



ISO 9001:2008



ALUMINUM SOLID WELD WIRES

# MIG ER4043

## ลวดเชื่อมอลูมิเนียม

**ER4043** เป็นลวดเชื่อมฐานซิลิคอน สามารถใช้เชื่อมอลูมิเนียมเกรด 2014, 5052, 6061 และ 6101 ได้ ทนต่อการกัดกร่อนได้เป็นอย่างดีในน้ำเค็ม

ER4043 is a silicon alloyed aluminum weld rod great for filler 4xxx series alloys. 2014, 5052, 6061, and 6101 (in various conditions of heat treatment and 6063 sheets, plates and shapes). Offers better corrosion resistance in salt water conditions.



Mechanical Properties			Weight	Price
Size (mm)	Tensile Strength	Elongation		
<b>0.8</b>	-	-	<b>0.5 kg</b>	<b>420.-/ม้วน</b>
<b>1.2</b>	-	-	<b>6.0 kg</b>	<b>360.-/กก.</b>



CHEMICAL COMPOSITION (%)							
ELEMENT	Fe	Si	Mn	Mg	Zn	Cu	Ti
REQUIREMENT	≤0.8	4.5~6.0	≤0.05	≤0.05	≤0.10	≤0.30	≤0.20
ACTUAL RESULT	0.10	5.1	0.01	0.003	0.003	0.03	0.02

### Application :

- โครงสร้างรถบรรทุก (Truck Bodies)
- ถังแรงดัน (Pressure Vessels)
- ชิ้นส่วนยานยนต์ (Automotive Components Such as Frame and Drive Shafts)
- โครงสร้างสิ่งก่อสร้าง (Structural Members)
- ระบบไฟฟ้ารถบัส (Electrical Bus Bars)
- ท่อส่งน้ำมัน (Petroleum Distribution Equipment)

สินค้าแนะนำที่ใช้คู่กับลวดเชื่อมอลูมิเนียม ER4043 **ขนาด 0.8mm 0.5 กก./ม้วน**

ชุดสายเชื่อมสปูนกัน  
SPOOL GUN  
**200A**

**9400.-/Pc**





ISO 9001:2000  
AWS A5.10 ER5356



ALUMINUM SOLID WELD WIRES

# MIG ER5356

## ลวดเชื่อมอลูมิเนียม

### เชื่อมได้เน็่ม และเน็ยมมาก

THE BEST OF MILD AND  
EXCEPTIONALLY  
SMOOTH WELDS

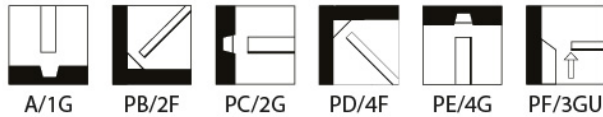
**6 กก.**  
**6 kg**

**ER5356** เป็นลวดเชื่อมอลูมิเนียมฐานแมกนีเซียม สามารถใช้เชื่อมอลูมิเนียมเกรด 5050, 5052, 5083, 5086, 5356, 5454 และ 5456 ได้ให้ ความแข็งแรง สูงมากมีความเหนียวและต้านทาน การกัดกร่อนได้ดี

ER5356 is a 5% magnesium aluminum weld metal recommended for general purpose welding 5050, 5052, 5083, 5086, 5356, 5454 and 5456. has high strength, ductility, toughness, fatigue and good corrosion resistance.

#### Welding Position :

สามารถเชื่อมได้ทุกท่าเชื่อม(All, except vertical down)



#### Guideline For USE :

For MIG : set machine on DC reverse polarity. Use Ar shielding gas. Make sure all contaminants such as grease and oil are removed. Hold a short arc and weld with stringer beads or a slight weave bead.

**Recommended :** This alloy is not recommended for elevated temperature applications (above 150°F).

**Storage :** Product should be stored in a dry, enclosed environment, and in its original intact packaging.



หน่วย : mm



Mechanical Properties			Weight	Price
Ø Size (mm)	Tensile Strength	Elongation		
<b>1.2</b>	-	-	<b>0.6 kg</b>	<b>450.-/กก.</b>

#### Shielding Gases (ACC.ISO 14175)

- I1 Inert gas Ar (100%)
- I3 Inert gas Ar+ 0.5-95% Helium mixtures
- Flow rate 4.2 - 23.6L/min

CHEMICAL COMPOSITION (%) Ø1.2 mm								
ELEMENT	Fe	Si	Mn	Cr	Zn	Mg	Cu	Ti
REQUIREMENT	≤0.4	≤0.25	0.05~0.2	0.05~0.2	≤0.1	4.5~5.5	≤0.1	0.06~0.2
ACTUAL RESULT	0.12	0.026	0.082	0.061	0.020	5.12	0.01	0.12

**Application :** เหมาะสำหรับใช้ในงานอุตสาหกรรม • อุตสาหกรรมโครงสร้างการต่อเรือ • อลูมิเนียมหล่อ และเสื่อสูบเครื่องยนต์ • ฝาสูบ • ท่อหรือเฟรม • อุตสาหกรรมเฟรมจักรยาน ยานยนต์ รถบัส หรือรถพ่วง • อุตสาหกรรมรางรถไฟ

This alloy is commonly used in the construction industry in • Structural Frames in The Shipbuilding Industry. • Cts and Housings. • Cylinder Heads. • Pipes and Frames. • Bicycle, Automotive, Bus and Trailer Industry structural Frames. • Railway Industry.

#### TYPICAL GMAW (MIG) WELDING PROCEDURES : DCEP 100% Ar

Wire Diameter	Amps	Volts	Travel Speed (ipm)	Argon (cfh)
0.8 mm	60 - 175	15 - 24	25 - 45	25 - 30
0.9 mm	70 - 185	15 - 27	25 - 40	30 - 35
▶ <b>1.2 mm</b>	125 - 260	20 - 29	24 - 35	35 - 45
1.6 mm	170 - 300	24 - 30	28 - 38	45 - 55
2.4 mm	275 - 400	26 - 31	14 - 20	60 - 75

▶ = มีสินค้า

#### WARNING

PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can KILL. • Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs) , and your employer's safety practices. • Keep your head out of fumes. • Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. • Wear correct eye, ear, and body protection. • Do not touch live electrical parts.





# ER70S-6

CO<sub>2</sub> WELDING WIRE

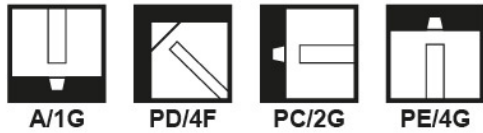
ISO 9001:2015 WG ER50-6 ISO14341-A - G 42 3 C1 3S1 CE

**STABLE ARC WITH LOW FEEDING FORCE & EXTREMELY LOW OVERALL SPATTER**

## BENEFITS :

- Consistent welding performance
- Stable arc with low feeding force
- Excellent arc ignition
- High current applicability
- Extremely low overall spatter
- Low fume emission
- Trouble-free feed ability, even at high wire feed speeds and lengthy feed distances

## WELDING POSITIONS



A general purpose of welding wire with copper coated for long contact tip life is provides superior feeding and arc stability design for fabrication of mild steel. Contains higher levels of manganese and silicon than the other standard grades of MIG wire, provide high deoxidizers to heavy mill scale surfaces that provide better wetting, yielding a flatter bead shape and the capability of faster travel speeds. Usually used with 75/25 (Argon/CO<sub>2</sub>) shielding gas or higher contents of Argon, such as 90/10. Can also be used with 100% CO<sub>2</sub>. Conforms to AWS A5.18 **ER70S-6**.

**APPLICATIONS :** SUMO ER70S-6 It is a great choice for welding light to moderately scaled, oily or rusty plates. It can also be recommended for spray transfer arc welding applications. Used for butt and fillet welding of sheet and plate of a variety of thickness. Applications included general carbon steel fabrication.

## STORAGE :

Product should be stored in a dry, enclosed environment, and in its original intact packaging.

### Chemical Composition (%) - 1KG

Element	C	Si	Mn	S	P	Cr	Ni	Mo	V	Cu
Requirement	0.06-0.15	0.8-1.15	1.4-1.85	≤ 0.035	≤ 0.025	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.03	≤ 0.5
Actual Result	0.06	0.9	1.51	0.016	0.012	0.013	0.005	0.002	0.002	0.13
Mechanical Properties						Soundness Test				
	Tensile Strength	Yield Strength	Elongation%	Test Temp °C	Absorbed Energy J	II				
Requirement	≥ 480	≥ 400	≥ 22	-30	≥ 27					
Sample Test	545	432	30	-30	86 94 90					
						Acceptable				

### Chemical Composition (%) - 5 / 15KG

Element	C	Si	Mn	S	P	Cr	Ni	Mo	V	Cu
Requirement	0.06-0.15	0.80-1.15	1.40-1.85	≤ 0.035	≤ 0.025	≤ 0.15	≤ 0.15	≤ 0.15	≤ 0.03	≤ 0.50
Actual Result	0.074	0.91	1.48	0.010	0.017	0.015	0.017	0.011	0.007	0.036
Mechanical Properties						Soundness Test				
	Tensile Strength	Yield Strength	Elongation %	Test Temp °C	Absorbed Energy J	II				
Requirement	≥ 480	≥ 400	≥ 22.0	-30	≥ 27					
Sample Test	546	449	27.0	-30	71 91 73					
						Acceptable				

ขนาด Size (mm)	น้ำหนัก Weight (kg)	ราคา (Price)
● 0.8	1	105.- /kg
▶ 0.8	5	70.- /kg
▶ 0.8	15	60.- /kg
▶ 0.9	15	60.- /kg
▶ 1.0	15	58.- /kg
▶ 1.2	15	57.- /kg
● 1.2	250	XX.- /kg

## SHIELDING GAS :

100% CO<sub>2</sub>  
75-95% Argon / Balance CO<sub>2</sub>  
95-98% Argon / Balance O<sub>2</sub>  
Flow Rate : 30-50 CFH

## GUIDELINE FOR USE :

Oil stains and rust must be removed from surface of weldment prior to welding in accordance with appropriate welding standards.

● กำลังจะเข้า ▶ มีสินค้า



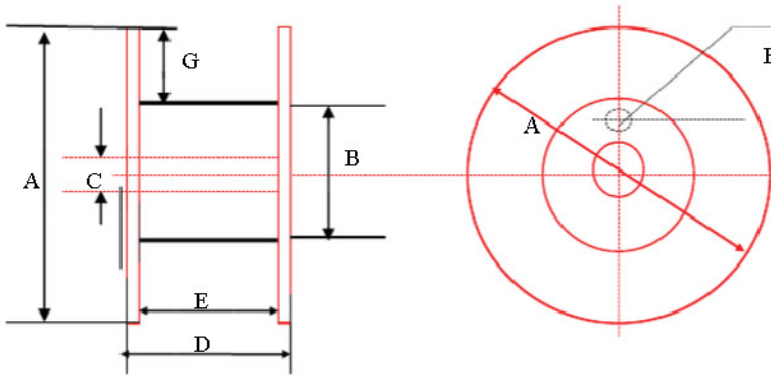
# ER70S-6

## CO<sub>2</sub> WELDING WIRE

ISO 9001:2015 WG ER50-6 ISO14341-A - G 42 3 C1 3S1 CE

**STABLE ARC WITH LOW FEEDING FORCE  
& EXTREMELY LOW OVERALL SPATTER**

### Factory control standard For Plastic Spool precision layer winding CO<sub>2</sub> wire

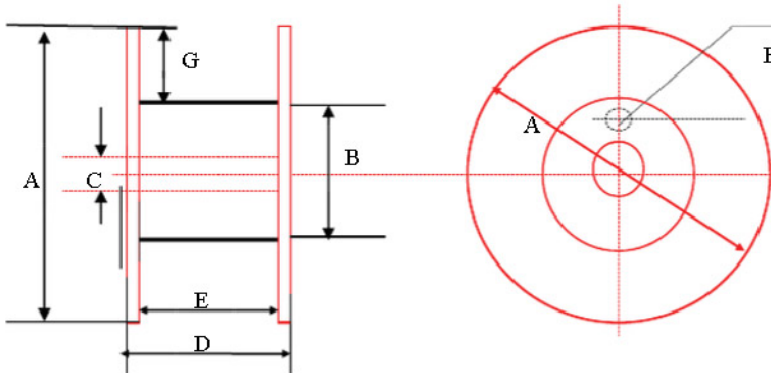


D100 (Black)

Main parameter

1kg

1	C	16 +0.5mm
2	A	100 +5mm
4	B	45 +2mm -2mm
5	G	28.5 +0.5mm -0.5mm
6	D	42 +1.5mm -1.5mm
7	E	38 +1mm -1mm
8	Weight	53 +5g -5g

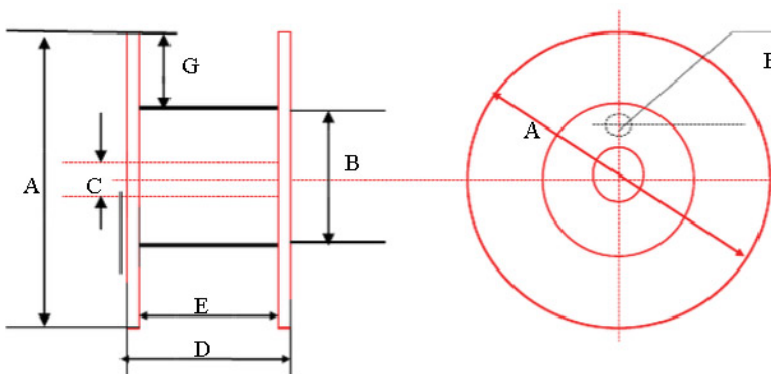


D200 (Black)

Main parameter

5kg

1	C	50.5 +2.5mm
2	A	200 +5mm
4	B	95 +2mm -2mm
5	G	44.5 +0.5mm -0.5mm
6	F	11 +1mm
7	D	56 +1.5mm -1.5mm
8	E	46 +1mm -1mm
9	Weight	260 +10g -10g



D270 (Black)

Main parameter

15kg

1	C	50.5 +2.5mm
2	A	270 +5mm
4	B	138 +2mm -2mm
5	G	60 +0.5mm -0.5mm
6	F	11 +1mm
7	D	102 -3mm
8	E	90 +1mm -1mm
9	Weight	680 +10g -10g



GASLESS FLUX CORED WELDING WIRE  
**AWS E71T-GS**  
 ลวดเชื่อมมิกฟลักซ์คอร์

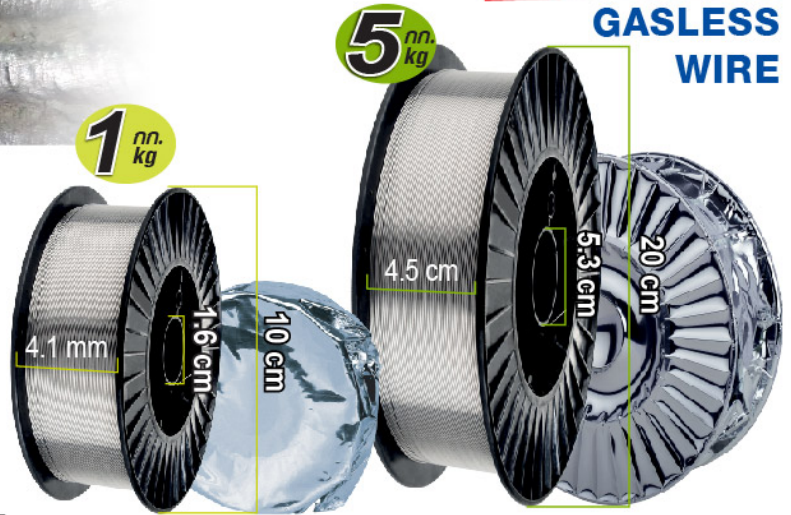
ไม่ใช้แก๊ส

**GASLESS WIRE**

ใช้ได้กับงานเชื่อมเหล็กทุกชนิด



- ลวดเชื่อมแบบไม่ใช้แก๊ส FLUX CORE 0.8 mm, 1.0 mm E71T-GS SUMO
- เป็นลวดเชื่อมที่ไม่มีการสึกหรอเป็นข้อเพลิงขึ้นพื้นฐานที่ออกแบบมาสำหรับการเชื่อมตำแหน่งเหล็กอ่อนในทุกตำแหน่งที่ต้องการ
- ความแข็งแรงระดับปานกลางและ
- ความเหนียวที่ดีมาก
- ไม่ใช้แก๊ส GASLESS WIRE



▶ มีสินค้า

Wire Diameter	Amps
Ø0.8 mm	70-120
Ø1.0 mm	80-180

Mechanical Properties			QTY Spool / Box	Weight	Price
Size (mm)	Tensile Strength	Elongation			
▶ Ø0.8	-	-	1	1 kg	188.-/กก.
▶ Ø0.8	-	-	1	5 kg	180.-/กก.
▶ Ø1.0	-	-	1	1 kg	180.-/กก.
▶ Ø1.0	-	-	1	5 kg	160.-/กก.

**SUGGESTION :**

Storage product should be stored in a dry, enclosed environment, and in its original intact packaging.



**CHARACTERISTIC :**

This kind of wire is 1kg, 5kg self protective flux cored wire.

**SUITABLE :**

For all position. When welding, the spatter is smaller, the arc is stable and soft, slag removal is easy and the forming is beautiful.

Trade Name	E71T-GS	Size (mm)	0.8 mm	1.0 mm	Production Batch	DATE :			
Executive Standard	GB/T10045-2001 E501T-GS ( AWS A5.20 E71T-GS )				Quantities	1 KG 5 KG			
Chemical Composition (%) Ø0.8 mm , Ø1.0 mm						Mechanical Properties of Deposited			
C	Mn	Si	P	S	Al	Tensile Strength MPa	Yield Strength MPa	Longation & (%)	Impact Energy -20 °C
0.12	0.89	0.32	0.012	0.009	1.23	540	476	27	110/107/112
Examination Clerk	Quality Leader				This certificate is invalid without seal of quality control department.				

- ELECTRIC SHOCK CAN KILL :**
- Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood.
  - Wear dry, hole-free gloves. (Change as necessary to keep dry.)
  - Do not touch electrically "hot" parts or electrode with bare skin or wet clothing.
  - If wet area and welder cannot be insulated from workpiece with dry insulation, use a semiautomatic, constant-voltage welder or stick welder with voltage reducing device.
  - Keep electrode holder and cable insulation in good condition. Do not use if insulation damaged or missing.

- WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION :**
- Do not weld on containers which have held combustible materials (unless strict AWS F4.1 procedures are followed). Check before welding.
  - Remove flammable materials from welding area or shield from sparks, heat.
  - Keep a fire watch in area during and after welding. • Keep a fire extinguisher in the welding area.
  - Wear fire retardant clothing and hat. Use earplugs when welding overhead.

- ARC RAYS CAN BUR EYES AND SKIN :**
- Select a filter lens which is comfortable for you while welding.
  - Always use helmet when welding. • Provide non-flammable shielding to protect others. • Wear clothing which protects skin while welding.

- FUMES AND GASES CAN BE DANGEROUS :**
- Use ventilation or exhaust to keep air breathing zone clear, comfortable.
  - Use helmet and positioning of head to minimize fume in breathing zone.
  - Read warnings on electrode container and material safety data sheet (MSDS) for electrode.
  - Provide additional ventilation/exhaust where special ventilation requirements exist.
  - Use special care when welding in a confined area.
  - Do not weld unless ventilation is adequate.

- CONFINED SPACE :**
- Carefully evaluate adequacy of ventilation especially where electrode requires special ventilation or where gas may displace breathing air.
  - If basic electric shock precautions cannot be followed to insulate welder from work and electrode, use semiautomatic, constant-voltage equipment with cold electrode or stick welder with voltage reducing device.
  - Provide welder helper and method of welder retrieval from outside enclosure.





ISO 9001:2005



FLUX CORED WELDING WIRE

# AWS E71T-1

## ลวดเชื่อมฟลักซ์คอร์

**15** กก.  
kg

### SHIELDING GAS

100% CO<sub>2</sub> shielding gas.

ลวดเชื่อมฟลักซ์คอร์ 1.2 mm E71T-1 เป็นลวดเชื่อมที่มี ฟลักซ์คอร์ อยู่ในแกนกลางของลวดเชื่อม เหมาะสำหรับงานเชื่อมต่อเรือ ชิ้นส่วนรถยนต์ หรืออุตสาหกรรมที่มีขนาดใหญ่

**Sumo AWS E71T-1**  
Is a flux-cored welding wire basic-rutile designed for all position welding of mild steel in applications requiring moderate levels strength and very good toughness. Impact values of weld metal are good.

**APPLICATIONS**  
All position welding of machinery, shipbuilding, bridges, offshore structures, Structural fabrication.

- ADVANTAGE**
- Excellent mechanical properties.
  - Slag system provides for puddle support, good wetting, and bead shape in all position.
  - Arc action and metal transfer are smooth.
  - Slag removal is easily achieved with hand tools.
  - One sided welding is possible with ceramic backing and will produce excellent results.
  - Applications include those in general fabrication, Ship or barge construction, building or bridge erection, and off-shore industries.
  - Manufactured under a quality system certified to ISO 9001 requirements.

**▶ มี่สินค้า**

Mechanical Properties			QTY	Weight	Price
Size (mm)	Tensile Strength	Elongation	Spool / Box		
▶ Ø1.2	-	-	1	15 kg	110.-/กก.



Reference Current (DC+)

Wire Diameter	Amps
Ø1.2 mm	160-320A

**SUGGESTION :**

Product should be stored in a dry, enclosed environment, and in its original intact packaging.



**ข้อแนะนำ : ผลิตภัณฑ์ควรเก็บไว้ในที่แห้ง**

Trade Name	E71T-1	Size (mm)	1.2 mm	Production Batch	DATE :			
Executive Standard	GB/T10045-2001 E501T-1 ( AWS A5.20 E71T-1C )			Quantities : 15 kg				
Chemical Composition (%) Ø1.2 mm				Mechanical Properties of Deposited				
C	Mn	Si	P	S	Tensile Strength MPa	Yield Strength MPa	Longation & (%)	Impact Energy -20 °C
0.06	1.44	0.41	0.012	0.009	557	485	27	110/107/112
Examination Clerk	Quality Leader			This certificate is invalid without seal of quality control department.				

- ELECTRIC SHOCK CAN KILL :**
- Insulate welder from workpiece and ground using dry insulation. Rubber mat or dry wood.
  - Wear dry, hole-free gloves. (Change as necessary to keep dry.)
  - Do not touch electrically "hot" parts or electrode with bare skin or wet clothing.
  - If wet area and welder cannot be insulated from workpiece with dry insulation, use a semiautomatic, constant-voltage welder or stick welder with voltage reducing device.
  - Keep electrode holder and cable insulation in good condition. Do not use if insulation damaged or missing.

- WELDING SPARKS CAN CAUSE FIRE OR EXPLOSION :**
- Do not weld on containers which have held combustible materials (unless strict AWS F4.1 procedures are followed). Check before welding.
  - Remove flammable materials from welding area or shield from sparks, heat.
  - Keep a fire watch in area during and after welding. • Keep a fire extinguisher in the welding area.
  - Wear fire retardant clothing and hat. Use earplugs when welding overhead.

- ARC RAYS CAN BUR EYES AND SKIN :**
- Select a filter lens which is comfortable for you while welding.
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- FUMES AND GASES CAN BE DANGEROUS :**
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  - Use helmet and positioning of head to minimize fume in breathing zone.
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  - Provide additional ventilation/exhaust where special ventilation requirements exist.
  - Use special care when welding in a confined area.
  - Do not weld unless ventilation is adequate.

- CONFINED SPACE :**
- Carefully evaluate adequacy of ventilation especially where electrode requires special ventilation or where gas may displace breathing air.
  - If basic electric shock precautions cannot be followed to insulate welder from work and electrode, use semiautomatic, constant-voltage equipment with cold electrode or stick welder with voltage reducing device.
  - Provide welder helper and method of welder retrieval from outside enclosure.

**WELDING POSITIONS**





EN17632 ⚡  
CE 0035-CPD-C742-15



FLUX CORE WELDING WIRES

# MIG E71T-1C

## ลวดเชื่อมฟลักซ์คอร์

**15** กก.  
kg

### SHIELDING GAS

100% CO<sub>2</sub> shielding gas.

### แนวเชื่อมมันเงา

### อาร์คได้นิ่ม สะเก็ดไฟน้อย

#### Sumo E71T-1C

is a flux-cored welding wire basic-rutile designed for all position welding of mild steel in applications requiring moderate levels strength and very good toughness. Impact values of weld metal are good.

#### APPLICATIONS

All position welding of machinery, shipbuilding, bridges, offshore structures, Structural fabrication.

**CONFORMANCE**  
ISO 9001:2000

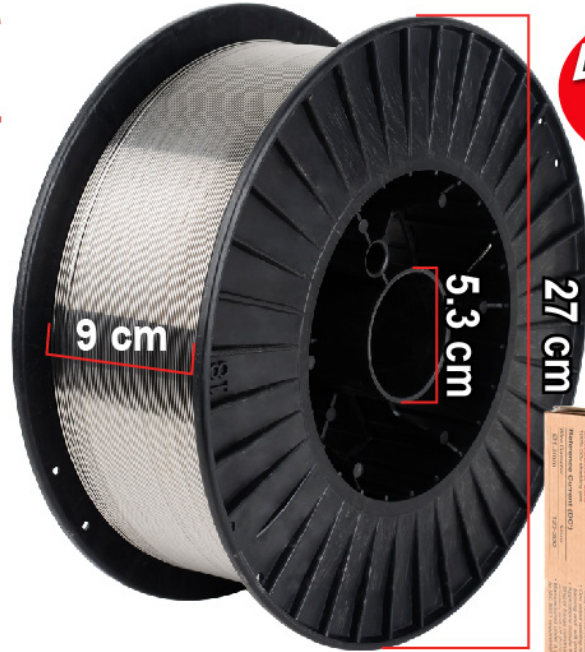
AWS A5.20 E71T-1C

#### ADVANTAGE

- Excellent mechanical properties.
- Slag system provides for puddle support, good wetting, and bead shape in all position.
- Arc action and metal transfer are smooth.
- Slag removal is easily achieved with hand tools.
- One sided welding is possible with ceramic backing and will produce excellent results.
- Applications include those in general fabrication, Ship or barge construction, building or bridge erection, and off-shore industries.
- Manufactured under a quality system certified to ISO 9001 requirements.

#### ▶ มีสินค้า

Mechanical Properties			QTY Spool / Box	Weight	Price
Size (mm)	Tensile Strength	Elongation			
▷ Ø1.2	-	-	1	15 kg	140.-/กก.



#### Reference Current (DC+)

Wire Diameter	Amps
Ø1.6 mm	180-450A
Ø1.2 mm	120-300A

#### APPROVALS

CCS	:	3YSH10
LR	:	3YSH10
GL	:	3YH5S
ABS	:	3YSAH10
DNV	:	IIISH10
BV	:	SA3YMH10
NK	:	KSW53GH10
RINA	:	3YSAH10

#### SUGGESTION :

Product should be stored in a dry, enclosed environment, and in its original intact packaging.

**ข้อแนะนำ : ผลิตภัณฑ์ควรเก็บไว้ในที่แห้ง**

### CHEMICAL COMPOSITION (%) Ø1.2mm

ELEMENT	C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
REQUIREMENT	≤0.12	≤1.75	≤0.90	≤0.03	≤0.03	-	-	-	-	-
ACTUAL RESULT	0.048	1.22	0.38	0.0038	0.012	-	-	-	-	-

### Mechanical Properties

	Tensile Strength MPa	Yield Strength MPa	Elongation (%)	Impact Temp (°C)	Impact Value (J)
Requirement	≥490	≥400	≥22	-20	≥47
Real Parameter	529	462	26	-20	54 63 119

### WELDING POSITIONS



### ⚠ WARNING

PROTECT yourself and others. Read and understand this information. FUMES AND GASES can be hazardous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can KILL.  
• Before use, read and understand the manufacturer's instructions, Material Safety Data Sheets (MSDSs), and your employer's safety practices. • Keep your head out of fumes. • Use enough ventilation, exhaust at the arc, or both, to keep fumes and gases from your breathing zone and the general area. • Wear correct eye, ear, and body protection. • Do not touch live electrical parts.



# ลวดเชื่อมสแตนเลส

## STAINLESS STEEL WIRE

# MIG ER308LSi

**12.5<sup>nn.</sup>**  
**kg**



**ใช้แก๊ส**  
**100% CO<sub>2</sub>**  
**shielding gas.**

Shielding Gas

• 100% CO<sub>2</sub>

• 90% Helium / 7-1/2% Argon / 2-1/2% CO<sub>2</sub>

MIG ER308LSi สำหรับงานเชื่อมสแตนเลสเกรด 304 และ 304L หรือสแตนเลสทั่วไปในกลุ่ม Austenitic ที่จะนิยมเรียกกันว่า "18-8" มีคุณสมบัติดีกว่า ER308L เนื่องจากมีส่วนผสมของซิลิกอน จึงทำให้การเชื่อมมีประสิทธิภาพดีกว่ามีลักษณะการไหลของน้ำโลหะได้ดีแนวเชื่อมซึมลึกเชื่อมได้นิ่มและเรียบเหมาะกับการใช้งานที่ต้องการแนวเชื่อมที่สวยงามพร้อมทั้งทนต่อการกัดกร่อนได้ดีเยี่ยม ER308LSi is designed for joining type 304 and 304L stainless steels and other common austenitic stainless steels referred to as "18-8" steels. It has the same analysis as ER308L but with higher silicon content. The higher silicon content improves arc stability, bead appearance and wetting action. ER308LSi produces exceptionally smooth welds for applications that require a good cosmetic appearance and excellent corrosion resistance.

Type	Mechanical Properties			Weight	Price
	Size (mm)	Tensile Strength	Elongation		
MIG (Wire)	<b>0.8</b>	-	-	12.5 kg	<b>385.-/กก.</b>
	<b>0.9</b>	1350-1450 N/mm <sup>2</sup>	2%	12.5 kg	<b>375.-/กก.</b>
	<b>1.2</b>	1250-1350 N/mm <sup>2</sup>	3%	12.5 kg	<b>370.-/กก.</b>

Certificate of Quality For Welding Electrode			
Name of Commodity : Welding Wire		Cer No.:TW23E0130E	
Trade name	Diameter(mm)	Batch No.	Application Standard
MIG ER308LSi	0.8mm	2.30E+07	AWS A5.9 ER308LSi

Chemical Composition of Deposited Metal (%) Ø0.8, Ø1.2 mm									
Test item	C	Si	Mn	S	P	Ni	Cr	Mo	Cu
Standard	≤0.03	0.65-1.00	1.00-2.50	≤0.02	≤0.025	9.00-11.00	19.50-22.00	≤0.75	≤0.75
Actual Result	0.022	0.83	1.87	0.008	0.018	9.73	19.96	0.01	0.02

Mechanical Properties of Deposited Metal							
Test item	Tensile Test Of Deposited Metal			V-Notch Impact Test			
	Tensile strength Rm (MPa)	Yield point ReL (MPa)	Elongation (%)	Impact Temp (°C)	Impact value Average (J)	X-Ray	Diffusion hydrogen content (ml/100g)
Standard	≥510	-	≥25	-	-	I	-
Actual Result	600	-	45	-	-	I	-

CHEMICAL COMPOSITION (%) Ø0.9 mm												
ELEMENT	Tensile Strength (MPa)	Elongation (%)	ELEMENT	C	Si	Mn	P	S	Ni	Cr	Mo	Cu
REQUIREMENT	≤520	≤35	REQUIREMENT	≤0.3	0.65-1.00	1.00-2.50	≤0.030	≤0.030	9.00-11.00	19.50-22.00	≤0.75	≤0.75
ACTUAL RESULT	594	45	ACTUAL RESULT	0.016	0.86	1.94	0.017	0.013	9.73	19.98	0.010	0.010

### Advantage

- Excellent operator appeal-great weld puddle fluidity and bead shape.
- Superior corrosion and crack resistance.
- ISO 9001 certified-manufactured to standards for environmental and quality management systems.

### Key Features

- High silicon level for increased puddle fluidity and toe wetting.
- Proprietary surface lubricant for steady feeding and arc stability.
- Versatile electrode designed to weld CrNi austenitic stainless steels.
- Controlled ferrite content for maximum corrosion resistance.

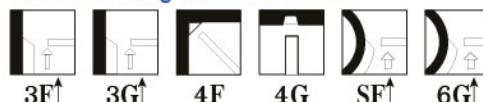
### Application :

### Welding Positions

Globular and Spray Transfer :



Short Circuiting and Pulsed Arc :



**การใช้งาน**  
เหมาะกับการเชื่อมอุตสาหกรรมต่อเรือ ยานยนต์ เครื่องจักรในอุตสาหกรรมอาหาร ยา และเครื่องใช้ไฟฟ้า  
Application: Ship building, automobile, electric power food medicine machinery manufacturing.

**วิธีใช้ :** สำหรับเชื่อมสแตนเลส  
**ข้อแนะนำ :** เลือกลวดเชื่อมให้เหมาะกับชิ้นงาน

**⚠ WARNING**

PROTECT yourself and others.  
Read and understand this information.  
FUMES AND GASES can be hazardous to your health.  
ARC RAYS can injure eyes and burn skin.  
ELECTRIC SHOCK can KILL.

คำเตือน: สวมอุปกรณ์ป้องกันทุกครั้ง





AWS E308LT1-1  
 AWS A5.22 E308LT1-1  
 GB/T 17853 TS 308L-FC11  
 JIS Z3323 YF308LC  
 EN ISO 17633-B TS308L-FB1



ลวดเชื่อมฟลักซ์คอร์สแตนเลส  
 FLUX CORE STAINLESS STEEL WIRE

**MIG E308L**

**MIG 308L** สำหรับงานเชื่อมสแตนเลส มีคุณสมบัติในการป้องกันการกัดกร่อน ไม่มีรูอากาศ เหมาะสำหรับงานเชื่อมที่ต้องการคุณภาพสูงและผ่านการ X-Ray ได้ดี เช่น งานเชื่อมท่อน้ำมัน ถังน้ำมันงานอุตสาหกรรมการต่อเรือ

**MIG 308L** for stainless steel welding Has anti-corrosion properties, no air holes, suitable for welding work that Need high quality and pass X-Ray well, such as welding of oil pipes, oil tanks, shipbuilding industry.

**Features**

- Easy to control, able to welding at any position.
- Has anti-corrosion properties.

**Key Features**

- X-ray quality welds and good penetration.
- Excellent slag removal.
- Provides excellent weldability and crack resistance.



**Shielding Gas**

- 100% CO<sub>2</sub>
- 75% Argon 25% CO<sub>2</sub>

Type	Size (mm)	Weight	Price
MIG (Wire)	<b>1.2</b>	<b>12.5 kg</b>	<b>520.-/กก.</b>



Specification & Classification	GB/T17853 TS 308L-FC11 AWS A5.22 E308LT1-1				Commodity	MIG 308L	Dimension	1.2 mm	
<b>(%) CHEMICAL COMPOSITION OF DEPOSITED METAL Ø1.2 mm</b>									
Elements	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Cu</b>
Requirement	≤0.04	0.5-2.5	≤1.0	≤0.03	≤0.04	18.0-21.0	9.0-11.0	≤0.5	≤0.5
Actual Result	0.026	1.110	0.6	0.005	0.013	19.960	9.66	0.02	0.01
Mechanical Property of Deposited Metal	Yield Strength Mpa	Tensile Strength Mpa	Elongation %	Reduction of Area %	Test Temperature °C	Ave. Energy J	BENDING TEST ACCORDING TO	RADIOGRAPHIC ACCORDING TO	FILET WEIDING TEST
Requirement	-	≥520	≥35	-	-	-	-	II	-
Actual Result	-	610	42	-	-	-	-	I	-
SHIELDING GAS		CURRENT (A)	VOLTAGE (V)	POLARITY	PREHEAT	INTERPASS (°C)		WS (MM/MIN)	
CO2		130-260	26-32	DCEP	-	16-150		300-400	
We hereby certify that this report is correct and that all test results are in compliance with the specification described herein.					Inspection Stamp	Manager of QA		Remarks	

**Welding Positions**

Globular and Spray Transfer :



Short Circuiting and Pulsed Arc :



**WARNING**

คำเตือน : สวมอุปกรณ์ป้องกันทุกครั้ง  
 PROTECT yourself and others. Read and understand this information.  
 FUMES AND GASES can be hazardous to your health. ARC RAYS can injure eyes and burn skin. ELECTRIC SHOCK can KILL.