

SELECTARC ESSENTIALS

FOR WELDING PROFESSIONALS

EXPORT



Selectarc[®]

Electrodes: Un-alloyed, low alloyed,
high-alloyed steel, cast iron, nickel
alloys, TIG (GTAW) & MIG (GMAW)
wires, brazing alloys and fluxes...

and much more on
www.fsh-welding.com



**SOLUTIONS PROVIDER
OF WELDING AND BRAZING
SPECIALTIES**

French industrial group specialized in the manufacture and marketing of innovative welding and brazing consumables (brazing alloys, electrodes for arc welding, TIG & MIG wires, flux cored wires and fluxes).

With three production facilities in France, its own distribution network across all continents and with over two hundred years' experience, FSH Welding Group offers one of the broadest ranges of consumables and welding services for all types of applications (energy, transportation, petrochemicals, HVAC, M&R...) under the brand SELECTARC®.



Innovation
Quality **Responsiveness**
Flexibility
Customization ...



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www.fsh-welding.com

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* Note: "Inconel ®" is a registered trade name of Inco Companies.

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Alloys : ■ Un-alloyed steel, ■ High-alloyed steel, ■ Nickel alloys, ■ Cast iron, ■ Hardfacing, ■ Aluminium alloys, ■ Copper-Phosphorus, ■ Silver brazing alloys.

VIEW OUR FULL RANGE ON
WWW.FSH-WELDING.COM

For more information, see our technical data sheets at:
www.fsh-welding.com/en/datasheets.htm

ELECTRODES



CHOICE

WHICH APPLICATION ?	WHICH ELECTRODE ?	SPECIAL FEATURE
CARBON STEEL WELDING	51	■ <i>Universal</i>
	B7016Sp	■ <i>Special for repairing</i>
	B58	■ <i>Enhanced mechanical properties</i>
DIFFICULT-TO-WELD STEEL WELDING	29/9	■ <i>Multi-purpose high security</i>
	B90	■ <i>Extreme cases</i>
STAINLESS STEEL WELDING	20/10 BC	■ <i>304L</i>
	20/10 MBC	■ <i>316L</i>
DISSIMILAR WELDING	24/12S	■ <i>Assembly cast iron/steel</i>
	29/9	■ <i>Repairing</i>
	18/8Mn	■ <i>Stainless for repairing & surfacing</i>
CAST IRON WELDING	Fonte Ni	■ <i>Lamellar cast iron</i>
	Ferro Ni	■ <i>Cast iron/stainless steel and nodular cast iron</i>
HARDFACING	HB63	■ <i>Mineral abrasion - 63HRC</i>
	HB61B	■ <i>Universal - 60HRC</i>

BRAZING



CHOICE

WHICH APPLICATION ?	WHICH BRAZING ALLOY ?	SPECIAL FEATURE
COPPER BRAZING	PHOSBRAZ M73	■ <i>Plumbing / Heating</i>
GAS SYSTEMS	PHOSBRAZ AG60	■ <i>Gas Systems</i>
ALL METALS TO BE JOINED	BRAZARGENT 5034	■ <i>All applications</i>

RUTILE / BASIC ELECTRODES



SELECTARC 51

- ★ Universal
- ★ Exceptional welder appeal

SELECTARC B7016Sp

- ★ Double coated basic
- ★ Exceptional welder appeal

SELECTARC B58

- ★ Universal basic high performance
- ★ Enhanced operator appeal

■ SELECTARC 51

All position rutile electrode providing an exceptional welder appeal. Good weld bead appearance. Easy slag removal.

■ **Weldable steel range:**
General purpose construction steels.

MAIN APPLICATIONS

- ★ Sheet metal, piping, metal works, tanks...

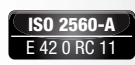
Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
51022 S12	2.0	300	374	4	4
51003 S12	2.5	350	281	5	4
51033 S12	3.2	350	172	5	4
51043 S12	4.0	350	114	5	4

Product also available in PE cases: 1 kg and PR cases: ~ 300 gr.



⊕ PRODUCT ADVANTAGES:

- Universal all positions
- Exceptional operator appeal
- Smooth and stable arc
- Self-releasing slag



■ SELECTARC B7016Sp

Basic double coated electrode presenting exceptional welding characteristics. Enhanced mechanical properties.

■ Weldable steel range:

Construction steel for general use, ship steel, various steel for boiler and pressure vessels, high strength steel, heat resisting steel, cold tough steel...

MAIN APPLICATIONS

★ Frames, heavy supports, shipbuilding, pressure vessels and all repair works...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
80903 S12	2.5	350	250	5	4
80933 S12	3.2	350	152	5	4
80944 S12	4.0	450	92	6	4

Product also available in PE cases: 1 kg.

**BASIC,
SPECIAL FOR
REPAIRING**

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- Excellent welder appeal
- High resistance to cracking
- Easy slag removal

AWS 5.1
E7016

ISO 2560-A
E 38 2 B 12 H10

=+ ~70 V



■ SELECTARC B58

Universal basic electrode for welding highly stressed connections, for use at operational temperatures between -40°C and +400°C. Excellent resilience. Excellent operator appeal.

■ Weldable steel range:

Construction steel for general use, ship steel, steel for boiler and pressure vessels, high strength steel, heat resisting steel, cold tough steel...

MAIN APPLICATIONS

★ Pressure vessels, piping, ship building...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
81403 S12	2.5	350	250	5	4
81433 S12	3.2	350	156	5	4
81444 S12	4.0	450	97	6.5	4

**UNIVERSAL
BASIC 7018**

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- Very good operator appeal
- Easy striking and re-striking
- Easy slag removal
- Great mechanical properties and high resistance to cracking

AWS 5.1
E7018

ISO 2560-A
E 42 4 B 32 H5

=+ ~65 V



STAINLESS STEEL ELECTRODES

■ SELECTARC 20/10 BC

Rutile-basic 308L electrode for welding of 18/8 austenitic stainless steels. Ease of use. Excellent bead appearance. Easy slag removal.

- **Weldable steel range:**
18/8 type stainless steels (304L).

MAIN APPLICATIONS

★ Tubes and tanks in the chemical and petrochemical industries...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
13102 S12	2.5	300	215	4	4
13133 S12	3.2	350	143	5	4
13143 S12	4.0	350	94	5	4

STAINLESS
STEEL TYPE
304L

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- Low carbon stainless steel
- Coating with very low moisture pick up
- Exceptional operator appeal
- Smooth welding and spatter-free

AWS 5.4
E308L-16

ISO 3581-A
E 19.9 LR 32

=+ ~70V



SELECTARC 20/10 MBC

Rutile-basic 316L electrode used for welding of 18/8/3 austenitic stainless steels and clad steels. Excellent corrosion resistance. Smooth welding. Easy slag removal.

Weldable steel range:

18/8/3 type stainless steels (316L) and similar grades.

MAIN APPLICATIONS

★ Chemical and petrochemical industries, ship building, tanks, pipes, heat exchangers, food industry...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
12003 S12	2.5	350	230	5	4
12033 S12	3.2	350	139	5	4
12043 S12	4.0	350	93	5	4

Product also available in PE cases: 1 kg and PR: ~ 300 gr.

STAINLESS
STEEL TYPE
316L

Selectarc
WELDING

PRODUCT ADVANTAGES:

- Low carbon universal stainless steel
- Excellent corrosion resistance
- Exceptional operator appeal
- Coating with very low moisture pick up

AWS 5.4
E316L-16

ISO 3581-A
E 19 12 3 R 32

= + ~ 70 V



SELECTARC 24/12S

309L type electrode used for welding similar stainless steels grades and dissimilar assemblies. Great bead appearance. Self-releasing slag.

Weldable steel range:

24/12 type stainless steels (309L), heat-resistant steel, dissimilar welding steel/stainless steel with difficult-to-weld steels.

MAIN APPLICATIONS

★ Chemical and petrochemical industries, ship building and all maintenance works...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
13502 S12	2.5	300	217	4	4
13533 S12	3.2	350	143	5	4
13543 S12	4.0	350	96	5	4

STAINLESS
STEEL TYPE
309L

Selectarc
WELDING

PRODUCT ADVANTAGES:

- Weld dissimilar grades
- Difficult-to-weld steels
- Smooth welding spatter-free
- Self-releasing slag

AWS 5.4
E309L-16

ISO 3581-A
E 23 12 LR 32

= + ~ 70 V



■ SELECTARC 29/9

Rutile-basic electrode with an enhanced mechanical characteristic stainless steel deposit. Highly resistant to cracking. Welding of low-alloyed and high alloyed steels. It is a multi-purpose electrode for high security repairs.

■ Weldable steel range:

Carbon steel, galvanized steel, stainless steel, tool steel, manganese steel...

MAIN APPLICATIONS

★ Repairing and maintenance on dissimilar, difficult-to-weld or unknown steels, suitable for buffer layers before hardfacing, building up piston rods, gears...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
16122 S12	2.0	300	339	4	4
16103 S12	2.5	300	216	4	4
16133 S12	3.2	350	147	5	4
16143 S12	4.0	350	96	5	4

Product also available in PE cases: 1 kg and PR: ~ 300 gr.

UNIVERSAL FOR
MAINTENANCE
AND REPAIRS

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- This product is ideally universal
- High resistance
- Stainless deposit
- Uniformed weld beads

AWS 5.4

~E312-16

ISO 3581-A

E 29 9 R 32

⊕ ~ 50 V



■ SELECTARC 18/8Mn

Rutile-basic electrode with high recovery.

Fully austenitic stainless steel deposit with a high Mn-content. Welding dissimilar assemblies, difficult-to-weld materials and buffer layers before hardfacing.

■ Weldable steel range:

Repairing and maintenance on railways, on earth moving equipment: excavators buckets, jaw crusher, public works, cement, armour plates...

MAIN APPLICATIONS

★ Repairing and maintenance on railways, on earth moving equipment, on quarries and on dissimilar, difficult-to-weld or unknown steels, suitable for buffer layers before hardfacing, building up piston rods, gears.

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
10703 S12	2.5	350	130	4.5	4
10733 S12	3.2	350	100	5	4
10744 S12	4.0	450	61	6.5	4

STAINLESS FOR
REPAIRING AND
SURFACING

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- Very good operator appeal
- Smooth welding low spatter
- Regular weld beads
- Self-releasing slag

AWS 5.4

~E307-26

ISO 3581-A

E 18 8 Mn R 73 X

⊕ ~ 50 V



NICKEL ALLOYS / CAST IRON ELECTRODES

SELECTARC B90

Inconel 600* type basic electrode, used for repairing and joining high nickel percentage alloys and difficult-to-weld steels. Excellent resistance to cracking down to -196°C . Refractory deposit (1400°C). 140% recovery.

Weldable steel range:

Alloyed steel, hard-to-weld steel (high C.E.), tool steel, heat resistant steel, dissimilar assemblies, nickel alloyed steel...

MAIN APPLICATIONS

★ Oven parts, burners, heat treatment tanks and equipment, cement works (kilns and balls coating), moulds, strip tanks, transport and storage of liquid gas. Chemical and petrochemical industries, glassworks, civil engineering, repair and maintenance workshops.

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
49003 S12	2.5	350	185	5	4
49033 S12	3.2	350	102	5	4
49043 S12	4.0	350	72	5	4

Product also available in PE cases: 1 kg.

«INCONEL 600*» TYPE
REPAIRING
AND JOINING

Selectarc
WELDING

PRODUCT ADVANTAGES:

- Repairing all kind of steels (extreme cases)
- Exceptionally high mechanical properties (hot and cold)
- Insensitive to heat treatments
- All-position electrode

AWS 5.11
ENiCrFe-3

ISO 14172
E-Ni 6182 (NiCr15Fe6Mn)

≈ + ~ 60 V



*Note: "Inconel" is a registered trade name of Inco Companies.

■ SELECTARC Fonte Ni

Graphite electrode with high percentage of nickel, for cold repairing of different grades of cast iron.

■ Weldable steel range:

All grey lamellar cast irons.

N.B. Lamellar cast iron welding requires a maximum temperature of 70°C between runs - See Technical Data Sheet.

MAIN APPLICATIONS

★ Repairing of engine blocks, frames of tool machines, gearboxes, reducing gears, valve and pump bodies, cast parts.

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
04003 S12	2.5	350	237	5	4
04033 S12	3.2	350	143	5	4
04043 S12	4.0	350	96	5	4

Product also available in PE cases: 1 kg.

GREY CAST IRON
REPAIRING

Selectarc
WELDING

+ PRODUCT ADVANTAGES:

- Excellent all-position weldability, without preheating
- Homogeneous and easy to machine deposit
- Great deposit extension for lamellar cast iron
- Ideal for repairing old cast iron

AWS 5.15
ENI-CI

ISO 1071
E C Ni-CI 3

= + ~ 40 V



■ SELECTARC Ferro Ni

Ferro-Nickel graphite electrode for joining nodular cast iron and dissimilar assemblies of grey cast iron on steel. Suitable for buffer layers before repairing of contaminated cast iron.

■ Weldable steel range:

Grey cast iron, dissimilar welds grey cast iron/steel.

MAIN APPLICATIONS

★ Defects in foundries, repairing of engine blocks, frames of tool machines, gearboxes, reducing gears, valve and pump bodies, cast parts...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
05003 S12	2.5	350	248	5	4
05033 S12	3.2	350	156	5	4
05043 S12	4.0	350	100	5	4

Product available in PE cases: 1 kg and PR: ~ 300 gr.

WELDING NODULAR
CAST IRON AND
CAST IRON/STEEL

Selectarc
WELDING

+ PRODUCT ADVANTAGES:

- Enhanced mechanical properties
- Dissimilar assemblies
- Graphite coating
- Excellent all-position weldability, without preheating

AWS 5.15
ENiFe-CI

ISO 1071
E C NiFe-CI 3

= + ~ 40 V



HARDFACING ELECTRODES

■ SELECTARC HB63

High recovery electrode 160% for hardfacing carbide deposit, resilient to abrasive wear by hard particles and impact. Enhanced hardness (63 HRC before dilution). Only machinable by grinding. Surfacing in 1-2 or eventual 3 layers.

■ Weldable steel range:

Low alloyed steel, high alloyed steel, wear plates.

MAIN APPLICATIONS

★ For civil engineering, excavating and crashing equipment, pump bodies for abrasive materials, excavator teeth, concrete pumps, ores crushing, brick press, armour plates, agricultural equipment...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
62103 S12	2.5	350	159	5	4
62133 S12	3.2	350	94	5	4
62144 S12	4.0	450	57	6	4

Product available in PE cases: 1 kg.

**HARDFACING
MINERAL-WEAR**

Selectarc
WELDING

+ PRODUCT ADVANTAGES:

- Very good abrasion-impact compromise
- High resistance to mineral abrasion
- High recovery 160%
- Very good bead appearance

DIN 8555
E10-UM-60-GRPZ

EN 14700
E Fe14

=+ ~ 50 V



■ SELECTARC HB61B

Basic coated general purpose hardfacing electrode for applications subject to impact and abrasive wear (60HRC). Great resistance to cracking. Smooth welding spatter-free.

■ Weldable steel range:

Low alloyed steel, high alloyed steel, wear plates.

MAIN APPLICATIONS

★ For civil engineering, excavating and crushing equipment, pump bodies for abrasive materials, excavator teeth, concrete pumps, ores crushing, brick press, armour plates, agricultural equipment...

Ref.	Ø (mm)	Length (mm)	Items /case	Kg /case ST	Case /package
61133 S12	3.2	350	152	5	4
61144 S12	4.0	450	96	6.5	4

**HARDFACING
UNIVERSAL**

Selectarc
WELDING

+ PRODUCT ADVANTAGES:

- Universal anti-wear hardfacing
- Very good resistance to impact and mineral wear
- High resistance to metal abrasion
- Crack resistant

DIN 8555
E6-UM-60-S

EN 14700
E Fe8

= + ~ 70 V



TIG/MIG WELDING WIRES

ALUMINIUM ALLOYS

■ SELECTARC ALG5

Aluminium alloys welding wire with 5 % Magnesium. Excellent corrosion resistance. Good mechanical properties.

■ **Weldable steel range:**
AlMg5 and similar grades (5000 series).

MAIN APPLICATIONS

★ Ship building, railway, road transport, aviation.

MIG Ref.	Ø (mm)	Weight (kg) / Spool
73213 13712F	1.0	7 kg metal
73212 13712F	1.2	7 kg metal
73213 83612F	1.0	6 kg plastic
73212 83612F	1.2	6 kg plastic

Available in D200 and D100 spools.

ALUMINIUM
TYPE AL-MG5

Selectarc
WELDING

⊕ PRODUCT ADVANTAGES:

- The wire cleanliness is suitable for radio requirements
- Good wire feeding (MIG)
- No sheath fouling (MIG)

TIG Ref.	Ø (mm)	Kg / Case
73216 50512F	1.6	5
73226 50512F	2.0	5
73206 50512F	2.4	5
73236 50512F	3.2	5

AWS 5.10
ER5356

ISO 18273
S Al 5356 (AlMg5Cr)

STAINLESS STEELS

■ SELECTARC 20/10M (TIG) SELECTARC 20/10MS (MIG)

AUSTENITIC
TYPE 316L

Selectarc
WELDING

Solid welding wire for stabilised stainless steels type 316L. Excellent corrosion resistance.

■ **Weldable steel range:**
316L and similar grades type 304L.

MAIN APPLICATIONS

★ Any type of metal construction not exceeding 400 °C operational. Chemical, petrochemical, food industry...

⊕ PRODUCT ADVANTAGES:

- Low carbon universal stainless steel
- Excellent corrosion resistance
- The wire cleanliness is suitable for radio requirements

SELECTARC 20/10M (TIG)

AWS 5.9
ER316L

ISO 14343-A
W 19 12 3L

TIG Ref.	Ø (mm)	Kg / Case
71316 50512R	1.6	5
71326 50512R	2.0	5
71306 50512R	2.4	5
71336 50512R	3.2	5

SELECTARC 20/10MS (MIG)

AWS 5.9
ER316LSi

ISO 14343-A
G 19 12 3LSi

MIG Ref.	Ø (mm)	Weight (kg) / Spool
71414 14512R	0.8	15 kg metal
71413 14512R	1.0	15 kg metal
71412 14512R	1.2	15 kg metal

Available in D200 and D100 spools.

BRAZING FILLER METALS

■ PHOSBRAZ M73

Copper-phosphorus alloy for hard brazing of red coppers without soldering flux. Excellent fluidity. Great comfort in use.

■ Weldable grades:

Copper, Cuprous alloys (bronze, brass): necessity to use our Phosbraz flux.

MAIN APPLICATIONS

★ Capillary brazing of tubes and connections, water heaters, cooling systems.
Mainly used by plumbers, heating engineers and HVAC technicians.

Ref.	Ø (mm)	Length (mm)	Kg / Case
M73B20500R T20FA	2.0	500	5
M73B30500R T20FA	3.0	500	5

UNIVERSAL
PLUMBING

Selectarc
BRAZING

⊕ PRODUCT ADVANTAGES:

- Excellent fluidity
- Self-fluxing on red coppers (without using flux)
- Non gassed alloy (do not sparkle)

EN ISO 3677
B Cu 93 P 710-785

NF EN 1044
CP 202

NF EN ISO 17672
CuP 181

■ PHOSBRAZ AG60 *

Copper-phosphorus alloy with 6% Ag for hard brazing of red coppers in gas systems. ATG Certified (French Gas Company). Enhanced mechanical properties.

■ Weldable grades:

Copper, Cuprous alloys (bronze, brass) necessity to use our AG-FLUX.



*Also available with ATG certification (French Gas company)

MAIN APPLICATIONS

- ★ Fuel gas systems.

Ref.	Ø (mm)	Length (mm)	Kg /Case
P60B20500R/F T20F	2.0	500	1

GAZ
SYSTEMS

Selectarc
BRAZING

⊕ PRODUCT ADVANTAGES:

- Not sparking alloy
- Excellent resistance to vibration and cold
- Low melting temperature
- ATG Certified in printed rods

EN ISO 3677

B Cu 87 PAg (Ni) 645-725

NF EN ISO 17672

CuP 283a

■ BRAZARGENT 5034

Versatile alloy with 34% silver, suitable for similar and dissimilar welds. Very good soldering properties. Efficient and economical.

■ Weldable grades:

Ferrous alloys, cuprous alloys, nickel alloys, stainless steel and tool steel.

MAIN APPLICATIONS

- ★ Health and food industries, medical flux transport, equipment, plumbing, delicate works...

Ref.	Bare / Flux-coated	Ø (mm)	Length (mm)	Kg /Case
5034B15500N T18FA	Bare	1.5	500	1
5034B20500N T18FA	Bare	2.0	500	1
5034E15500F T19FA	Blue coating	1.5	500	1
5034E20500F T19FA	Blue coating	2.0	500	1

Product also available in 250 gr cases.

ALL DISSIMILAR
WELDS

Selectarc
BRAZING

⊕ PRODUCT ADVANTAGES:

- Good fluidity
- Very good wetting properties
- Great mechanical properties
- Excellent for small gap soldering

EN ISO 3677

B Cu 36 Zn Ag Sn 630-730

NF EN 1044

Ag 106

NF EN ISO 17672

Ag 134

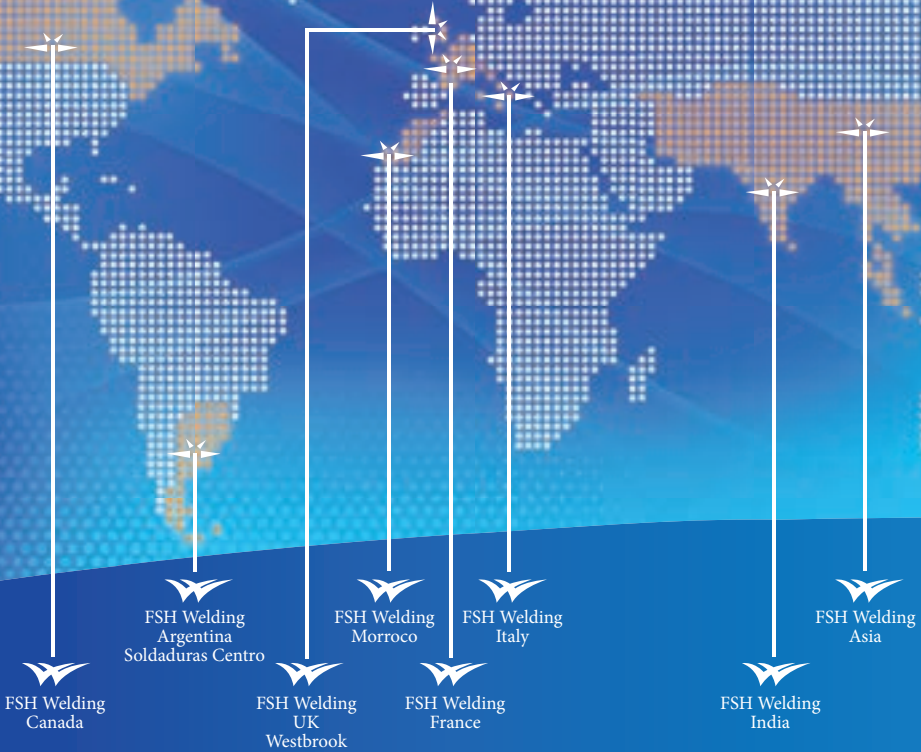
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Our factories of manufacturing in France:



FSHWG: French industrial group specialized in the manufacture and marketing of innovative welding and brazing consumables (brazing alloys, electrodes for arc welding, TIG & MIG wires, flux cored wires and fluxes). With three production facilities in France, a its own distribution network across all continents and experience over two hundred years, FSH Welding Group offers one of the broadest ranges of consumables and welding services for all types of applications (energy, transportation, petrochemicals, HVAC, M & R,...) under the brand Selectarc.



OFFICIAL DISTRIBUTOR

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