

			FCAW						SAW										
Gatunek			-	1.4316	1.4316	1.4316	1.4430	1.4430	-	-	1.4316	1.4430		2.4607	2.4831				
Typ			T 42 6 2Ni B M 2 H5	T 19 9 L R M 3 / T19 9 L R C 3	T 19 9 L P M 2	T 19 9 L M M 2	T 19 12 3 L R C 3	T 19 12 3 L P M 2			SA FB 1 55 AC H5			SA AF 2 DC					
Materiał dodatkowy			OK Tubrod 15.25	Shield-Bright 308L X-H	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-H	Shield-Bright 316L	OK Tubrod 15.31		OK Flux 10.62	OK Autrod 13.27	OK Autrod 13.49	OK Flux 10.93	OK Autrod 308L	OK Autrod 316L	OK Flux 10.90	OK Autrod 19.81	OK Autrod 19.82
Materiał rodzimy																			
Temp. pracy (°C)			-60	-80	-120	-196	-60 (-110)	-120	-60 (-196)										
1.8869	P355QL2	-60	●								●								
1.8864	P460QL2	-60									●	●							
1.8916	S460QL1	-60									●	●							
1.6212	11MnNi5-3	-60	●								●	●							
1.6217	13MnNi6-3	-60	●								●	●							
1.5636	G9Ni10	-70	○								●	●							
1.6228	15NiMn6	-80	○								●	●							
1.5638	G9Ni15	-90	○								○	●							
1.5637	12Ni14	-105	○								○	●							
1.5680	X12Ni5	-120															●	●	
1.5662	X8Ni9	-200															●	●	●
1.5663	X7Ni9	-200															●	●	●
1.5682	X10Ni9	-200															●	●	●
1.4301	X5CrNi18-10	-200		●	●	●	○	○	○					●	○		●	●	●
1.4306	X2CrNi19-11	-270		●	●	●	○	○	○					●	○		●	●	●
1.4311	X2CrNiN18-10	-270		●	●	●	○	○	○					●	○		●	●	●
1.4401	X5CrNiMo17-12-2	-200					●	●	●							●	●	●	●
1.4404	X2CrNiMo17-12-2	-200					●	●	●						●	●	●	●	●
1.4406	X2CrNiMoN17-11-2	-270					●	●	●						●	●	●	●	●
1.4429	X2CrNiMoN17-13-3	-270					●	●	●						●	●	●	●	●
1.4541	X8CrNiTi18-10	-270		●	●	○	○	○						●	○		●	●	●
1.4571	X6CrNiMoTi17-12-2	-270					●	●							●		●	●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne  
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

# Materiały do spawania stali pracujących w niskiej temperaturze ( $\leq -60^{\circ}\text{C}$ )

			FCAW				SAW						
Gatunek			-	1.4316	1.4316	1.4316	1.4316	1.4316	1.4430	1.4430			
Typ			T 42.6 2Ni B M 2 H5	T 19.9 L R M 3 / T 19.9 L R C 3	T 19.9 L P M 2	T 19.9 L M M 2	T 19.12.3 L R M 3 / T 19.12.3 L R C	T 19.12.3 L P M 2	T 19.12.3 L M M 2	T 19.12.3 L M M 2			
Material dodatkowy		Material rodzimy	Temp. pracy ( $^{\circ}\text{C}$ )	OK Tubrod 15.25	Shield-Bright 308L X-H	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-H	Shield-Bright 316L	OK Tubrod 15.31			
				OK Flux 10.62	OK Autrod 13.27	OK Autrod 13.49	OK Flux 10.93	OK Autrod 308L	OK Autrod 316L	OK Flux 10.90	OK Autrod 19.81	OK Autrod 19.82	
				-60	-80	-120	-196	-60 (-110)	-120	-60 (-196)			
1.8869	P355QL2	-60	●										
1.8864	P460QL2	-60											
1.8916	S460QL1	-60											
1.6212	11MnNi5-3	-60	●										
1.6217	13MnNi6-3	-60	●										
1.5636	G9Ni10	-70	○										
1.6228	15NiMn6	-80	○										
1.5638	G9Ni15	-90	○										
1.5637	12Ni14	-105	○										
1.5680	X12Ni5	-120										●	●
1.5662	X8Ni9	-200										●	●
1.5663	X7Ni9	-200										●	●
1.5682	X10Ni9	-200										●	●
1.4301	X5CrNi18-10	-200		●	●	●	○	○	○				
1.4306	X2CrNi19-11	-270		●	●	●	○	○	○				
1.4311	X2CrNiN18-10	-270		●	●	●	○	○	○				
1.4401	X5CrNiMo17-12-2	-200					●	●	●			●	●
1.4404	X2CrNiMo17-12-2	-200					●	●	●			●	●
1.4406	X2CrNiMoN17-11-2	-270					●	●	●			●	●
1.4429	X2CrNiMoN17-13-3	-270					●	●	●			●	●
1.4541	X8CrNiTi18-10	-270		●	●	○	○	○	○			●	●
1.4571	X6CrNiMoTi17-12-2	-270					●	●	●			●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne  
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

