for example OP 122 and OP 178.

For details of the complete product range, consult "OERLIKON Welding Consumables Product Data" or www.oerlikon-welding.com

SAW Flux-wire data sheets

SAW Rutile-Acid Flux Line Pipe Applications

OP 119

OP 119 is an agglomerated calcium-silicate type flux with stable operating characteristics over a wide range of welding parameters, used extensively for the spiral seam welding of line pipe. The high current carrying capacity enables high levels of productivity to be attained using multi wire systems, for use with both AC and DC+. The slag is self releasing, to leave a

smooth bead profile without undercut. OP 119 donates manganese and silicon and is a cost effective choice with both OE-S1 & S2 wires. The slag freezes quickly and smaller diameter pipes and girth seams can be welded without run off. Damp flux should be re-dried at 300-350 °C for 1 hour.

Classification

EN 760 SA CS 1 77 AC H5

Applications

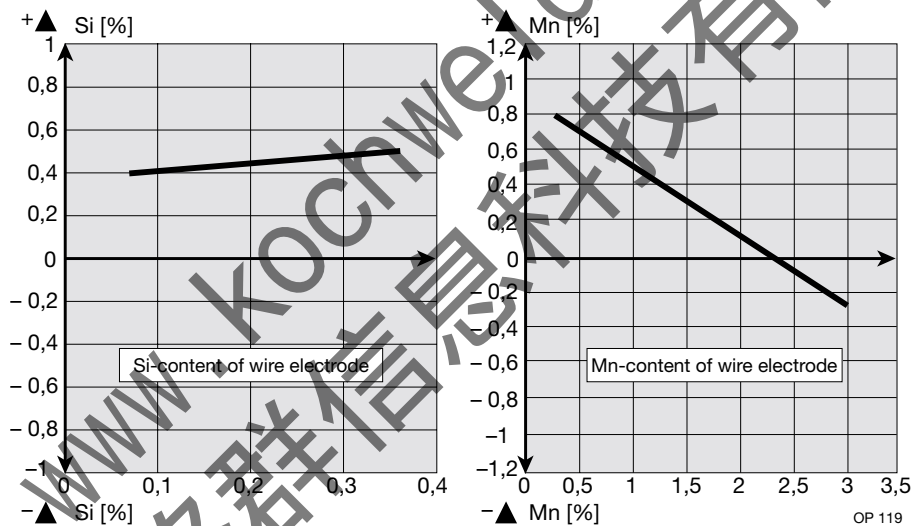
EN 10208-2	L240	L290	L360	L415	L450	L485	L555
API-5L / 5LS	B	X42 X46	X52	X56 X60	X65	X70	X80

Main Constituents & Basicity index

CaO+MgO	CaF ₂	Al ₂ O ₃ +MnO	SiO ₂ +TiO ₂
20%	10%	25%	40%
Boniszewski Basicity index: ~1.0			

Metallurgical Behaviour

Pick up and Burn out of the alloying elements Si & Mn = f (alloy content of the wire electrode)
DVS Merkblatt 0907 Part 1.



Main characteristics

Two-run technique

Chemical composition and mechanical properties (typical values) in the as welded condition on API 5L X70 pipe steel*

Wire Grade	AWS-A5.17 & A5.23	C	Mn	Si	Mo	Hardness HV 10	Yield strength MPa	Tensile strength MPa	Impact Energy - ISO-V (J)	
									0 °C	-20 °C
OE-S1	F7A0G-EL12	0.07	1.2	0.4	--	190	450	530	60	35
OE-S2	F8A0G-EM12K	0.07	1.4	0.4	--	200	500	590	70	35
OE-S2 Mo	F9A0G-EA2	0.07	1.4	0.4	0.2	220	560	630	100	50

* the chemical composition and mechanical properties of the weld metal are strongly dependant on the chemistry of the pipe steel.

Multi-run technique

Classification of all-weld-metal wire-flux combinations - All weld metal analysis and mechanical properties, as welded condition

Wire Grade	AWS-A5.17 & A5.23	C	Mn	Si	Mo	Yield strength MPa	Tensile strength MPa	A5 %	Impact Energy - ISO-V (J)	
									0 °C	-20 °C
OE-S1	F7A0 EL 12	0.05	1.1	0.5	--	>360	420-520	>24	>60	>30
OE-S2	F7A2 EM 12K	0.05	1.4	0.5	--	>400	520-620	>24	>80	>50
OE-S2 Mo	F8A0 EA2 A2	0.05	1.3	0.5	0.5	>480	600-700	>20	>50	>35

SAW Flux-wire data sheets

SAW Semi Basic Flux Line Pipe Applications

OP 192P

OP 192P is an agglomerated aluminate-basic flux with stable operating characteristics over a wide range of welding parameters, Used extensively for both the longitudinal and spiral seam welding of line pipe in single or multi pass applications. The high current carrying capacity enables high levels of productivity to be attained using multi wire systems, for use with both AC and DC+. The slag is self

releasing, to leave a smooth bead profile without undercut. High deposit toughness to -40 °C can be attained at a variety of strength levels depending on wire selection and welding technique.

Additional feature: Excellent weldability in thin plate applications. Damp flux should be re-dried at 300-350 °C for 1 hour.

Classification

EN 760 SA AB 1 67 AC H5

Applications

EN 10208-2	L240	L290	L360	L415	L450	L485	L555
API-5L / 5LS	B	X42 X46	X52	X56 X60	X65	X70	X80

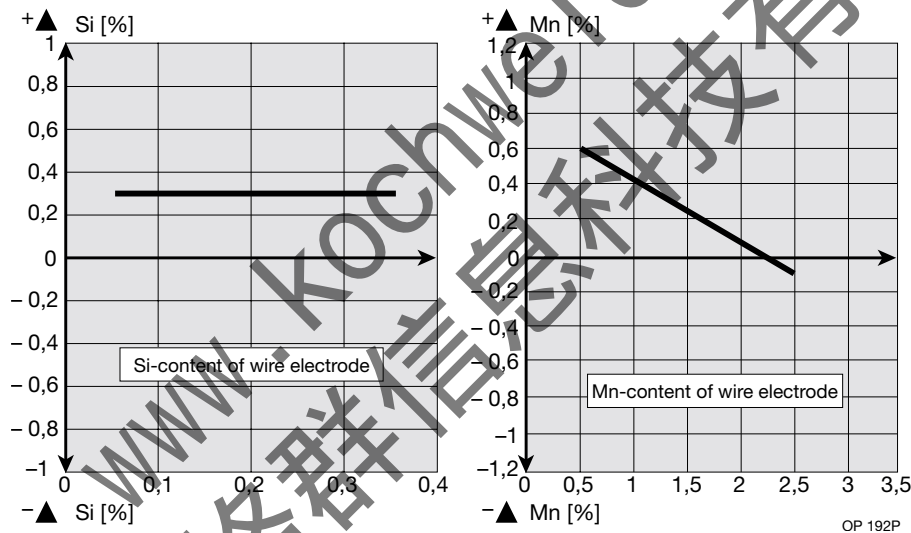
Main Constituents & Basicity index

MnO+FeO	CaO+CaF ₂ +MgO	Al ₂ O ₃ +T ₂ ZrO ₂	SiO ₂
8%	43%	28%	19%
Boniszewski Basicity index: ~1.3			

Metallurgical Behaviour

Pick up and Burn out of the alloying elements Si & Mn = f (alloy content of the wire electrode)

DVS Merkblatt 0907 Part 1.



Main characteristics

Two-run technique

Chemical composition and mechanical properties (typical values), as welded condition on API 5 L X80 pipe steel *

Wire Grade	AWS A5.23	C	Mn	Si	Mo	Others	Hardness HV 10	Yield strength MPa	Tensile strength MPa	Impact Energy - ISO-V (J)		
										-20 °C	-30 °C	-40 °C
OE-S2	F8TA0G-EM12K	0.07	1.4	0.35	--	--	200	500	590	80	--	--
OE-S2 Mo	F9TA2G-EA2	0.07	1.4	0.35	0.2	--	220	560	630	100	50	--
TIBOR 33	F9TA4G-EA2TIB	0.07	1.45	0.35	0.2	Ti, B	230	600	670	140	100	50

* the chemical composition and mechanical properties of the weld metal are strongly dependant on the chemistry of the pipe steel.

Multi-run technique

Classification of all-weld-metal wire-flux combinations - All weld metal analysis and mechanical properties, as welded condition

Wire Grade	AWS A 5.17 & A5.23	C	Mn	Si	Mo	Yield strength MPa	Tensile strength MPa	A5 %	Impact Energy - ISO-V (J)		
									-20 °C	-30 °C	-40 °C
OE-S2	F7AP4-EM12K	0.05	1.4	0.45	--	>400	480-580	>25	>100	>70	>27
OE-S2 Mo	F8AP2-EA2-A2	0.06	1.4	0.50	0.5	>470	570-680	>22	>60	>47	--
OE-SD3 Mo	F9AP2-EA4-A4	0.06	1.7	0.60	0.5	>550	630-720	>20	>50	>27	--

SAW Flux-wire data sheets

SAW Semi- Basic Flux Line Pipe Applications

OP 132

OP 132 is an agglomerated aluminate-basic flux with stable operating characteristics over a wide range of welding parameters. A global choice for both the longitudinal and spiral seam welding of line pipe in single or multi pass applications in combination with both solid and OE FLUXOCORD wires. The high current carrying capacity enables high levels of productivity to be attained using multi wire systems, for use with both AC and DC+.

The slag is self releasing, to leave a smooth bead profile without undercut. OP 132 donates manganese and excellent sub zero CVN and CTOD deposit toughness can be attained at higher strength levels, depending on wire selection and welding technique. The weld deposit is highly resistant to copper induced cracking. Damp flux should be re-dried at 300-350 °C for 1 hour.

Classification

EN 760 SA AB 1 67 AC H5

Applications

EN 10208-2	L290	L360	L415	L450	L485	L555	
API-5L / 5LS	X42 X46	X52	X56 X60	X65	X70	X80	X100

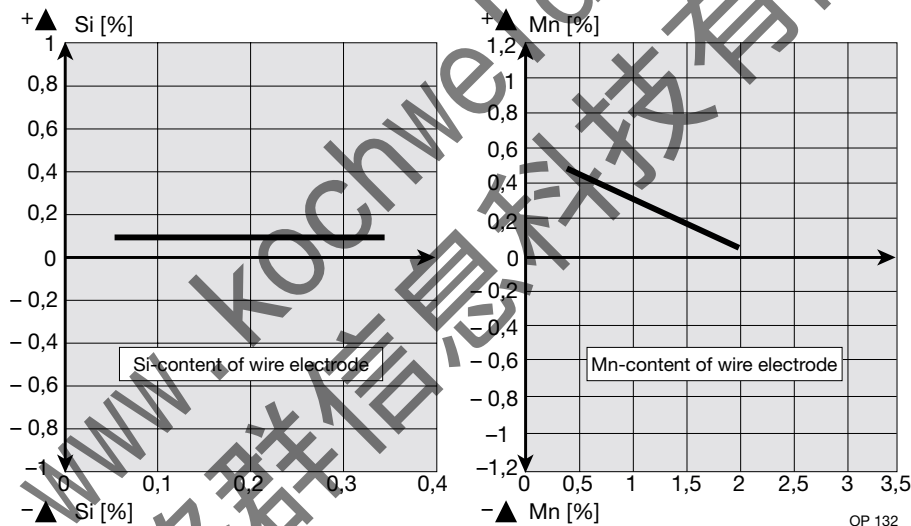
Main Constituents & Basicity index

CaO+MgO	CaF ₂	Al ₂ O ₃ +MnO	SiO ₂ + TiO ₂
25%	15%	35%	20%
Boniszewski Basicity index: ~1.5			

Metallurgical Behaviour

Pick up and Burn out of the alloying elements Si & Mn = f (alloy content of the wire electrode)

DVS Merkblatt 0907 Part 1.



Main characteristics

Two-run technique

Chemical composition and mechanical properties (typical values) in as welded condition on API 5L pipe steel*

Wire Grade	API 5L steel	AWS-A5.23	C	Mn	Si	Mo	Others	Hardness HV 10	Yield strength MPa	Tensile strength MPa	Impact Energy - ISO-V (J)			
											-20 °C	-30 °C	-40 °C	-50 °C
OE-S2	X70	F8TA2G-EM12K	0.07	1.4	0.25	--	--	200	500	590	80	--	--	--
OE-S2 Mo	X80	F9TA4G-EA2	0.07	1.4	0.25	0.2	--	220	560	630	100	70	--	--
TIBOR 33	X80	F9TA6G-EA2TiB	0.07	1.45	0.25	0.2	Ti, B	230	600	670	150	120	100	80
FC X100T	X100	F11TA4G-ECG	0.07	1.8	0.3	0.4	--	280	700	850	50	40	30	--

* the chemical composition and mechanical properties of the weld metal are strongly dependant on the chemistry of the pipe steel.

Multi-run technique

Classification of all-weld-metal wire-flux combinations - All weld metal analysis and mechanical properties, as welded condition

Wire Grade	AWS A 5.17 & A5.23	C	Mn	Si	Mo	Yield strength MPa	Tensile strength MPa	A5 %	Impact Energy - ISO-V (J)		
									-20 °C	-40 °C	-50 °C
OE-S2	F7A5-EM 12K	0.06	1.3	0.2	--	>400	480-510	>27	>140	>40	--
OE-S2 Mo	F8A5-EA2-A2	0.06	1.3	0.2	0.5	>470	550-620	>23	>110	>80	--
OE SD3 Mo	F9A5-EA4-A4	0.06	1.7	0.4	0.5	>540	620-660	>21	>100	>60	>50

SAW Flux-wire data sheets

SAW Basic Flux Pipe & Tubular Applications

OP 121TT

OP 121TT is a fully basic agglomerated flux with stable operating characteristics over a wide range of welding parameters. Used extensively for the welding of tubular sections, construction pipe and line pipe with both solid and OE FLUXOCORD wires in multi pass applications for as welded, stress relieved and fully heat treated applications. OP 121TT has a low hydrogen content of <5 ml H₂ per 100 g deposited weld metal in the as manufactured condition with a high resistance to moisture pick up during exposure under workshop conditions. The current carrying capacity of ~1000 A per wire enables high levels of productivity to be attained using single, twin, tandem and other multi wire systems, with both AC and DC+. The slag is easily removed, to leave a smooth bead profile and well blended toes. OP 121TT has a neutral flux characteristic for

manganese and silicon and can be used with a wide range of wires to achieve the highest strength levels while retaining excellent CVN and CTOD weld metal toughness. The slag freezes quickly and smaller diameter pipes and girth seams can be welded without run off.

Damp flux should be re-dried at 300-350 °C for 1 hour.

OP 121TTW is an agglomerated flux with high basicity, B.I. ~3.1, with a very low diffusible hydrogen content of <4 ml H₂ per 100 g deposited weld metal. It is used for welding steels with high hardenability such as X100 or thicker sections of higher strength steels. OP 121TTW is particularly suitable in combination with the OE FLUXOCORD range of cored wires for submerged arc welding.

Classification

EN 760 SA FB 55 AC H5

Applications

EN 10208-2	L290	L360	L415	L450	L485	L555	
API-5L / 5LS	X42 X46	X52	X56 X60	X65	X70	X80	X100

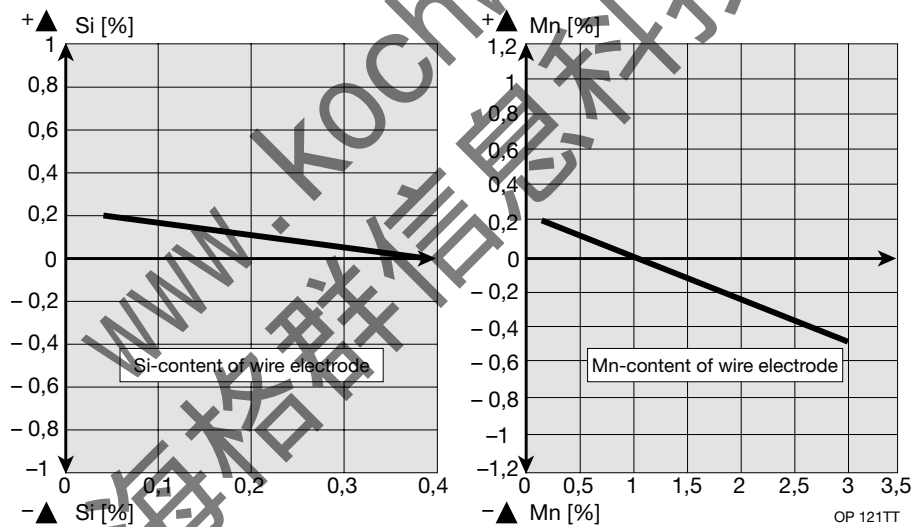
Main Constituents & Basicity index

CaO+MgO	CaF ₂	Al ₂ O ₃ +MnO	SiO ₂ + TiO ₂
40%	25%	20%	15%
Boniszewski Basicity index: ~3.1			

Metallurgical Behaviour

Pick up and Burn out of the alloying elements Si & Mn = f (alloy content of the wire electrode)

DVS Merkblatt 0907 Part 1.



Main characteristics

Multi-run technique

Classification of all-weld-metal wire-flux combinations - All weld metal analysis and mechanical properties, as welded condition

Wire Grade	AWS A5.17 & A5.23	C	Mn	Si	Ni	Mo	Cr	Yield Strength MPa	Tensile Strength MPa	A5 %	Impact Energy - ISO-V (J)		
											-20 °C	-40 °C	-60 °C
OE-S2 Mo	F8A4 EA2-A2	0.07	0.9	0.2	--	0.5	--	>470	550-680	>24	>100	>50	--
OE-SD3	F7A8 EH12K	0.07	1.6	0.3	--	--	--	>450	530-630	>25	>140	>100	>70
OE-SD3 Mo	F8A6 EG-A4	0.07	1.3	0.3	--	0.5	--	>520	600-700	>24	>120	>80	--
OE-SD3 1Ni 1/4Mo	F8A8 EG-G	0.07	1.3	0.3	0.8	0.2	--	>530	600-650	>24	>140	>120	>80
OE-SD3 1Ni 1/2Mo	F9A8 EF3-F3	0.07	1.5	0.3	1.0	0.5	--	>540	650-750	>20	>90	>70	>50
OE-SD3 2NiCrMo	F11A6 EG-G	0.07	1.4	0.4	2.2	0.5	0.6	>720	850-1000	>14	>90	>70	>50
FLUXOCORD 31 HD	F7A8 -EC1	0.05	1.6	0.3	--	--	--	>450	500-600	>25	>140	>100	>60
FLUXOCORD 41 HD	F9A8 -EC-F3	0.05	1.4	0.2	1.2	0.4	--	>550	620-760	>20	>120	>100	>60
FLUXOCORD 42	F11A8 -EC-F5	0.08	1.4	0.25	2.35	0.5	0.5	>690	760-830	>16	>90	>70	>50
FLUXOCORD 83	F13A4 -EC-F5	0.06	1.5	0.4	2.8	0.5	0.2	>830	890-1000	>12	>50	>40	--

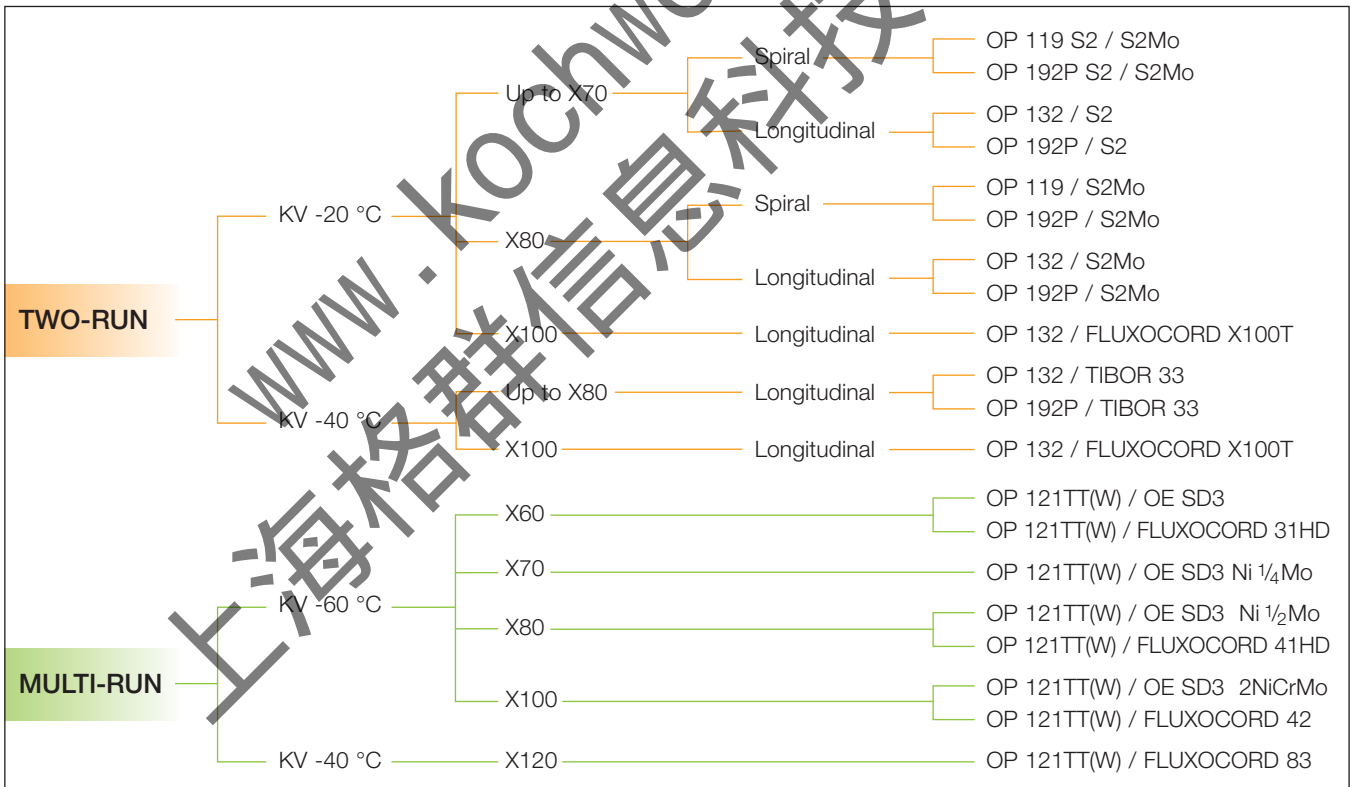
SAW Flux/Wire Selection Guide for Pipe steels



Selection guide

	OP 119	OP 192P	OP 132	OP 121 TT
Technology	TWO-RUN		MULTI-RUN	
Spiral	●●●	●●●	●●	●
Thickness > 1"	●●	●●	●●●	●●●
High speed	●●●	●●●	●●	●
Low temp. KV	●	●●	●●●	●●●
Slag removal	●●●	●●●	●●●	●●●
Weldability	●●●	●●	●●	●●●

● Not recommended
 ●● Good
 ●●● Very good
 ●●●● Excellent



* the chemical composition and mechanical properties of the weld metal are strongly dependant on the chemistry of the pipe steel.

Note:

Two pass welds when pipe welding are high dilution and the pipe steel chemistry will therefore have a strong effect on the chemistry and mechanical properties of the final joint. When two pass pipe welding it is therefore possible for a range of wire chemistries to meet the joint strength requirements for a given chemistry of pipe steel. Joint toughness, and service requirements, e.g. sour service, must also be carefully considered

in combination with the pipe chemistry during the selection of an OERLIKON wire/flux combination - please consult OERLIKON technical service and experienced engineers will recommend the most appropriate choice of SAW wire/flux combination and welding procedural guidelines for the application.

Classification Society Approvals



Type	AWS	TÜV	DB	ABS	BV	DNV	GL	LRS	RMRS
SAW									
OP 119 / OE-S1	F7A0 EL12	06699	51.098.18	-	-	-	-	-	-
OP 119 / OE-S2	F7A2 EM12K	06700	51.098.18	-	-	-	-	-	-
OP 119 / OE-S2Mo	F8A0 EA2 A2	06702	51.098.18	-	-	-	-	-	-
OP 192 / OE-S2	F7AP4 EM12K	TÜV	DB	-	-	-	-	-	-
OP 132 / OE-S2	F7A5 EM12K	09860	51.098.22	-	-	-	-	-	-
OP 132 / OE-S2Mo	F8A5 EA2-A2	09861	51.098.22	-	-	-	-	-	-
OP 121TT / OE-SD3	F7P8 EH12K	03768	51.098.09	3YM (-40 °C)	3YM	1W42M H5	5Y40M	4Y40M	5Y40M HHH
OP 121TT / OE-SD3 1Ni 1/4Mo	F8A8-EG-G	09895	-	-	-	-	-	-	-
OP 121TT / OE-SD3 1Ni 1/2Mo	F9A8 EF3-F3	-	-	-	-	-	-	3Y50M	-
OP 121TT / SD3 2NiCrMo	F11A6 EG-G	10356	51.098.09	-	-	-	-	-	-

INITIALS	AWS	EN	TÜV	DB	ABS	BV	DNV	GL	LRS	PRS	RMRS
DESCRIPTION	American Welding Society	European Normalization	Technischer Überwachungs Verein	Deutsche Bahn	American Bureau of Shipping	Bureau Veritas	Det Norske Veritas	Germanischer Lloyd	Lloyd's Register of Shipping	Polski Rejestr Statkow	Russian Maritime Register of Shipping



Product packaging - welding consumables

In the demanding environment of a pipe mill, the packaging of SAW wires and fluxes can make a significant contribution to productivity and technical performance.

OERLIKON bulk SAW wire systems are designed for fast reliable pay off, to minimise wire change overs and optimise productivity.

OERLIKON SAW BIGBAG flux packaging system efficiently delivers flux in bulk quantities into central flux hoppers, now combined with the DRYBAG system for very low flux moisture content, eliminating the need to re-condition flux before use.

OERLIKON "OE" Submerged Arc Welding Wires

OERLIKON High Productivity Delivery System

- Designed for high consumption pipe-mill environments
- Wire is free spooled, 1,000-3,000 kg
- Pay off system adaptable for floor or gantry
- Reliable rapid pay off at high wire feed speeds
- Double HDPE layer protection from atmosphere during storage
- Integral pallet



OERLIKON Round Pac

- Heavy duty cardboard drums
- 320 kg & 600 kg formats
- 100% recyclable
- Reliable rapid pay off at high wire feed speeds
- Fitted sling points for handling safety



Spool

- B450
- 100% recyclable
- Supply: 1 tonne/ 40 x 25 kg coils per pallet

OERLIKON "OP" Submerged Arc Welding Fluxes

OERLIKON DRYBAG

This new packaging solution has been developed by the Air Liquide research teams for OERLIKON submerged arc welding fluxes.



OERLIKON DRYBAG packaging system features:

- Triple layer composite technology system
- Fully moisture proof
- Low vacuum
- Protection from atmospheric humidity
- Designed for the most hostile ambient conditions
- Protection during extended transport and storage
- Supply: 1 tonne / 40 x 25 kg DRYBAG per pallet



OERLIKON PE Sack

- Weld sealed
- 100% recyclable ("4")
- Easy to handle
- Effective flux protection from the environment
- Supply: 1 tonne / 40 x 25 kg sacks per pallet

OERLIKON BIGBAG

A specially designed packaging system for high consumption pipe-mill environments. Combining the BIGBAG bulk flux packaging system with the low vacuum, composite technology DRYBAG system, delivering these additional benefits:

- 500, 800 and 1000 kg formats
- Mounted on an integral pallet
- Ready slung for crane lifting safety
- Very fast flux discharge



Arc equipment for pipe mills and large fabrication sites

MIG/MAG welding equipment

OERLIKON CITOMIG and CITOPULS ranges of heavy-duty MIG/MAG machines have a comprehensive array of features focused on the requirements of major fabricators. Durable design is combined with easy-to-use control panels and a variety of synergic programmes, combining improved productivity with high quality results.



Conventional switch based MIG-MAG installations

CITOMIG

Two power sources for intensive industrial applications in workshop conditions. These machines are easy to use via an intuitive parameter adjustment system which provides optimised welding parameters for the highest quality results.

Product features:

- Digital parameter display
- 4 rollers feeder with speed regulation
- Assistant adjustment mode
- Complete welding cycle
- Compact wirer feeder
- Protected harness (5 m or 10 m)
- 30 step adjustment
- 220/400 V three phase

CITOMIG 400W XP 380 A at 40%

CITOMIG 500W XP 480 A at 50%



Digital technology for advanced welding installations

CITOPULS

Efficient and advanced MIG/MAG machines for all applications. Equipped with a tough separate wire feeder for improved reach.

These innovative OERLIKON CITOPULS machines have been recognised with an internationally prestigious Janus de l'Industrie design award.

Features for improved quality and productivity:

- Digital current regulation and control, totally managing the current wave form and exact parameter reproduction.
- A more powerful current/voltage characteristic, increasing arc stiffness and joint penetration.
- SSA (Speed Short Arc), which provides an increase in welding speed while reducing distortion, an advantage when welding thinner sheets.
- CDP (Cold Double Pulse) enabling very high quality beads to be obtained on thinner sheet material without distortion. The CDP™ gives the same

bead appearance as a TIG weld, and delivers optimum results on very thin aluminium or stainless steel, < 2 mm, with increased molten pool control even on poor edge preparations.

- MIG Brazing, or MIG braze welding, an extremely effective process which accommodates large joint tolerances.
- An unequalled number of welding programmes with more than 150 synergic curves as standard and a memory capacity for over 100 welding procedures.
- Increased control: Warning system for parameter variations, parameter print-outs, power source networking, correction and calibration of the values displayed, etc.

Product features:

- Digital parameter display
- Harness 5 m to 25 m
- 400 V three-phase
- MMA welding
- Gouging with CITOPULS MXW 520



CITOPULS MXW 420
420 A at 45%

CITOPULS MXW 520
500 A at 60%



DMY 4000 WKS

New rugged wire feeder for heavy duty applications

Arc equipment for pipe mills and large fabrication sites

Plasma cutting installations

OERLIKON has a complete Manual Plasma cutting range for all applications,



MMA electrode power sources

OERLIKON has a wide range of equipment for MMA welding on site in all conditions.

From the CITOCUT K, a single phase unit with integrated compressor, a highly portable unit that cuts up to 6 mm, to the NERTAJET 50, a high performance chopper, multi gas machine that cuts up to 50 mm of steel.

CITOCUT 40i

Heavy duty portable cutting unit inverter technology.



2007-117

- 400 V 50/60 Hz three phase.
- Heavy duty cycle, 120 A at 60% at 40 °C.
- Quality cut, up to 40 mm.
- Contact cut, distance cut, plasma gouging.
- Blow back start, no HF interference.
- Grid cutting capability.

CITOCUT 40

Product features.

- High cutting capacity: 40 mm with 120 A.
- High duty cycle: 50% at 40 °C.
- 4 steps for setting the current according to the thickness to cut.
- IP 23 for indoor and outdoor applications.
- High quality cut with drag cutting nozzles.
- Delivered ready to use with 6 m torch, air hose, primary cable, earth cable, starting set of wear parts.
- Input voltage three phases : 220/230/380/400 V - 50/60 Hz



2007-065

From small, portable, high performance machines which can be carried by the welder to the location, such as the CITOARC 1900i, to rugged thyristor controlled units, such as the CITOROD 6500TH designed for heavy duty site applications, with rack fitting, remote parameter control and use with very long cables

CITOARC 1900i

Single phase inverter portable machine.

- MMA / TIG Lift / MMA Cellulosic.
- 230 V 50/60 Hz single phase.
- Motor generator compatible.
- Duty cycle 160 A at 60%.
- Light and portable 40 x 18 x 30 cm - 11kg.
- Digital display.
- Remote control.
- 2 years warranty



2006-912

CITOROD 6500 TH

Thyristor controlled multiprocess power source.

- MMA, TIG Lift, MMA cellulosic, gouging.
- Double characteristic, CC/CV.
- Options: TIG, TIG – HF / MIG.
- 230/400/440 V 50/60 Hz three phase.
- Heavy duty cycle, 630 A at 35%.
- 82 x 51 x 57 cm - 185 kg.
- Hot start and arc force adjustment.
- Remote control.
- Hoisting ring standard, suitable for rack fitting.



2007-477

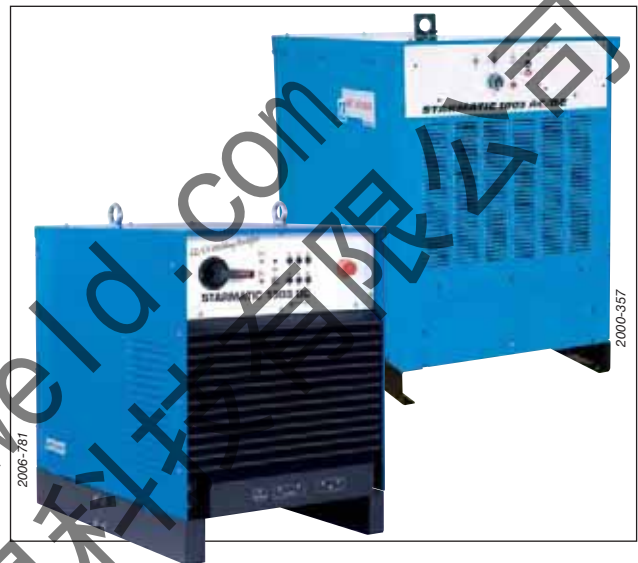
Equipment for submerged arc welding



Power sources

STARMATIC

- Rugged, reliable, suitable for aggressive industrial surroundings.
- Fan-cooled, fitted with thermal cut-out, easy to move using crane or forklift.
- Quick connection to the core of the installation by simple and accessible connectors.
- Remote control system.
- Function type:
 - 1 - SAW direct current (DC).
 - 2 - SAW alternative current (AC).
 - 3 - SAW gouging arc.



	STARMATIC 1303 DC	STARMATIC 1003 AC/DC
Duty cycle at 100%	1 300 A - 44 V	1 000 A - 44 V
Welding range	2 DC	1 AC - 1 DC
Primary power supply	400-440 V 50/60 Hz* three-phase	380/400/415 V 50/60 Hz* three-phase
Technology	Thyristors	Thyristors
Power at 100% duty cycle	99 kVA	64.6 kVA
External-static characteristics		AC DC
- flat	■	■
- drooping	■	■
Net weight	483 kg	540 kg

* For other primary power supply three-phase, consult Air Liquide Welding.

Equipment for submerged arc welding



Welding heads

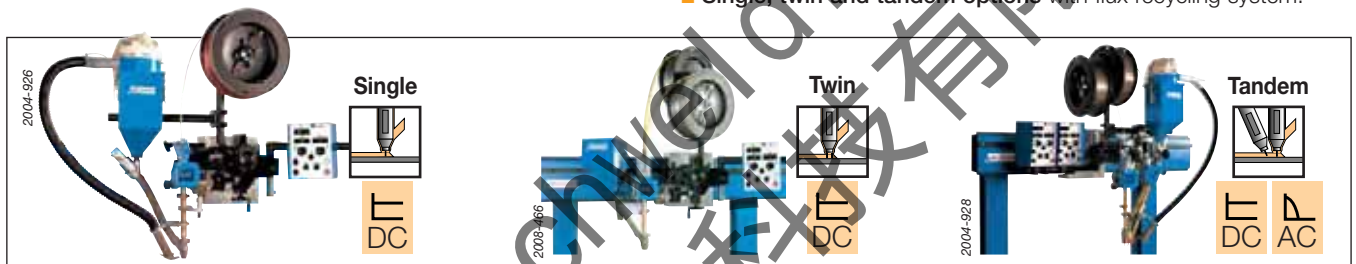
SUBARC 5 standard welding heads

A complete range of high-performance equipment using microprocessor technology to combine performance, flexibility of use and guaranteed high reliability in welding cycle management.

For the most demanding applications, SUBARC 5 is a compact welding and hard surfacing installation. It allows accurate

pre-setting and pre-selection of the actual welding current and voltage parameters for excellent arc striking every time:

- **Submerged arc welding:**
 - direct current: flat or drooping power source characteristics.
 - alternating current: drooping power source characteristic.
- **MIG/MAG** (spray-arc transfer)
- **Single, twin and tandem options** with flux recycling system.



Submerged arc special welding heads.

Single or tandem narrow-gap torch.

- Narrow-gap torch/holding device up to 250 mm wall thicknesses.
- Changeable head (standard heads up to 180 mm available).
- Self-centring head on floating bearing.
- Ceramic coating.



Single or twin heavy duty torch.

- Thicknesses up to 70 mm.
- Kit to retrofit on SUBARC installations.
- Adjustable nozzle.
- 2.4 mm to 5.0 mm single wire diameter.
- 2 x 1.6 mm - 2 x 2.4 mm twin wire diameter.



Submerged arc welding heads for pipe mills.

- Customised installations.
- Multi-wire welding heads 5 wire.



Equipment for submerged arc welding



SAW self propelled tractor.

A practical, efficient and cost effective solution.

MEGATRAC 6 SUBARC 3C

- Modular S.A. carriage which can be adapted to various applications.
- Flat and angle assembly of plates in all grades and thicknesses.
- Wheel diameter: 150 mm.
- Crabbing arms



Positioning equipment

Air Liquide Welding provides a large range of positioning equipment such as rotators and column and booms.

Rotators

The ROTAMATIC range from 2 tons to 600 tons allows the rotation of vessels or tube for manual or automatic welding. Medium duty and heavy duty ranges are available to fit the needs of every customer.



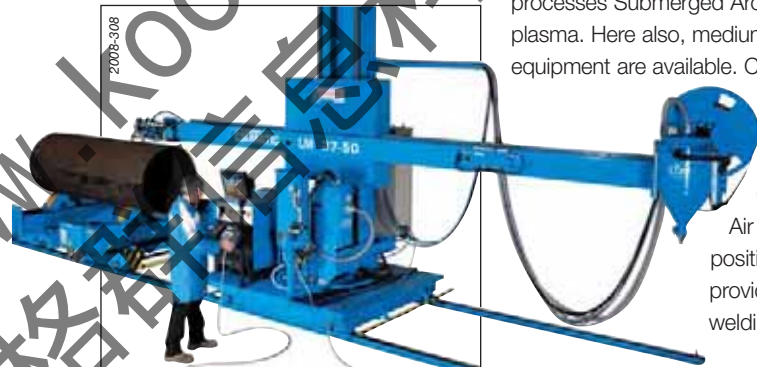
Column and booms

CB-MATIC, the Air Liquide Welding column and boom range is the professional answer to your needs. Ideal for perfect positioning of the welding head in every welding

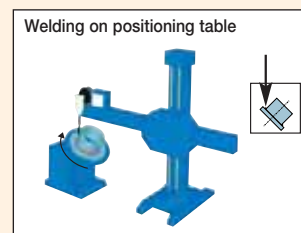
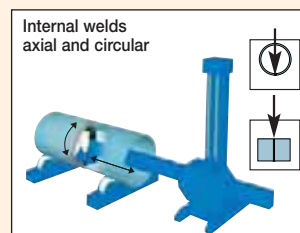
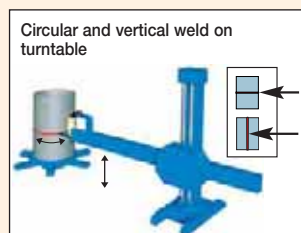
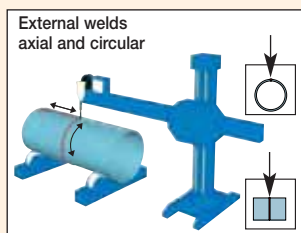
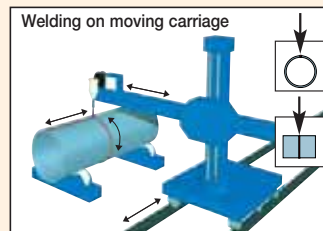
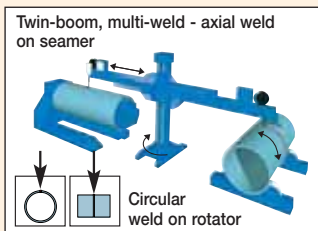
processes Submerged Arc, MAG, TIG and plasma. Here also, medium and heavy duty equipment are available. Customised solutions

are often created to fit the customers' requirements.

Combined together, Air Liquide Welding positioning equipment provides a wide range of welding solutions.



Combined together, Air Liquide Welding positioning equipment provides a wide range of welding solutions.



Temperature Conversion Table

°C	°F	°C	°F	°C	°F	°C	°F				
-156.6	-250	-418	-36.6	-34	-29.2	-25.5	-14	6.8	-14.4	6	42.8
-128.8	-200	-328	-36.1	-33	-27.4	-25.0	-13	8.6	-13.9	7	44.6
-101.1	-150	-238	-35.5	-32	-25.6	-24.4	-12	10.4	-13.3	8	46.4
-73.3	-100	-148	-35.0	-31	-23.8	-23.8	-11	12.2	-12.8	9	48.2
-45.5	-50	-58	-34.4	-30	-22.0	-23.3	-10	14.0	-12.2	10	50.0
-45.0	-49	-56.2	-33.8	-29	-20.2	-22.7	-9	15.8	-11.7	11	51.8
-44.4	-48	-54.4	-33.3	-28	-18.4	-22.2	-8	17.6	-11.1	12	53.6
-43.8	-47	-52.6	-32.7	-27	-16.6	-21.6	-7	19.4	-10.6	13	55.4
-43.3	-46	-50.8	-32.2	-26	-14.8	-21.1	-6	21.2	-10.0	14	57.2
-42.7	-45	-49	-31.6	-25	-13.0	-20.5	-5	23.0	-9.44	15	59.0
-42.2	-44	-47.2	-31.1	-24	-11.2	-20.0	-4	24.8	-8.89	16	61.8
-41.6	-43	-45.4	-30.5	-23	-9.4	-19.4	-3	26.6	-8.33	17	63.6
-41.1	-42	-43.6	-30.0	-22	-7.6	-18.8	-2	28.4	-7.78	18	65.4
-40.5	-41	-41.8	-29.4	-21	-5.8	-18.3	-1	30.2	-7.22	19	67.2
-40.0	-40	-40.0	-28.8	-20	-4.0	-17.8	0	32.0	-6.67	20	68.0
-39.4	-39	-38.2	-28.3	-19	-2.2	-17.2	1	33.8	-6.11	21	69.8
-38.8	-38	-36.4	-27.7	-18	-0.4	-16.7	2	35.6	-5.56	22	71.6
-38.3	-37	-34.6	-27.2	-17	1.4	-16.1	3	37.4	-5.0	23	73.4
-37.7	-36	-32.8	-26.6	-16	3.2	-15.6	4	39.2	-4.44	24	75.2
-37.2	-35	-31	-26.1	-15	5.0	-15.0	5	41.0	-3.89	25	77.0
-33.3	26	78.8	7.78	46	114.8	18.9	66	160.8	30.0	86	186.8
-2.78	27	80.6	8.33	47	116.6	19.4	67	162.6	30.6	87	188.6
-2.22	28	82.4	8.89	48	118.4	20.2	68	164.4	31.1	88	190.4
-1.67	29	84.2	9.44	49	120.2	20.6	69	166.2	31.7	89	192.2
-1.11	30	86.0	10.0	50	122.0	21.1	70	168.0	32.2	90	194.0
-0.56	31	87.8	10.6	51	123.8	21.7	71	169.8	32.8	91	195.8
0.00	32	89.6	11.1	52	125.6	22.2	72	171.6	33.3	92	197.6
0.56	33	91.4	11.7	53	127.4	22.8	73	173.4	33.9	93	199.4
1.11	34	93.2	12.2	54	129.2	23.3	74	175.2	34.4	94	201.2
1.67	35	95.0	12.8	55	131.0	23.9	75	177.0	35.0	95	203.0
2.22	36	96.8	13.3	56	132.8	24.4	76	178.8	35.6	96	204.8
2.78	37	98.6	13.9	57	134.6	25.0	77	180.6	36.1	97	206.6
3.33	38	100.4	14.4	58	136.4	25.6	78	182.4	36.7	98	208.4
3.89	39	102.2	15.0	59	138.2	26.1	79	184.2	37.2	99	210.2
4.44	40	104.0	15.6	60	140.0	26.7	80	186.0	38	100	212.0
5.00	41	105.8	16.1	61	141.8	27.2	81	187.8	43	110	230
5.56	42	107.6	16.7	62	143.6	27.8	82	189.6	49	120	248
6.11	43	109.4	17.2	63	145.4	28.3	83	191.4	54	130	266
6.67	44	111.2	17.8	64	147.2	28.9	84	193.2	60	140	284
7.22	45	113.0	18.3	65	149.0	29.4	85	195.0	66	150	302
71	160	320	177	350	662	621	1150	2102	1177	2150	3902
77	170	338	182	360	680	649	1200	2192	1204	2200	3992
82	180	356	188	370	698	677	1250	2282	1232	2250	4082
88	190	374	193	380	716	704	1300	2372	1260	2300	4172
93	200	392	199	390	734	732	1350	2462	1288	2350	4262
99	210	410	204	400	752	760	1400	2552	1316	2400	4352
100	212	413	232	450	842	788	1450	2642	1343	2450	4442
104	220	428	260	500	932	816	1500	2732	1371	2500	4532
110	230	446	288	550	1022	843	1550	2822	1399	2550	4622
116	240	464	316	600	1112	871	1600	2912	1427	2600	4712
121	250	482	343	650	1202	899	1650	3002	1454	2650	4802
127	260	500	371	700	1292	927	1700	3092	1482	2700	4892
132	270	518	399	750	1382	954	1750	3182	1510	2750	4982
138	280	536	427	800	1472	982	1800	3272	1538	2800	5072
143	290	554	454	850	1562	1010	1850	3362	1566	2850	5162
149	300	572	482	900	1652	1038	1900	3452	1593	2900	5252
154	310	590	510	950	1742	1066	1950	3542	1621	2950	5342
160	320	608	538	1000	1832	1093	2000	3632	1649	3000	5432
166	330	626	566	1050	1922	1121	2050	3722			
171	340	644	593	1100	2012	1149	2100	3812			

Note: the numbers in bold type refer to the temperature, either in Celsius or Fahrenheit, which is desired to convert into the other scale. If converting from Fahrenheit degrees to Celsius degrees, the equivalent temperature will be found in the left column, while converting from Celsius degrees to Fahrenheit degrees the answer will be found in the column on the right.

Impact Toughness Conversion Table

J	ft.lb.	J	ft.lb.	J	ft.lb.	J	ft.lb.
20	14.7	48	35.4	76	56.0	104	76.7
22	16.2	50	36.8	78	57.5	106	78.1
24	17.7	52	38.3	80	59.0	108	79.6
26	19.1	54	39.8	82	60.4	110	81.1
28	20.6	56	41.3	84	61.9	112	82.6
30	22.1	58	42.7	86	63.4	114	84.0
32	23.6	60	44.2	88	64.9	116	85.5
34	25.0	62	45.7	90	66.3	118	87.0
36	26.5	64	47.2	92	67.8	120	88.5
38	28.0	66	48.6	94	69.3	122	89.9
40	29.5	68	50.1	96	70.8	124	91.4
42	30.9	70	51.6	98	72.2	126	92.9
44	32.4	72	53.1	100	73.7	128	94.4
46	33.9	74	54.5	102	75.2	130	95.8

J	ft.lb.	J	ft.lb.	J	ft.lb.
132	97.3	160	118.9	188	138.5
134	98.8	162	119.4	190	140.0
136	100.3	164	120.8	192	141.5
138	101.7	166	122.3	194	142.9
140	103.2	168	123.8	196	144.4
142	104.7	170	125.3	198	145.9
144	106.2	172	126.7	200	147.4
146	107.6	174	128.2		
148	109.1	176	129.7		
150	110.6	178	131.2		
152	112.1	180	132.6		
154	113.5	182	134.1		
156	115.0	184	135.6		
158	116.5	186	137.1		

Conversion factors:
 1 Joule = 0.73756 ft.lb.
 1 ft.lb. = 1.35582 J

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Stress Conversion Table

N/mm ²	ksi	psi	MPa	N/mm ²	ksi	psi	MPa	N/mm ²	ksi	psi	MPa
150	21.8	21800	150	350	50.8	50800	350	550	79.8	79800	550
160	23.2	23200	160	360	52.2	52200	360	560	81.2	81200	560
170	24.7	24700	170	370	53.7	53700	370	570	82.7	82700	570
180	26.1	26100	180	380	55.1	55100	380	580	84.1	84100	580
190	27.6	27600	190	390	56.6	56600	390	590	85.6	85600	590
200	29.0	29000	200	400	58.0	58000	400	600	87.0	87000	600
210	30.5	30500	210	410	59.5	59500	410	610	88.5	88500	610
220	31.9	31900	220	420	60.9	60900	420	620	89.9	89900	620
230	33.4	33400	230	430	62.4	62400	430	630	91.4	91400	630
240	34.8	34800	240	440	63.8	63800	440	640	92.8	92800	640
250	36.3	36300	250	450	65.3	65300	450	650	94.3	94300	650
260	37.7	37700	260	460	66.7	66700	460	660	95.7	95700	660
270	39.2	39200	270	470	68.2	68200	470	670	97.2	97200	670
280	40.6	40600	280	480	69.6	69600	480	680	98.6	98600	680
290	42.1	42100	290	490	71.1	71100	490	690	100.1	100100	690
300	43.5	43500	300	500	72.5	72500	500	700	101.5	101500	700
310	45.0	45000	310	510	74.0	74000	510	710	103.0	103000	710
320	46.4	46400	320	520	75.4	75400	520	720	104.4	104400	720
330	47.9	47900	330	530	76.9	76900	530	730	105.9	105900	730
340	49.3	49300	340	540	78.3	78300	540	740	107.3	107300	740

N/mm ²	ksi	psi	MPa	N/mm ²	ksi	psi	MPa	N/mm ²	ksi	psi	MPa
750	108.8	108800	750	950	137.8	137800	950	1150	166.8	166800	1150
760	110.2	110200	760	960	139.2	139200	960	1160	168.2	168200	1160
770	111.7	111700	770	970	140.7	140700	970	1170	169.7	169700	1170
780	113.1	113100	780	980	142.1	142100	980	1180	171.1	171100	1180
790	114.6	114600	790	990	143.6	143600	990	1190	172.6	172600	1190
800	116.0	116000	800	1000	145.0	145000	1000	1200	174.0	174000	1200
810	117.5	117500	810	1010	146.5	146500	1010				
820	118.9	118900	820	1020	147.9	147900	1020				
830	120.4	120400	830	1030	149.4	149400	1030				
840	121.8	121800	840	1040	150.8	150800	1040				
850	123.3	123300	850	1050	152.3	152300	1050				
860	124.7	124700	860	1060	153.7	153700	1060				
870	126.2	126200	870	1070	155.2	155200	1070				
880	127.8	127800	880	1080	156.6	156600	1080				
890	129.1	129100	890	1090	158.1	158100	1090				
900	130.5	130500	900	1100	159.5	159500	1100				
910	132.0	132000	910	1110	161.0	161000	1110				
920	133.4	133400	920	1120	162.4	162400	1120				
930	134.9	134900	930	1130	163.9	163900	1130				
940	136.3	136300	940	1140	165.3	165300	1140				

Conversion factors: 1 N/mm² = 145.038 psi
 1 N/mm² = 0.145038 ksi
 1 MPa = 145.038 psi
 1 MPa = 0.145038 ksi

Note: psi values have been rounded off to the nearest fourth digit.

Welding Units Comparison Tables

Deposition rates		Wire feed speed		Consumable weight		Electrode and wire diameter	
lbs/hr	kg/hr	ins/min	m/min	lbs	kgs	inches	mm
1	0.45	25	0.6	2.2	1		
2	0.9	50	1.3	4.4	2	0.024	0.6
3	1.36	75	1.9	6.6	3	0.030	0.8
4	1.81	100	2.5	8.8	4	0.035	0.9
5	2.26	125	3.1	11.0	5	0.045	1.0
6	2.72	150	3.8	13.2	6	0.052	1.2
7	3.17	175	4.4	15.4	7	1/16	1.6
8	3.68	200	5.1	17.6	8	5/64	2.0
9	4.08	225	5.7	19.8	9	3/32	2.4
10	4.53	250	6.3	22.0	10	7/64	3.0
11	4.98	275	6.9	33.0	15	1/8	3.2
12	5.44	300	7.6	44.0	20	5/32	4.0
13	5.89	325	8.2	55.0	25	3/16	5.0
14	6.35	350	8.9	66.0	30	1/4	6.0
15	6.80	375	9.5	77.0	35		
16	7.25	400	10.2	88.0	40		
17	7.71	425	10.8	99.0	45		
18	8.16	450	11.4	110.0	50		
19	8.61	475	12.0				
20	9.07	500	12.7				
21	9.52	525	13.3				
22	9.97	550	14.0				
23	10.43	575	14.6				
24	10.88	600	15.2				
25	11.33	625	15.8				
		650	16.5				
		675	17.1				
		700	17.8				

Electrode length	
inches	mm
10	250
12	300
13	330
14	350
18	450

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