






CONSUMABLES

- MMA Electrodes & Hardfacing
- TIG Tungsten Electrodes
- TIG Filler Rods
- MIG/MAG Wire Reels

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MMA Electrodes & Hardfacing

Electrode type	Normalisation	Description & example of applications	Mechanical characteristics	Polarity
Steel	EN 499 - E420 RC11 AWS A 5.1 - E 6013 DIN 1913 - E 43 21 RC11	<ul style="list-style-type: none"> • Easy to strike • Good welding in any position • Flat to slightly curved cords and easy to clean • Maintenance, steel frame, metal sheet... 	AFNOR NF 1594.1 Re 440 MPa Rm 540 MPa A 5 d 54% FV 0°C 50j	Polarity (-) 
Cast Iron	AWS 5.15 - E-NiFe C1 NF A 81342 - E-NiFe BG 13 DIN 8575 - E-NiFe BG 13	<ul style="list-style-type: none"> • Ferro-nickel alloy highly resistant to cracking • Excellent sticking even on old cast irons • High mechanical characteristics • Welding cylinder head, engine block, body pump, dented wheel.. 	Re 390 MPa Rm 550 MPa 180HB	Polarity (+) 
Stainless Steel	EN 1600 - 19123 LR12 AWS 5.4 - E 316 L-16	<ul style="list-style-type: none"> • Smooth and regular melting • Excellent welding finish • Welding of Stainless Steel 304, 308, 316L, 188 et 1883 • Pipes, tanks... 	AFNOR NF 1597.1 Re 350 MPa Rm 490 MPa A 5 d 30% FV 0°C 60j	Polarity (+) 
Aluminium	DIN 1732 - EL-AISI5 AWS A 5.3 - E 4043	<ul style="list-style-type: none"> • Designed for welding Aluminium and Aluminium alloys • Foundries, engine blocks, cylinder heads, tanks, automotive, marine, chemical ... 	Rm 110-160 MPa A 5 d >15% ~50HB	Polarity (+) 
Hardfacing (600 HB)	DIN 8555 - E 2 UM-60	<ul style="list-style-type: none"> • High resistance to abrasion and shock • Good resistance to heat • Smooth melting • Recommended for repairing used parts 	AFNOR NF 1594.1 Brinell HB 580-610 Rockwell HRC 555-60	Polarity (-) 

GYS part number																	
Steel			Cast Iron			Stainless Steel			Aluminium		Hardfacing						
Blister :			Blister :			Blister :			Blister :		Blister :						
ø1.6	x17	084315	ø1.6	x210	085114	ø2.5	x12	083332	ø2 (316L)	x12	082359	ø3.2	x5	084803	ø2.5	x46	081543
ø1.6	x50	084414	ø2	x355	085022	ø3.2	x9	083349	ø2.5 (308L)	x10	082328				ø3.2	x141	081529
ø2	x50	084421	ø2	x155	085121				ø2.5 (316L)	x10	082335				ø3.2	x22	081574
ø2	x13	084322	ø2.5	x230	085039				ø3.2 (316L)	x8	082342				ø4	x90	081512
ø2.5	x50	084438	ø2.5	x110	085138										ø4	x14	081581
ø2.5	x11	084339	ø3.2	x165	085046												
ø3.2	x50	084445	ø3.2	x70	085145												
ø3.2	x9	084346	ø4	x110	085053												
ø4	x8	084353	ø4	x47	085152												
ø4	x50	084452															

TIG Filler Rods

Filler rod type	Normalisation	Description & example of applications	Mechanical Characteristics
Steel	AWS 5.18 - ER70S-6 EN 636-A - W 46 4 W3Si1	<ul style="list-style-type: none"> • TIG filler rods for welding in direct current 	Re 480 MPa Rm 580 MPa A 5 d 28% KV 20°C 160j
Stainless Steel (308L)	EN 12072 - W19.9L DIN 8556 - X2CrNi19.9 AWS A5.9 - ER308L	<ul style="list-style-type: none"> • Stainless Steel TIG filler rods for welding in direct current • Suitable for food industry, organic acid... 	Re 380 MPa Rm 610 MPa A 5 d 42% KV 20°C 100j
Stainless Steel (316L)	EN 12072 - W19.12.3 L DIN 8556 - X2CrNiMo19.12 AWS A5.9 - ER316L	<ul style="list-style-type: none"> • Stainless Steel TIG filler rods for welding in direct current • Suitable for corrosive environments, acid, chlorine... 	Re 400 MPa Rm 590 MPa A 5 d 39% KV 20°C 100j
Aluminium	NF A 81.331 - N-AIMg5 AWS A5.10 - ER5356	<ul style="list-style-type: none"> • Aluminium TIG filler rods for welding in alternating current 	Re 210 MPa Rm 235 MPa A 5 d >15%

GYS part number															
Steel				Stainless Steel (308L)				Stainless Steel (316L)				Aluminium			
Blister :				Blister :				Blister :				Case :			
ø1.6	x60	330mm	087224	ø1.6	x60	330mm	087248	ø1.6	x60	330mm	087262	ø1.6	x920	1m	087170
ø2	x40	330mm	087231	ø1.6	x319	1m	087156	ø1.6	x315	1m	087125	ø2	x590	1m	087187
Case :				ø2				ø2				ø2.4			
ø1.2	x319	1m	087019	ø2	x40	330mm	087255	ø2	x40	330mm	087279				
ø2	x204	1m	087217	ø2.4	x204	1m	087163	ø2	x205	1m	087200				
ø2.4	x142	1m	087033					ø2.4	x140	1m	087149				

TIG Tungsten Electrodes

Electrode type	Normalisation	Description & example of applications	Current
Pure	EN 26848 ISO 6848	<ul style="list-style-type: none"> • Designed for welding Aluminium in AC • The tip of this electrode is green • Within seconds well formed ball is created at the end of the electrode. It must not be sharpened. 	AC
Lanthanum	EN 26848 ISO 6848	<ul style="list-style-type: none"> • Designed for welding Steel and Stainless Steel in DC and Aluminium in AC • Slow wear and consumes less power at striking • The tip of this electrode is gold • To sharpen according to the metal to weld in an angle of approximately 30° to 60° 	AC / DC according to the metal to weld
WR2	DIN 1732 - EL-AISI5 AWS A 5.3 - E 4043	<ul style="list-style-type: none"> • Designed for welding Steel and Stainless Steel in DC and Aluminium in AC • The tip of this electrode is turquoise • To sharpen according to the metal to weld in an angle of approximately 30° to 60° 	AC / DC according to the metal to weld

GYS part number															
Thoriated				Pure				Lanthanum				WR2			
Blister :				Blister :				Blister :				Blister :			
ø1.6	x10		044524	ø1.6	x10		044555	ø1.6	x10		044330	ø1.6	x10		044586
ø2	x10		044531	ø2.4	x10		044579	ø2	x10		044347	ø2	x10		044593
ø2.5	x10		044548					ø2.4	x10		044354	ø2.4	x10		044609
								ø3.2	x10		044361	ø3.2	x10		044616

MIG/MAG Wire Reels

Wire reel type	Normalisation	Description & example of applications	Mechanical characteristics
Steel (SG2)	AWS A5.18 - ER70S-6 EN 440 - G3 Si 1	<ul style="list-style-type: none"> • MAG filler metal for welding steel. • Used in general construction, shipbuilding, bridges ... 	Re 470 MPa Rm 560 MPa A 5 d 26% KV 20°C 150j
Galva (G2TI)	AWS A5.18 - ER70S-6	<ul style="list-style-type: none"> • MAG filler metal for welding carboned Steel, galvanized Steel... • Suitable for construction of general use, metal construction, maintenance of agricultural equipment... 	Re 460 MPa Rm 560 MPa A 5 d 28% KV 20°C 150j
Cored Wire	AWS A5.20 - E71T-GS EN 758 - T 42 Z W N 1H10	<ul style="list-style-type: none"> • MAG filler metal for welding Steel. • No need for a gas supply and is insensitive to external disturbances such as wind 	Re 430 MPa Rm 520 MPa A 5 d 22%
AlMg5	AWS A5.10 - ER 5356 DIN 1732 - AlMg5	<ul style="list-style-type: none"> • MIG filler metal for welding alloys from Aluminium to Magnesium. • Used in shipbuilding, tanks, railway and automotive industries. 	Re 280 MPa Rm 350 MPa A 5 d 26%
AlSi5	AWS A5.18 - ER 70S6	<ul style="list-style-type: none"> • MIG filler metal for repairing and hardfacing alloys of Aluminum Silicon forged and casted. • Smooth welding. 	Re 100 MPa Rm 160 MPa A 5 d 15% KV 20°C 20j
AlSi12	AWS A5.10 - ER 4047 DIN 1913 - E 51 21 R3	<ul style="list-style-type: none"> • MIG filler metal for welding Aluminium alloys. • Used for window frames, aluminum tubes, furniture, engine blocks, auto parts... 	Re 100 MPa Rm 160 MPa A 5 d 15 % KV 20°C 20j
Stainless Steel 308LSi	AWS A5.9 - ER 308L Si EN 12072 - G19 9L	<ul style="list-style-type: none"> • MIG filler metal for welding Stainless Steel • Suitable for food industry. Corrosion resistance, organic acid, saline or alkaline solution... 	Re 380 MPa Rm 600 MPa A 5 d 40% KV 20°C 90j
Stainless Steel 316LSi	AWS A5.9 - ER 316L Si EN 12072 - G19 12 3L	<ul style="list-style-type: none"> • MIG filler metal for welding Stainless Steel • High resistance to acid and chlorinated environments 	Re 400 MPa Rm 600 MPa A 5 d 39% KV 20°C 95j
CuSi3	DIN 1733 - CuSi3 AWS A5.7 - ER CuSi-A	<ul style="list-style-type: none"> • Designed for welding Boron Steel • Used in the industrial sector in general 	Re 120 MPa Rm 350 MPa A 5 d 40 % KV 20°C 60j
CuAl8	AWS A5.7 - ER CuAl-A1 EN 12072 - G19 9L	<ul style="list-style-type: none"> • Designed for welding Boron Steel • Resistance to saline environment, it is ideal for shipbuilding, chemical industry ... 	Re 180 MPa Rm 400 MPa A 5 d 40 %

GYS part number							
Steel (SG2)		Galva (G2TI)		Cored wire		AlMg5	
∅0.6-D100	086593	∅0.6-D200	086760	∅0.9-D100	086104	∅0.8-D100	086548
∅0.6-D200	086111	∅0.8-D200	086777	∅0.9-D200	086623	∅0.8-D200	086555
∅0.6-D300	086166			∅1.2-D200	086630	∅1.0-D200	086562
∅0.8-D100	086609					∅1.0-D300	086524
∅0.8-D200	086128					∅1.2-D300	086531
∅0.8-D300	086227						
∅0.8-D300 eco	086272						
∅1.0-D200	086135						
∅1.0-D300	086234						
∅1.0-D300 eco	086289						
∅1.2-D300	086241						
∅12-D300 eco	086296						
AlSi5		AlSi12		Stainless Steel 308LSi		Stainless Steel 316LSi	
∅0.8-D100	086685	∅0.8-D100	086678	∅0.8-D100	086616	∅0.8-D200	086326
∅1.0-D200	086142	∅1.0-D200	086067	∅0.8-D200	086579		
∅12-D200	086159	∅1.2-D200	086074				
CuSi3		CuAl8					
∅0.8-D100	086692	∅0.8-D200	086661				
∅0.8-D200	086647						
∅10-D200	086654						