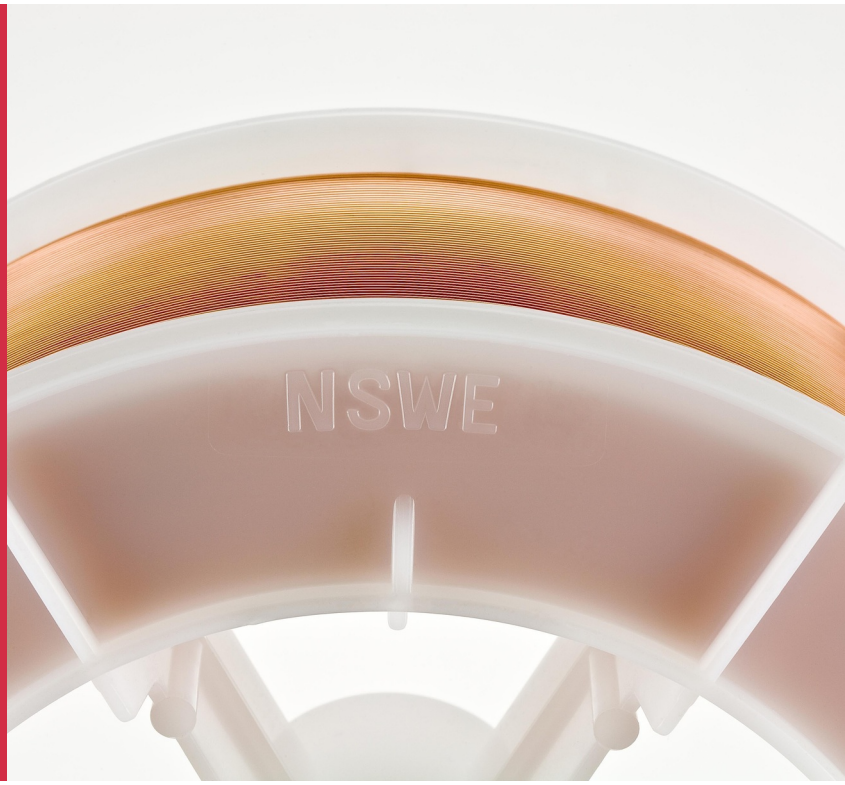
RANGE & ORDERING GUIDE

NST MIG/MAG Welding Wires

Solid, Flux-Cored & Metal-Cored Wire

For fabrication, repair and specialist steelwork.



Find the Right Wire

Choose by material, wire type and the requirements of your welding procedure. The NSWE seamless range is also known by the earlier names NSSW and Nittetsu.

Material / Wire Type	Range	Pages
Solid Wire for Carbon & Low-Alloy Steel	Carbomig and Fliess	02
Flux-Cored Wire for Steel	Seamless SF grades	03–05
Metal-Cored Wire for Steel	Seamless SM grades	06
Stainless & Duplex Flux-Cored Wire	NST A, LT and 329J3L grades	07–09
Stainless & Duplex Solid Wire	NST, UGIWELD and Exaton	10–12
Aluminium MIG Wire	MIG WELD 4043, 5356 and 5183	13
Nickel Alloy & Cast Iron Wire	NST Alloy 625 and Lastifil	14
Repair & Hardfacing Wire	Lastifil	15

Ordering From R H Davey

Underlined article numbers link to matching R H Davey products. For other supplier packs, quote the grade, diameter, pack and article number so we can confirm UK availability. D200 and D300 refer to spool size.

Contents

CARBON & LOW-ALLOY STEEL

Solid MIG/MAG Wire for Steel

Copper-coated solid wire for structural and general steel fabrication.

NST Carbomig 2N



Use for General fabrication in unalloyed steels. Copper-coated SG2 wire for manual or mechanised work.

Shielding C1 or M21

EN ISO 14341-A: G 46 2 M21 3Si1
AWS: A5-18/SFA5.18: ER70S-6

Ø mm	Pack	NST article
0.6	5 kg D200	**90606L**
0.8	5 kg D200	**90708L**
0.8	15 kg D300	**90708**
0.8	250 kg drum	**90708F**
1.0	5 kg D200	**90710L**
1.0	15 kg D300	**90710**
1.0	250 kg drum	**90710F**
1.2	15 kg D300	**90712**
1.2	250 kg drum	**90712F**

Technical datasheet

NST Carbomig 3N



Use for Unalloyed steel fabrication requiring an SG3 wire with higher silicon and manganese.

Shielding C1 or M21

EN ISO 14341-A: G 42 2 C1 G4Si1
AWS: A5-18/SFA5.18: ER70S-6

Ø mm	Pack	NST article
0.8	15 kg D300	**90808**
0.8	250 kg drum	**90808F**
1.0	15 kg D300	**90810**
1.0	250 kg drum	**90810F**
1.2	15 kg D300	**90812**
1.2	250 kg drum	**90812F**

Technical datasheet

Fliess ED ER80S-Ni1



Use for Fine-grain and low-alloy structural steels where nickel-alloyed weld metal is specified.

Shielding M21

EN ISO 14341-A: G 46 6 M21 3Ni1
AWS A5.28: ER80S-Ni1

Ø mm	Pack	NST article
0.8	15 kg spool	**802508**
1.0	15 kg spool	**802510**
1.2	15 kg spool	**802512**
1.6	15 kg spool	**802516**
0.8	250 kg drum	**802808**
1.0	250 kg drum	**802810**
1.2	250 kg drum	**802812**
1.6	250 kg drum	**802816**

Technical datasheet

Start with the steel grade

Carbomig 2N and 3N are SG2 and SG3 options for unalloyed steel. The Fliess grade is a nickel-alloyed wire for low-alloy and fine-grain steel.

CARBON & LOW-ALLOY STEEL

Flux-Cored Wire for Fabrication

Seamless rutile wires for carbon steel and low-alloy steel, with grades for mixed gas and pure CO_2.

SF-1A

Use for Positional fabrication and shipbuilding in carbon steel, including root passes against ceramic backing.



Shielding M21

EN ISO 17632-A: T 42 2 ZMn P M21 1 H5
AWS A5.20 E71T-1M H4

Ø mm	Pack	NST article
1.0	5 kg spool	500110
1.0	12.5 kg spool	500120
1.2	5 kg spool	500223
1.2	12.5 kg spool	500124
1.2	250 kg drum	500320
1.4	12.5 kg spool	500141
1.4	250 kg drum	500330
1.6	12.5 kg spool	500160
1.6	250 kg drum	500360

Technical datasheet R H Davey range

SF-1E

Use for Positional carbon steel fabrication and shipbuilding on procedures specifying CO_2 shielding.



Shielding C1

EN ISO 17632-A: T 42 2 ZMnNi P C1 1 H5
AWS A5.20 E71T-1C

Ø mm	Pack	NST article
1.0	5 kg spool	500115
1.2	5 kg spool	500130
1.2	12.5 kg spool	501151
1.2	250 kg drum	501157
1.4	12.5 kg spool	501158

Technical datasheet

SF-3A

Use for Positional welding of carbon steel for shipbuilding and fabrication with impact requirements at −40 °C.



Shielding M21

EN ISO 17632-A: T 46 4 ZMnNi P M21 1 H5
AWS A5.20 E71T-9M-JH4

Ø mm	Pack	NST article
1.0	5 kg spool	5110270
1.2	5 kg spool	5112270
1.2	12.5 kg spool	5112470
1.2	250 kg drum	511320
1.4	12.5 kg spool	5114470
1.6	12.5 kg spool	5116470

R H Davey code for 5116470 / SF3A16125

Technical datasheet R H Davey range

SF-3E

Use for Carbon and low-alloy steel fabrication with −40 °C impact requirements and CO_2 shielding.



Shielding C1

EN ISO 17632-A: T 46 4 ZMn P C1 2 H5
AWS A5.29 E81T1-GC-H4

Ø mm	Pack	NST article
1.2	5 kg spool	5112580
1.2	12.5 kg spool	5112280

Technical datasheet

Contents

CARBON & LOW-ALLOY STEEL

Flux-Cored Wire for Offshore & Pipework

Seamless flux-cored wires for offshore structures, pipework and restrained joints.

SF-3M

Use for Shipbuilding and offshore structures with −40 °C impact requirements. NST reports CTOD testing.



Shielding C1

EN ISO 17632-A: T 46 4 ZMnNi P C1 2 H5
AWS A5.20 E71T-9C-JH4

Ø mm	Pack	NST article
1.2	5 kg spool	**5112282**
1.2	12.5 kg spool	**5112480**

Technical datasheet

SF-3AM

Use for Offshore structures, pipework and other low-alloy steel fabrication with low-temperature toughness requirements.



Shielding M21

EN ISO 17632-A: T 46 4 ZMn1Ni P M21 2 H5
EN ISO 17632-A: T 46 6 ZMn1Ni P M21 2 H5
AWS A5.29 E81T1-Ni1M-H4

Ø mm	Pack	NST article
1.0	5 kg spool	**5210227**
1.2	5 kg spool	**5212227**
1.2	12.5 kg spool	**5212427**
1.2	250 kg drum	**5212500**
1.4	12.5 kg spool	**5214480**
1.4	250 kg drum	**5212400**
1.6	12.5 kg spool	**5216427**

Technical datasheet R H Davey range

SF-3AMSR

Use for Piping and fabrication where the welding procedure calls for post-weld heat treatment.



Shielding M21

EN ISO 17632-A: T 42 4 ZMnNi P M21 2 H5
AWS A5.29 E71T1-GM-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5212715**
1.2	12.5 kg spool	**5212717**

Technical datasheet

SF-36EA

Use for Restrained carbon and low-alloy steel joints, particularly in flat and fillet positions.



Shielding M21

EN ISO 17632-A: T 46 4 ZMnNi R M21 2 H5
AWS A5.29 E81T1-Ni1M-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5312405**
1.2	12.5 kg spool	**5312400**

Technical datasheet

Check the required test condition

If the job specifies CTOD or post-weld heat treatment, check the grade datasheet and the procedure qualification for the required test temperature and condition.

CARBON & LOW-ALLOY STEEL

Flux-Cored Wire for High-Strength Steel

Seamless flux-cored wires for low-temperature service and higher-strength steels.

SF-36E

Use for Low-temperature steel and offshore fabrication, including roots against ceramic backing.



Shielding C1

EN ISO 17632-A: T 46 6 ZMn1.5Ni P C1 2 H5
AWS A5.29 E81T1-K2C-H4

Ø mm	Pack	NST article
1.2	12.5 kg spool	**5312403**

Technical datasheet

SF-47E

Use for Positional low-alloy steel work with −60 °C impact requirements and CO_2 shielding.



Shielding C1

EN ISO 17632-A: T 46 6 ZMn1Ni P C1 2 H5
AWS A5.29 E81T1-Ni1C-JH4

Ø mm	Pack	NST article
1.2	5 kg spool	**5312270**
1.2	12.5 kg spool	**5312470**

Technical datasheet

SF-50A

Use for High-strength steels in the 500 MPa yield class where mixed-gas shielding is specified.



Shielding M21

EN ISO 17632-A: T 50 4 ZMn1.5Ni P M21 2 H5
AWS A5.29 E91T1-K2M-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5212481M**
1.2	12.5 kg spool	**5212480M**

Technical datasheet

SF-50E

Use for High-strength steels in the 500 MPa yield class where CO_2 shielding is specified.



Shielding C1

EN ISO 17632-A: T 50 6 ZMn2.5Ni P C1 2 H5
AWS A5.29 E91T1-Ni2C-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5212585**
1.2	12.5 kg spool	**5212580**

Technical datasheet

SF-65A

Use for Positional welding of high-strength steels such as S550.



Shielding M21

EN ISO 18276-A: T 55 4 ZMn1.5Ni P M21 2 H5
AWS A5.29 E91T1-K2M-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5212265**
1.2	12.5 kg spool	**5212650**

Technical datasheet

SF-80A

Use for Extra high-strength steels in the 690 MPa yield class.



Shielding M21

EN ISO 18276-A: T69 4 ZMn2.5NiMo P M21 2 H5
AWS A5.29 E111T1-GM-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**5212680**
1.2	12.5 kg spool	**5212780**

Technical datasheet

Contents

CARBON & LOW-ALLOY STEEL

Metal-Cored Wire for Steel

Seamless metal-cored wires for manual, mechanised and automated steel fabrication.

SM-3A

Use for Manual and automated welding of unalloyed steel where a metal-cored wire is specified.



Shielding Ar/CO_2

EN ISO 17632-A: T 42 4 ZMn M M21 1 H5
AWS A5.18 E70C-G-H4

Ø mm	Pack	NST article
1.0	5 kg spool	**550221**
1.0	12.5 kg spool	**550217**
1.0	250 kg drum	**550219**
1.2	5 kg spool	**550231**
1.2	12.5 kg spool	**550227**
1.2	250 kg drum	**550229**
1.4	12.5 kg spool	**550228**
1.4	250 kg drum	**550230**

Technical datasheet

SM-47A

Use for Low-temperature steel and pipework. A nickel-alloyed metal-cored wire for short-arc or spray transfer.



Shielding M20 or M21

EN ISO 17632-A: T 46 6 1Ni M M21 1 H5
AWS A5. 28 E80C-Ni1-H4

Ø mm	Pack	NST article
1.0	5 kg spool	**550241**
1.2	5 kg spool	**550251**
1.2	12.5 kg spool	**550247**
1.2	250 kg drum	**550249**
1.4	12.5 kg spool	**550248**
1.4	250 kg drum	**550250**

Technical datasheet

SM-65A

Use for High-strength, low-temperature steel. Suitable for short-arc roots and spray-transfer fillets.



Shielding M21

EN ISO 18276-A: T 55 6 ZMn2Ni M M21 2 H5
AWS A5.28 E90C-G H4

Ø mm	Pack	NST article
1.2	5 kg spool	**550461**
1.2	12.5 kg spool	**550457**

Technical datasheet

SM-80A

Use for Extra high-strength steels in the 690 MPa yield class, including mechanised applications.



Shielding M21

EN ISO 18276-A: T69 4 ZMn2.5NiCrMo M M21 2 H5
AWS A5.28 E110C-G-H4

Ø mm	Pack	NST article
1.2	5 kg spool	**550261**
1.2	12.5 kg spool	**550257**

Technical datasheet

Match the transfer mode

Check the grade datasheet for permitted transfer modes, shielding gas and operating ranges. See the individual pack tables for spools and drums.

Contents

STAINLESS STEEL & DISSIMILAR JOINTS

Positional Stainless Flux-Cored Wire

NST A-series flux-cored wires for positional stainless welding and dissimilar joints.

NST A-308L

Use for Positional welding of 304-type austenitic stainless steels.

Shielding M21



EN ISO 17633-A: T 19 9 L P M21 1
AWS A5.22/A5.22M E308LT 1-4 NS

Ø mm	Pack	NST article
1.2	5 kg D200	**On request**
1.2	12.5 kg D300	**65212N**

Technical datasheet

NST A-309L

Use for Positional joints between 304-type stainless and carbon steel, and cladding on carbon steel.

Shielding M21



EN ISO 17633-A: T 23 12 L P M21 1
AWS A5.22/A5.22M E309LT 1-4

Ø mm	Pack	NST article
1.2	5 kg D200	**61213N**
1.2	12.5 kg D300	**61212N**

Technical datasheet

NST A-309MoL

Use for Positional joints between 316-type stainless and carbon steel.

Shielding M21



EN ISO 17633-A: T 23 12 2 L P M21 1
AWS A5.22/A5.22M E309LMoT 1-4

Ø mm	Pack	NST article
0.9	5 kg D200	**64109N**
1.2	5 kg D200	**64205**
1.2	12.5 kg D300	**64212N**

Technical datasheet

NST A-316L

Use for Positional welding of 316-type stainless steels.

Shielding M21



EN ISO 17633-A: T 19 12 3 L P M21 1
AWS A5.22/A5.22M E316LT 1-4

Ø mm	Pack	NST article
0.9	5 kg D200	**62109N**
1.2	5 kg D200	**62205N**
1.2	12.5 kg D300	**62212N**

Technical datasheet

Choose by the joint

Use the 308L or 316L grade for compatible stainless parent materials. The 309L and 309MoL grades are intended for specified joints between stainless and carbon steel.

STAINLESS STEEL & DISSIMILAR JOINTS

Flat & Fillet Stainless Flux-Cored Wire

NST LT grades for flat and fillet work in stainless steel and dissimilar joints.

NST 309LT

Use for Flat and fillet welding of 304-type stainless to carbon steel, including cladding.

Shielding M21



EN ISO 17633-A: T 23 12 L R M21 3
AWS A5.22/A5.22M E309LT 0-4

Ø mm	Pack	NST article
1.2	12.5 kg D300	**62110**

Technical datasheet

NST 309MoLT

Use for Flat and fillet welding of 316-type stainless to carbon steel.

Shielding M21



EN ISO 17633-A: T 23 12 2 L R M21 3
AWS A5.22/A5.22M E309LMoT 0-4

Ø mm	Pack	NST article
0.9	12.5 kg D300	**65009**
1.2	5 kg D200	**On request**
1.2	12.5 kg D300	**65012**

Technical datasheet

NST 316LT

Use for Flat and fillet welding of 316-type stainless steels.

Shielding M21



EN ISO 17633-A: T 19 12 3 L R M21 3
AWS A5.22/A5.22M E316LT 0-4

Ø mm	Pack	NST article
0.9	12.5 kg D300	**62109**
1.2	12.5 kg D300	**62112**

Technical datasheet

Check the welding position

These grades are intended for flat or specified fillet positions. The positional A-series is on page 7.

DUPLEX STAINLESS STEEL

Duplex Flux-Cored Wire

Two rutile cored wires for 2205-type duplex stainless steel.

NST 329J3L Duplex

Use for Positional welding of 2205-type duplex stainless, including EN 1.4462.



Shielding M21

EN ISO 17633-A: T 22 9 3 N L P M21 1
AWS A5.22/A5.22M E2209T1-4

Ø mm	Pack	NST article
1.2	5 kg D200	**69523**
1.2	12.5 kg D300	**69323**

Technical datasheet

NST 329J3L XLT Duplex

Use for Positional welding of 2205-type duplex where additional low-temperature toughness is specified.



Shielding M21

EN ISO 17633-A: T 22 9 3 N L P M21 1
AWS A5.22/A5.22M E2209T1-4

Ø mm	Pack	NST article
1.2	5 kg D200	**69525**
1.2	12.5 kg D300	**69325**

Technical datasheet

Standard or XLT

NST lists both under the same EN ISO and AWS classifications. Check the XLT datasheet when the job specifies low-temperature impact requirements. Use the qualified procedure for the particular duplex joint.

Compare Duplex Wire Options

2205-Type Duplex	Positional flux-cored	329J3L and 329J3L XLT	**09**
2205-Type Duplex	Solid MIG/MAG	NST MIG Duplex 2209	**10**
2205-Type Duplex	Solid MIG/MAG	UGIWELD 45N	**12**
2507-Type Superduplex	Solid MIG/MAG	UGIWELD 25.9.4 and Exaton 25.10.4.L	**12**

STAINLESS STEEL & DISSIMILAR JOINTS

NST Solid Wire for Stainless Steel

NST solid wires for austenitic stainless steel, dissimilar joints and duplex fabrication.

NST MIG 308LSi

Use for Solid wire for 304- and 304L-type stainless fabrication.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343: 2009 19 9 LSi
AWS: A5.9 ER308LSi

Ø mm	Pack	NST article
1.0	12.5 kg D300	**1263026**
1.0	200 kg drum	**1263033**
1.2	12.5 kg D300	**1263030**
1.2	200 kg drum	**On request**

Technical datasheet

NST MIG 309LSi

Use for Solid wire for joining 304-type stainless to carbon steel.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343: 2009 23 12 LSi
AWS: A5.9 ER 309LSi

Ø mm	Pack	NST article
1.0	12.5 kg D300	**1263023**
1.2	12.5 kg D300	**1263021**

Technical datasheet

NST MIG 316LSi

Use for Solid wire for 316- and 316L-type stainless fabrication.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343: 2009 G 19 12 3 LSi
AWS: A5.9 ER 316LSi

Ø mm	Pack	NST article
0.8	5 kg D200	**1263116**
0.8	12.5 kg D300	**1263016**
0.8	200 kg drum	**1263216**
1.0	12.5 kg D300	**1263018**
1.0	Drum, confirm weight	**1263218**
1.2	12.5 kg D300	**1263019**
1.2	250 kg drum	**1263028**
1.6	12.5 kg D300	**1263020**

Technical datasheet

NST MIG Duplex 2209

Use for Solid wire for 2205-type duplex stainless fabrication.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343: 2009 22 9 3 N L
AWS: A5.9 ER 2209

Ø mm	Pack	NST article
1.0	12.5 kg D300	**1263034**
1.2	12.5 kg D300	**1263022**

Technical datasheet

Compare by grade and pack

The pack table gives NST article numbers for each listed diameter. Drum formats and spool sizes vary by grade.

STAINLESS STEEL & DISSIMILAR JOINTS

UGIWELD Solid Wire for Stainless Steel

UGITECH UGIWELD solid wires available through NST for stainless and dissimilar joints.

UGIWELD 308LM (MIG 308LSi)

Use for Solid wire for 304- and 304L-type stainless fabrication.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343: 2009 19 9 LSi
AWS: A5.9 ER308LSi

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

UGIWELD 309LM (MIG 309LSi)

Use for Solid MIG wire for dissimilar joints between stainless and carbon steel.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343-A 23 12 L Si
AWS A5.9 ER309LSi

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

UGIWELD 316LM (MIG 316LSi)

Use for Solid wire for 316-type austenitic stainless fabrication.

Shielding Ar/CO_2 or Ar/O_2



EN ISO 14343-A 19 12 3 LSi
AWS A5.9 ER316LSi

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

UGIWELD 309LMo (MIG 309LMo)

Use for Solid Mo-alloyed wire for stainless fabrication and dissimilar joints.

Shielding Ar/CO_2 or Ar/He



EN ISO 14343-A 23 12 2 L
AWS A5.9 ER 309LMo (mod)

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

Choose the pack by diameter

The listed spool and drum choices are specific to the diameter shown. Quote the full UGIWELD grade, diameter and pack when enquiring.

DUPLEX STAINLESS STEEL

Duplex & Superduplex Solid Wire

Solid stainless wires for duplex and superduplex grades, supplied through NST.

UGIWELD 45N (MIG Duplex 2209)

Use for Solid wire for 2205-type and compatible lean duplex stainless.

Shielding Ar/CO_2, see datasheet



EN ISO 14343-A 22 9 2 N L
AWS A5.9 ER2209

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

UGIWELD 25.9.4 (MIG SuperDuplex)

Use for Solid wire for 2507-type and comparable superduplex stainless steels.

Shielding See datasheet



EN ISO 14343-A 25 9 4 N L
AWS A5.9 ER2594

Ø mm	Pack	NST article
0.8	5 or 15 kg spool / 250 kg drum	**Enquire**
1.0	5 or 15 kg spool / 250 kg drum	**Enquire**
1.2	5 or 15 kg spool / 250 kg drum	**Enquire**
1.6	15 kg spool / 250 kg drum	**Enquire**

Technical datasheet

Exaton 25.10.4.L

Use for Solid wire for SAF 2507 and other superduplex stainless steels.

Shielding See datasheet



EN ISO 14343: 25 9 4 N L
AWS A5.9 ER2594

Ø mm	Pack	NST article
0.8	5 kg spool	**7840905**
0.8	15 kg spool	**7840910**
1.0	5 kg spool	**7840915**
1.0	15 kg spool	**7840920**
1.2	15 kg spool	**7840930**
1.6	15 kg spool	**7840950**

Technical datasheet

Identify the parent grade

Use the exact grade designation in the procedure. NST's solid 2209 wire is on page 10 and its duplex flux-cored wires are on page 9.

Contents

ALUMINIUM

Solid MIG Wire for Aluminium

MIG WELD aluminium wire in AlSi5, AlMg5 and AlMg4.5Mn grades.

MIG WELD ML4043

Use for AlSi5 wire for compatible aluminium alloys where solidification cracking is a concern.



MIG WELD ML4043

Shielding I1 / I2 / I3

EN ISO 18273 S Al 4043 (AlSi5 (A))
AWS A 5-10 ER 4043

Ø mm	Pack	NST article
1.2	7 kg	**73111**
1.6	6 kg	**73112**

Technical datasheet

MIG WELD ML5356

Use for AlMg5 wire for compatible aluminium fabrication where anodised colour match is required.



MIG WELD ML5356

Shielding I1 / I2 / I3

EN ISO 18273: S Al 5356 (AlMg5MnCr)
AWS A 5-10: ER 5356

Ø mm	Pack	NST article
1.0	2 kg spool	**71210**
1.2	2 kg spool	**71212**
1.2	6 kg spool	**72112**

Technical datasheet

MIG WELD ML5183

Use for AlMg4.5Mn wire for compatible aluminium alloys in marine fabrication.



MIG WELD ML5183

Shielding I1 / I2 / I3

EN ISO 18273: S Al 5183 (AlMg4,5Mn0,7)
AWS A 5-10: ER 5183

Ø mm	Pack	NST article
1.2	2 kg spool	**71112**
1.2	6 kg spool	**72012**
1.6	6 kg spool	**72016**

Technical datasheet

Select by parent alloy and finish

Check the aluminium grade, service conditions and any anodised finish requirement. Quote the exact wire grade and diameter. NST lists other aluminium wire sizes and packs on request.

NICKEL ALLOYS & CAST IRON

Nickel Alloy & Cast Iron Wire

Wire for corrosion-resistant alloy joints, cladding and cast-iron repair.

NST MIG ERNiCrMo-3 (625)



Use for Alloy 625 and 6Mo materials, dissimilar joints and corrosion-resistant cladding.

Shielding Ar/He, see datasheet

EN ISO 18274: 2011 NiCr22Mo9Nb
AWS A5.14/A5.14M: 2011 ERNiCrMo-3

Ø mm	Pack	NST article
1.0	15 kg D300	**12610110**
1.0	250 kg drum	**7541510**
1.14	15 kg D300	**12610114**
1.14	250 kg drum	**7541515**
1.2	15 kg D300	**12610120**
1.2	250 kg drum	**7541512**

Technical datasheet

Lastifil 900



Use for Nickel wire for nickel alloys, specified dissimilar joints and machinable cast-iron repairs.

Shielding Ar + 2% CO_2

AWS A5.14 : ER Ni-1 (UNS N02061)

Ø mm	Pack	NST article
1.2	15 kg spool	**9900.12**

Technical datasheet

Lastifil 41



Use for Solid nickel-iron wire for cast iron, ductile iron and joints between cast iron and steel.

Shielding Ar + 2% CO_2

EN ISO 1071 : S C NiFe-1

Ø mm	Pack	NST article
1.2	15 kg spool	**941.12**

Technical datasheet

Lastifil 41G



Use for Cored wire for rebuilding grey or nodular cast iron and joining cast iron to steel.

Shielding M21 or M13

EN ISO 1071 (T C NiFe T3-Cl)

Ø mm	Pack	NST article
1.2	15 kg spool	**4112**

Technical datasheet

Identify the material before ordering

Give us the parent material, joint type and service conditions. For cast iron, confirm the grade and repair procedure before selecting a nickel or nickel-iron wire.

SPECIALIST STEEL WIRES

Repair & Hardfacing Wire

Specialist Lastifil wire for hardfacing, repair and joining difficult steels.

Lastifil 236TM



Use for Metal-cored hardfacing for components exposed to abrasion and heavy impact, such as bucket teeth.

Shielding M21

EN ISO 14700 (T Z Fe2)

Ø mm	Pack	NST article
1.2	16 kg spool	**9236.TM12**
1.6	16 kg spool	**9236.TM16**

Technical datasheet

Lastifil 10015



Use for Solid wire for joining high-strength low-alloy and fine-grain steels, including TMCP grades.

Shielding M21 or C1

EN ISO 16834-A (G 69 2 M21 Mn3Ni1CrMo)
AWS A5.28 ER110S-G

Ø mm	Pack	NST article
1.0	15 kg spool	**91001510**
1.2	15 kg spool	**91001512**

Technical datasheet

Lastifil 807



Use for Solid wire for difficult-to-weld steels and tough buffer layers beneath hardfacing.

Shielding M12 or M13

EN ISO 14343-A (G 18 8 Mn)
AWS A5.9 (ER307Si)

Ø mm	Pack	NST article
1.2	15 kg spool	**9807.12**
1.6	15 kg spool	**9807.16**

Technical datasheet

Lastifil 8071



Use for Cored wire for impact-loaded rebuilds and buffer layers. The maker permits optional M13 gas.

Shielding Self-shielded or M13

EN 14700: T Fe 9

Ø mm	Pack	NST article
1.2	15 kg spool	**8071.12**

Technical datasheet

Check the deposit and shielding

For surfacing, match the deposit to the wear mechanism and the part material. Lastifil 8071 is self-shielded and its technical sheet also permits M13 gas where required.