

WELDING STAINLESS STEELS - NICKEL ALLOYS

RODACCIAI REFERENCES AND COMPARABLE STANDARDS

	EN ISO 18274: 2010	AWS A5.14/A5.14M
RODALLOY 625	NiCr22Mo9Nb Ni6625	ERNiCrMo-3 N06625
RODALLOY 825	NiFe30Cr21Mo3 Ni8065	ERNiFeCr-1 N08065

CHEMICAL COMPOSITION (BATCH ANALYSIS) %

		C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	Nb	Ti	Al
RODALLOY 625	min	-	-	-	-	-	22,0	64,0	8,50	-	-	3,50	-	-
	max	0,03	0,50	0,50	0,015	0,015	23,0	-	10,00	0,50	0,50	4,10	0,40	0,40
RODALLOY 825	min	-	0,60	-	-	-	22,0	43,0	3,00	2,00	22,00	-	0,60	0,20
	max	0,03	0,80	0,35	0,015	0,015	23,0	46,0	3,50	3,00	-	-	1,20	-



PRODUCTION RANGE AND FINISHING

WELDING PROCESSES		SIZE	PACKAGING																							
MIG	mm	0,60 - 0,80 - 0,90 - 1,00 - 1,20 - 1,60	Plastic spool D200 - size: width 55 mm - outside diameter: 200 mm - spindle hole diameter: 51,5 mm - weight: 5 kg Rocchetto di plastica D300 - size: width 100 mm - outside diameter: 300 mm - spindle hole diameter: 51,5 mm - weight: 12,5 kg (for diameter ≤0,8 mm) 15 kg (for diameters >0,8 mm)																							
	inches	0.023 - 0.030 - 0.035 - 0.045 - 1/16	Blue metallic wire basket BS300 - size: width 100 mm - outside diameter: 300 mm - inside diameter: 51,5 mm - weight: 15 kg Bulk spool / wood / steel - size: width 285 mm - outside diameter: 750 mm - spindle hole diameter: 41 mm - weight: 250 kg Drum for robotic welding <table><tr><td>- wire diameter (mm):</td><td>0,8</td><td>0,9</td><td>1,0</td><td>1,2</td><td>1,6</td></tr><tr><td>- height of drum (mm):</td><td>670</td><td></td><td>790</td><td></td><td>790</td></tr><tr><td>- outside diameter (mm):</td><td>510</td><td></td><td>520</td><td></td><td>580</td></tr><tr><td>- weight (kg):</td><td>150</td><td></td><td>250-400</td><td></td><td>250-400</td></tr></table>	- wire diameter (mm):	0,8	0,9	1,0	1,2	1,6	- height of drum (mm):	670		790		790	- outside diameter (mm):	510		520		580	- weight (kg):	150		250-400	
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TIG	mm	0,80 - 1,00 - 1,20 - 1,60 - 2,00 2,40 - 3,20 - 4,00 - 5,00	Rods - length 1000 mm (Ø in mm)/36 inches (Ø in inches) - stamped with AWS and W.Nr. ref. - packed in neutral boxes or cardboard tubes - weight: 5 kg																							
	inches	0.030 - 0.035 - 0.045 - 1/16 - 5/64 3/32 - 1/8 - 5/32 - 3/16																								
SUBMERGED ARC	mm	1,60 - 2,00 - 2,40 - 3,20 - 4,00	Metallic wire basket K415 - size: width 100 mm - outside diameter: 415 mm - inside diameter: 300 mm - weight: 25 kg Drum - wire diameter: 2,0 - 4,0 mm - height of drum: 850 mm - outside diameter: 660 mm - weight: 300 kg																							
	inches	1/16 - 5/64 - 3/32 - 1/8 - 5/32																								
CORE WIRE IN CUT LENGTHS OR IN COILS	mm	1,60 - 2,00 - 2,50 - 3,25 - 4,00 - 5,00	Core wires in cut lengths - length 250 - 450 mm (9 - 18 inches) - packed in wooden crates sizes: - 800 - 1.000 kg, base 750x800 mm - height 500 mm - 500 - 650 kg, base 820x570 mm - height 580 mm																							
	inches	1/16 - 5/64 - 3/32 - 1/8 5/32 - 3/16	Core wires in coils - size: internal diameter: 380 mm - weight: 500/800 kg																							

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Rodacciai name

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