### Creep resistant steel

<table>
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<tr>
<th>EN ISO</th>
<th>AWS A5.36 / SFA-5.36</th>
<th>Product name</th>
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<th>Article numbers – packaging type – dimension</th>
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<td>EN ISO 17634-A: T ZCrMo9VNb P M21 1 H5</td>
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<td>FOXcore C 9 MV RC</td>
<td>BÖHLER C 9 MV Ti-FD</td>
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### Pipe steel

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<td>EN ISO 17632-A: T50 6 Ni P M21 1 H5</td>
<td>E81T1-M21A8-N11-H4</td>
<td>FOXcore X60 RC-Pipe</td>
<td>BÖHLER Ti 60-FD</td>
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</table>
### SOLID WIRES & RODS

#### EN ISO 14343-A | AWS A5.9 | Product name | Previous product name
| Article numbers – packaging type – dimension |
| Wire basket spool BS300-BLUE 15 kg | BASEdrum 250 |

#### Duplex solid wires

| 22 9 3 N L | ER2209 | Thermanit 22/09 | Avesta 2205 BÖHLER CN 22/9 N-IG |
| Article numbers – packaging type – dimension |
| 0.8 | 0.9 | 1.0 | 1.2 | 1.0 | 1.2 |
| 53339 | 18100 | 17930 | 66298 | 66289 |

| 23 9 3 N L | ER2209 | Thermanit 22/09 Si | Avesta 2205 Si |
| Article numbers – packaging type – dimension |
| 0.8 | 0.9 | 1.0 | 1.2 | 1.0 | 1.2 |
| 66280 | 66284 | 66281 |

| 23 7 N L | ER2307 | Thermanit 23/07 | Avesta 2304 Avesta LDX 2101 |
| Article numbers – packaging type – dimension |
| 0.8 | 1.0 | 1.2 |
| 64293 | 64229 | 64189 |

| 25 9 4 N L | ER2594 | Thermanit 25/09 | Avesta 2507/P100 |
| Article numbers – packaging type – dimension |
| 0.8 | 1.0 | 1.2 |
| 66259 | 66259 | 66277 |

| 25 9 4 N L | ER2594 | Thermanit 25/09 CuT | Avesta 2507/P100 Cu/W BÖHLER CN 25/9 CuT-IG |
| Article numbers – packaging type – dimension |
| 0.8 | 1.0 | 1.2 |
| 17582 | 80545 |

#### EN ISO 14343-A | AWS A5.9 | Product name | Previous product name
| Article numbers – packaging type – dimension |
| Box 20 kg (4 x 5 kg) |

#### Duplex TIG rods

| 22 9 3 N L | ER2209 | Thermanit 22/09 | Avesta 2205 BÖHLER CN 22/9 N-IG |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 83733 | 80455 | 80457 | 80458 |

| 23 7 N L | ER2307 | Thermanit 23/07 | Avesta 2304 Avesta LDX 2101 |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 64732 | 64303 | 64221 | 64098 |

| 25 9 4 N L | ER2594 | Thermanit 25/09 | Avesta 2507/P100 |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 64778 | 64784 | 64796 | 64977 |

| 25 9 4 N L | ER2594 | Thermanit 25/09 CuT | Avesta 2507/P100 Cu/W BÖHLER CN 25/9 CuT-IG |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 67456 | 66679 | 65031 | 66681 |

#### Nickel alloy solid wires

| Ni 6059 (NiCr23Mo16) | ERNiCrMo-13 | Thermanit Nimo C 24 | Avesta P16 |
| Article numbers – packaging type – dimension |
| 0.8 | 1.0 | 1.2 | 1.6 |
| 69740 | 69741 | 69742 | 65271 |

| Ni 6082 (NiCr20Mn3Nb) | ERNiCr-3 | Thermanit Nicro 82 BÖHLER NiCr 70 Nb-IG A |
| Article numbers – packaging type – dimension |
| 0.8 | 1.0 | 1.2 | 1.6 |
| 53197 | 69736 | 69738 | 69739 | 65272 | 65293 | 70209 |

#### Nickel alloy TIG rods

| Ni 6625 (NiCr22Mo9Nb) | ERNiCrMo-3 | Thermanit 625 |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 79470 | 85717 | 80432 | 80407 | 80534 |

| Ni 6059 (NiCr23Mo16) | ERNiCrMo-13 | Thermanit Nimo C 24 Avesta P16 | BÖHLER NiCr 70 Nb-IG A |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 83689 | 68211 | 66735 | 66736 | 66656 |

| Ni 6082 (NiCr20Mn3Nb) | ERNiCr-3 | Thermanit Nicro 82 BÖHLER NiCr 70 Nb-IG A |
| Article numbers – packaging type – dimension |
| 1.6 x 1000 | 2.0 x 1000 | 2.4 x 1000 | 3.2 x 1000 |
| 85553 | 85486 | 80499 | 82824 | 83705 |

#### Soft-martensitic solid wires

| 16 5 1 | ER410NiMo(mod.) | Thermanit 16/05 Mo AVESTA 2485V |
| Article numbers – packaging type – dimension |
| 1.2 |
| 60932 |

| 13 4 | ER410NiMo(mod.) | Thermanit 13/04 Si BÖHLER CN 13/4-IG |
| Article numbers – packaging type – dimension |
| 1.2 |
| 13410 |

| 9 13 | ER410NiMo(mod.) | Thermanit 14 K Si BÖHLER KW 10-IG |
| Article numbers – packaging type – dimension |
| 1.2 |
| 17901 |

#### Soft-martensitic TIG rods

| 13 4 | ER410NiMo(mod.) | Thermanit 13/04 Si BÖHLER CN 13/4-IG |
| Article numbers – packaging type – dimension |
| 2.0 x 1000 | 2.4 x 1000 |
| 13327 | 68609 |
## STAINLESS SAW – WIRES

### Martensitic + ferritic stainless steels

<table>
<thead>
<tr>
<th>EN-ISO 14343-A / 18274</th>
<th>AWS A5.9 / 5.14</th>
<th>Product name</th>
<th>Previous product name</th>
<th>Article numbers – packaging type – dimension</th>
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<td>Wire basket rim B415 25 kg</td>
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<td>ER410NiMo(mod.)</td>
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<td>BÖHLER CN 13/4-UP</td>
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<td>S 16 5 T</td>
<td>Theramanit 16/05 Mo</td>
<td>Avesta 248 SV</td>
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<td>S Z 17 Mo H</td>
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<td>Theramanit 1720</td>
<td>BÖHLER SKWAM-UP</td>
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### Austenitic stainless steels

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<th>AWS A5.9 / 5.14</th>
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<th>Article numbers – packaging type – dimension</th>
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<td>Wire basket rim B415 25 kg</td>
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<tr>
<td>S 19 9 L</td>
<td>ER308L</td>
<td>Theramanit JE-308L</td>
<td>Avesta 308L/MVR BÖHLER EAS 2-UP</td>
<td>66479</td>
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<td>S 19 9 L</td>
<td>ER308L</td>
<td>Theramanit JE-308L Cryo</td>
<td>Avesta 248 SV</td>
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<td>S 19 12 3 L</td>
<td>ER316L</td>
<td>Theramanit GE-316L</td>
<td>Avesta 316L/SKR BÖHLER EAS 4-M-UP</td>
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<td>S 19 13 4 L</td>
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<td>Theramanit 317L</td>
<td>Avesta 317L/SNR BÖHLER ASN 5 SY-UP</td>
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<td>S 19 9 Nb</td>
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<td>Avesta 347/MVNb BÖHLER SAS 2-UP</td>
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<td>S 19 12 3 Nb</td>
<td>ER318</td>
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<td>Theramanit 17/15 TT</td>
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<td>ER316LN</td>
<td>Theramanit 19/15</td>
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<td>S 25 22 2 N L</td>
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### Duplex stainless steels

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<th>Article numbers – packaging type – dimension</th>
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<td>S 22 9 3 N L</td>
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<td>Avesta 2205 BÖHLER CN 22/9 N-UP</td>
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### STAINLESS SAW – WIRES

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<td>Wire basket rim SA W 15 25 kg SAWdrum 350 kg - ACL Large wooden spool S760 W 300 kg</td>
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<td>Special austenitic wires for dissimilar and overlay welding</td>
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### Heat resistant stainless steels

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<td>Wire basket rim SA W 15 25 kg</td>
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### Nickel-base

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<td>Wire basket rim SA W 15 25 kg SAWdrum 350 kg - ACL</td>
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### STAINLESS SAW – FLUXES

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<th>Global promoted portfolio</th>
<th>Previous product name</th>
<th>Grain size (mm)</th>
<th>DRYsystem 25 kg bags</th>
<th>Metal bucket 30 kg</th>
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<td>Avesta Flux 801</td>
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<td>S F C 2 DC</td>
<td>1.3 / -</td>
<td>Marathon 213</td>
<td>1.6</td>
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<td>S A AF 2 DC</td>
<td>2.0 / 2.2</td>
<td>Marathon 805</td>
<td>Avesta Flux 805</td>
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<td>S A FB 2 DC</td>
<td>2.2 / 2.4</td>
<td>Marathon 431</td>
<td>BÖHLER BB 202</td>
<td>1.4</td>
<td>(13316)*</td>
<td>(30595)*</td>
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<td>Avesta Flux 807</td>
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* => please consider/propose to switch towards grain size 1.6 mm
**FLUX-CORE BECOMES FOXCORE – MATCHLESS IN STAINLESS**

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* only available on 15 kg | $/kg plus VAT ** Skg high-quality plastic spools

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Lasting Connections

voestalpine Böhler Welding
www.voestalpine.com/welding
# SAW diamondspark S Wires

<table>
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<tr>
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<th>AWS A5.36 / SFA-5.36</th>
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## Mild Steel

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## Low-alloyed high strength

| T2Ni1Cu | ECG | diamondspark S NiCu1 | SUBARC TNiCu1 | 38850 | 38836 | 38837 |
| T2Ni1Mo | ECNi5 | diamondspark S 550 HP |                      | 60249 | 60248 | 64771 |
| TZ      | ECF5 | diamondspark S 700 HP | SUBARC T80 HP      | 38919 | 38924 | 38928 | 55241 | 55240 | 55243 |
| TZ      | ECF5 | diamondspark S 770 | SUBARC T85         | 85602 | 85601 | 85701 |
| T2Ni2.5CrMoMn1.9 | ECG | diamondspark S 900 HP | SUBARC T95 HP      | 56626 | 56627 |       |        |        | 47375 |

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Lasting Connections

voestalpine Böhler Welding

www.voestalpine.com/welding
### Unalloyed steels

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<th>AWS A5.36 / SFA-5.36</th>
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### Atmospheric corrosion steels

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### Low temperature steels

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**Article numbers – packaging type – dimension**

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**Website:**[www.voestalpine.com/welding](http://www.voestalpine.com/welding)
<table>
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### High tensile steels

| T56 6 1NiMo M M21 1 H5 | E91T15-M21A8-K1-H4 | diamondspark 550 HC | diamondspark 620 HC | BÖHLER HL 65 T-MC | 82551 | 62027 | 62049 | 62028 | 81895 |
| T62 4 Z M M21 1 H5 | E101T15-M21A4-G-H4 | diamondspark 550 BC | diamondspark 620 MC | BÖHLER HL 75 T-MC | 50024 | 82420 | 62045 | 62046 |
| T55 4 1NiMo B M21 3 H5 | E90T5-M21A4-G-H4 | diamondspark 550 BC | diamondspark 620 BC | BÖHLER Kb 65 T-FD | 82547 | 62023 |
| T66 6 Mn2NiCrMo B M21 3 H5 | E101T5-M21A8-K4-H4 | diamondspark 700 BC | diamondspark 700 BC | BÖHLER Kb 65 T-FD | 82546 | 62021 | 62022 |
| T94 4 Mn2NiCrMo B M21 3 H5 | E130TS-GM-H4 | diamondspark 900 BC | diamondspark 900 BC | BÖHLER Kb 90 T-FD | 82553 | 62024 | 62014 |
| T62 4 Mn1.5Ni P M21 1 H5 | E101T1-M21A4-K2-H4 | diamondspark 620 RC | diamondspark 620 RC | BÖHLER Ti 75 T-FD | 81918 | 82549 | 62036 |
| T66 6 Z P M21 1 H5 | E111T-M21A8-G-H4 | diamondspark 700 RC | diamondspark 700 RC | BÖHLER Ti 80 T-FD | 81865 | 82543 | 82544 | 45311 |
| T66 6 Mn2NiCrMo M M21 1 H5 | E101T5-M21A8-K4-H4 | diamondspark 700 MC | diamondspark 700 MC | BÖHLER X70 L-MC | 34863 | 34875 | 34894 | 34864 | 34885 | 34896 |
| T95 9 ZCr2NiCrMo M M21 1 H5 | E131T-M21A8-K4-H4 | diamondspark 900 MC | diamondspark 900 MC | BÖHLER X90 L-MC | 42461 | 34946 |
| T89 4 ZCr2NiCrMo M M21 1 H5 | E111T1-M21A8-G-H4 | diamondspark 960 MC | diamondspark 960 MC | BÖHLER X96 L-MC | 42465 | 34954 |

### Pipe steels

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</table>

### Creep resistant steels

| EN ISO 17634-AT CM602 B M21 3 H5 | E90T5-M21PY-B3-H4 | diamondspark CM 2 BC | diamondspark CM 2 BC | BÖHLER CM 2 Kd T-FD | 84299 | 62041 |
| EN ISO 17634-A: T CM602 P M21 1 H5 | E91T1-M21PY-B3-H4 | diamondspark CM 2 RC | diamondspark CM 2 RC | BÖHLER CM 2 Ti T-FD | 46912 | 84023 |
| EN ISO 17634-A: T CM602 M M21 1 H5 | E91T5-M21PY-B3-H4 | diamondspark CM 2 MC | diamondspark CM 2 MC | BÖHLER CM 2 T-MC | 84298 | 62033 | 62007 |
| EN ISO 17634-A: T CM605 M M21 3 H5 | E80T5-M21PY-B6-H4 | diamondspark CM 5 BC | diamondspark CM 5 BC | BÖHLER CM 5 Kd T-FD | 62042 |
| EN ISO 17634-A: T CM601 M M21 1 H5 | E811T5-M21PY-B2-H4 | diamondspark DCM5 MC | diamondspark DCM5 MC | BÖHLER DCM5 T-MC | 81903 | 84295 | 62032 | 62008 |
| EN ISO 17634-A: T Z P M21 1 H5 | E91T1-M21PY-GH4 | diamondspark DCMH BC | diamondspark DCMH BC | BÖHLER DCMH Ti T-FD | 62015 | 27947 |