



Materiały do spawania stali nierdzewnych

		MMA																							
		1.4316	1.4316	1.4316	1.4316	1.4551	1.4551	1.4430	1.4430	1.4430	1.4430	1.4430	1.4576	1.4576	1.4370	1.4009	1.4351	1.4351	1.4519	2.4620	2.4621	2.4609			
Gatunek		E 19 L R 1 2	E 19 L R 1 2	E 19 L B 2 2	E 19 N b R 1 2	E 19 N b B 2 2	E 19 12 3 L R 1 1	E 19 12 3 L R 1 2	E 19 12 3 L R 1 2	E 19 12 3 L R 1 1	E 19 12 3 L B 2 2	E 19 12 3 L R 5 3	E 19 12 3 N b R 3 2	E 19 12 3 N b B 4 2	E 18 8 M n B 1 2	E 13 B 4 2	E 13 4 R 3 2	E 13 4 B 4 2 H5	E 16 6 B 4 2 H5	E 20 25 5 C u N L R 3 2	E N i 6182 (N i C r 15 F e 6 M)	E N i 6625 (N i C r 22 M o 9 N)	E N i 6059 (N i C r 23 M o 16)		
Typ		OK 61.20	OK 61.30	OK 61.35	OK 61.80	OK 61.85	OK 63.20	OK 63.30	OK 63.31	OK 63.34	OK 63.35	OK 63.41	OK 63.80	OK 63.85	OK 67.43	OK 68.15	OK 68.17	OK 68.25	OK 68.37	OK 69.33	OK 92.26	OK 92.45	OK 92.59		
Materiał dodatkowy		OK 61.20	OK 61.30	OK 61.35	OK 61.80	OK 61.85	OK 63.20	OK 63.30	OK 63.31	OK 63.34	OK 63.35	OK 63.41	OK 63.80	OK 63.85	OK 67.43	OK 68.15	OK 68.17	OK 68.25	OK 68.37	OK 69.33	OK 92.26	OK 92.45	OK 92.59		
Materiał rodzimy		OK 61.20	OK 61.30	OK 61.35	OK 61.80	OK 61.85	OK 63.20	OK 63.30	OK 63.31	OK 63.34	OK 63.35	OK 63.41	OK 63.80	OK 63.85	OK 67.43	OK 68.15	OK 68.17	OK 68.25	OK 68.37	OK 69.33	OK 92.26	OK 92.45	OK 92.59		
1.4405	GX4CrNiMo16-5-1																				●				
1.4406	X2CrNiMoN17-11-2					●	●	●	●	●	●	●										●			
1.4407	GX5CrNiMo13-4																●	●	○						
1.4408	GX5CrNiMo19-11-2					●	●	●	●	●	●	●	●	●							●				
1.4409	GX2CrNiMo19-11-2							●	●	●	●	●	●	●											
1.4412	GX5CrNiMo19-11-3					●	●	●	●	●	●	●	●	●							●				
1.4413	X4CrNiMo13-4																●	●	○						
1.4414	GX4CrNiMo13-4																●	●	○						
1.4416	GX2NiCrMoN25-20-5																				●		●		
1.4418	X4CrNiMo16-5-1																			●					
1.4421	GX4CrNiMo16-4																			●					
1.4425	X2CrNiMo18-13-3					○	○	○	○	○	○	○	○	○							●				
1.4429	X2CrNiMoN17-13-3						●	●	●	●	●	●	●	●							●		●		
1.4432	X2CrNiMo17-12-3					●	●	●	●	●	●	●	●	●							●		●		
1.4434	X2CrNiMoN18-12-4																				●		●		
1.4435	X2CrNiMo18-14-3					●	●	●	●	●	●	●	●	●							●				
1.4436	X3CrNiMo17-13-3					●	●	●	●	●	●	●	●	●							●				
1.4437	GX6CrNiMo18-12					●	●	●	●	●	●	●	●	●							●				
1.4438	X2CrNiMo18-15-4																				●		○	○	
1.4439	X2CrNiMoN17-13-5																				●		○	○	
1.4446	GX2CrNiMoN17-13-4																				●		○	○	
1.4448	GX6CrNiMo17-13																				●		○	○	
1.4500	GX7NiCrMoCuNb25-20																				●		●	●	
1.4505	X4NiCrMoCuNb20-18-2																				●		●	●	
1.4506	X5NiCrMoCuTi20-18																				●		●	●	
1.4509	X2CrTiNb18	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				
1.4510	X3CrTi17	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				
1.4511	X3CrNb17	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				

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

		MMA																						
Gatunek		1.4316	1.4316	1.4316	1.4551	1.4430	1.4430	1.4430	1.4430	1.4430	1.4430	1.4430	1.4576	1.4576	1.4370	1.4009	1.4351	1.4351	1.4519	2.4620	2.4621	2.4609		
Typ		E 19 9 LR 1 2	E 19 9 LR 1 2	E 19 9 LB 2 2	E 19 9 Nb R 1 2	E 19 9 Nb B 2 2	E 19 12 3 LR 1 1	E 19 12 3 LR 1 2	E 19 12 3 LR 1 2	E 19 12 3 LR 1 2	E 19 12 3 LR 1 1	E 19 12 3 LB 2 2	E 19 12 3 LR 5 3	E 19 12 3 Nb R 3 2	E 19 12 3 Nb B 4 2	E 18 Mn B 1 2	E 13 B 4 2	E 13 4 R 3 2	E 13 4 B 4 2 H5	E 16 6 B 4 2 H5	E 20 25 5 Cu N L R 3 2	E Ni 6182 (NiCr15Fe8M)	E Ni 6625 (NiCr22Mo9N)	E Ni 6059 (NiCr23Mo16)
Materiał dodatkowy		OK 61.20	OK 61.30	OK 61.35	OK 61.80	OK 61.85	OK 63.20	OK 63.30	OK 63.31	OK 63.34	OK 63.35	OK 63.41	OK 63.80	OK 63.85	OK 67.43	OK 68.15	OK 68.17	OK 68.25	OK 68.37	OK 69.33	OK 92.26	OK 92.45	OK 92.59	
Materiał rodzimy																								
1.4512	X2CrTi12	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	●							
1.4513	X2CrMoTi17-1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○								
1.4520	X2CrTi17	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○								
1.4521	X2CrMoTi18-2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○								
1.4526	X6CrMoNb17-1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○								
1.4529	X1NiCrMoCuN25-20-7																					●	●	
1.4531	GX2NiCrMoCuN20-18																				●	●	●	
1.4536	GX2NiCrMoCuN25-20																				●	●	●	
1.4537	X1CrNiMoCuN25-25-5																				●	●	●	
1.4538	GX1NiCrMoCuN25-20-5																				●	●	●	
1.4539	X1NiCrMoCu25-20-5																				●	●	●	
1.4541	X6CrNiTi18-10	●	●	●	●	○	○	○	○	○	○	○	○	○	○									
1.4547	X1CrNiMoCuN20-18-7																					●	●	
1.4550	X6CrNiNb18-10	●	●	●	●	○	○	○	○	○	○	○	○	○	○									
1.4552	GX5CrNiNb19-11	●	●	●	●	○	○	○	○	○	○	○	○	○	○									
1.4559	GX7NiCrMoCuNb41-20																					○	○	
1.4562	X1NiCrMoCu32-28-7																					●	●	
1.4563	X1NiCrMoCu31-27-4																					●	●	
1.4565	X2CrNiMnMoN25-18-6-5																					●	●	
1.4571	X6CrNiMoTi17-12-2					●	●	●	●	●	●	●	●	●	●									
1.4580	X6CrNiMoCuNb17-12-2					●	●	●	●	●	●	●	●	●	●									
1.4581	GX5CrNiMoCuNb19-11-2					●	●	●	●	●	●	●	●	●	●									
1.4583	X10CrNiMoNb18-12					●	●	●	●	●	●	●	●	●	●									
1.4584	GX2NiCrMoCu25-20-5																				●	●	●	
1.4585	GX7CrNiMoCuNb18-18																				●	●	●	
1.4586	X5NiCrMoCuNb22-18																				●	●	●	
1.4589	X5CrNiMoTi15-2	○	○	○	○	○										○								

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

		MAG										TIG																
Gatunek		1.4316	1.4430	1.4576	1.4551	1.4519	-1.4511	1.4502	1.4370	2.4607	2.4831	2.4806					1.4316	1.4430	1.4576	1.4551	1.4519	1.4502	1.4370	2.4607	2.4831	2.4806		
Typ		G 19 9 L Si	G 19 12 3 L Si	G 19 12 3 Nb Si	G 19 9 Nb Si	G 20 25 5 Cu L	G Z 18 L Nb	G Z 17 Ti	G 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)					W 19 9 L Si	W 19 12 3 L Si	W 19 12 3 Nb Si	W 19 9 Nb Si	W 20 25 5 Cu L	W Z 17 Ti	W 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)		
Materiał dodatkowy		OK Autrod 308LSi	OK Autrod 316LSi	OK Autrod 318Si	OK Autrod 347Si	OK Autrod 385	OK Autrod 430LNb	OK Autrod 430Ti	OK Autrod 16.95	OK Autrod 19.81	OK Autrod 19.82	OK Autrod 19.85					OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod 19.81	OK Tigrod 19.82	OK Tigrod 19.85		
Materiał rodzimy																												
1.4000	X6Cr13	○	○	○	○	○	●	●	○								○	○	○	○		○	○					
1.4001	X7Cr14						●	●	○								○	○	○	○		○	○					
1.4002	X6CrAl13	○	○	○	○	○	●	●	○								○	○	○	○		○	○					
1.4003	X2CrNi12	○	○	○	○	○	●	●	○								○	○	○	○		○	○					
1.4006	X12Cr13	○	○	○	○	○	○	○	○								○	○	○	○		○	○					
1.4008	GX7CrNiMo12-1				○			●	●													○	○					
1.4011	GX12Cr12				○			●	●													○	○					
1.4016	X6Cr17	○	○	○			●	●	○								○	○	○	○		○	○					
1.4021	X20Cr13				○		○	○	○			●										○	○					
1.4024	X15Cr13				○		○	○	○													○	○				●	
1.4027	GX20Cr14				○		○	○	○			●										○	○				●	
1.4028	X30Cr13							●	○													○	○				●	
1.4057	X17CrNi16-2				○			●			○											○	○		○	○		
1.4107	GX8CrNi12						●	●	○													○	○					
1.4113	X6CrMo17-1	○	○	○	○		●	●	○								○	○	○	○		○	○					
1.4120	X20CrMo13						●	●	○			●										○	○				●	
1.4301	X5CrNi18-10	●	○	○	●												●	○	○	○								
1.4303	X4CrNi18-12	●	○	○	●												●	○	○	○								
1.4306	X2CrNi19-11	●	○	○	●												●	○	○	○								
1.4307	X2CrNi18-9	●	○	○	●												●	○	○	○								
1.4308	GX5CrNi19-10	●	○	○	●												●	○	○	○								
1.4309	GX2CrNi19-11	●	○	○	●												●	○	○	○								
1.4313	X3CrNiMo13-4																											
1.4317	GX4CrNi13-4																											
1.4318	X2CrNiN18-7	○		○													○		○									
1.4371	X2CrMnNiN17-7-5								●															●				
1.4401	X5CrNiMo17-12-2		●	●		●												●	●		●							
1.4404	X2CrNiMo17-12-2		●	●		●												●	●		●							

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Gatunek		MAG												TIG									
		1.4316	1.4430	1.4576	1.4551	1.4519	~1.4511	1.4502	1.4370	2.4607	2.4831	2.4806	1.4316	1.4430	1.4576	1.4551	1.4519	1.4502	1.4370	2.4607	2.4831	2.4806	
Typ		G 19 9 L Si	G 19 12 3 L Si	G 19 12 3 Nb Si	G 19 9 Nb Si	G 20 25 5 Cu L	G Z 18 L Nb	G Z 17 Ti	G 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)	W 19 9 L Si	W 19 12 3 L Si	W 19 12 3 Nb Si	W 19 9 Nb Si	W 20 25 5 Cu L	W Z 17 Ti	W 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)	
Materiał dodatkowy		OK Autrod 308LSi	OK Autrod 316LSi	OK Autrod 318Si	OK Autrod 347Si	OK Autrod 385	OK Autrod 430LNb	OK Autrod 430Ti	OK Autrod 16.95	OK Autrod 19.81	OK Autrod 19.82	OK Autrod 19.85	OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod 19.81	OK Tigrod 19.82	OK Tigrod 19.85	
Materiał rodzimy																							
1.4405	GX4CrNiMo16-5-1																						
1.4406	X2CrNiMoN17-11-2		●	●										●	●								
1.4407	GX5CrNiMo13-4																						
1.4408	GX5CrNiMo19-11-2		●	●		●								●	●		●						
1.4409	GX2CrNiMo19-11-2		●	●		●								●	●		●						
1.4412	GX5CrNiMo19-11-3		●	●		●								●	●		●						
1.4413	X4CrNiMo13-4																						
1.4414	GX4CrNiMo13-4																						
1.4416	GX2NiCrMoN25-20-5					●			●	●							●			●	●		
1.4418	X4CrNiMo16-5-1																						
1.4421	GX4CrNiMo16-4																						
1.4425	X2CrNiMo18-13-3		○	○		●								○	○		●						
1.4429	X2CrNiMoN17-13-3		●	●		●				●	●			●	●						●	●	
1.4432	X2CrNiMo17-12-3		●	●		●								●	●						●	●	
1.4434	X2CrNiMoN18-12-4					●											●						
1.4435	X2CrNiMo18-14-3		●	●		●								●	●		●						
1.4436	X3CrNiMo17-13-3		●	●		●								●	●		●						
1.4437	GX6CrNiMo18-12		●	●		●								●	●		●						
1.4438	X2CrNiMo18-15-4					●			○	○							●			○	○		
1.4439	X2CrNiMoN17-13-5					●			○	○							●			○	○		
1.4446	GX2CrNiMoN17-13-4					●			○	○							●			○	○		
1.4448	GX6CrNiMo17-13					●				○	○						●			○	○		
1.4500	GX7NiCrMoCuNb25-20					●				●	●						●			●	●		
1.4505	X4NiCrMoCuNb20-18-2					●				●	●						●			●	●		
1.4506	X5NiCrMoCuTi20-18					●				●	●						●			●	●		
1.4509	X2CrTiNb18	○	○	○	○		●	●	○				○	○	○	○		●		○	○		
1.4510	X3CrTi17	○	○	○	○		●	●	○				○	○	○	○		●		○	○		
1.4511	X3CrNb17	○	○	○	○		●	●	○				○	○	○	○		●		○	○		

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Gatunek		MAG										TIG																			
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Typ		G 19 9 L Si	G 19 12 3 L Si	G 19 12 3 Nb Si	G 19 9 Nb Si	G 20 25 5 Cu L	G Z 18 L Nb	G Z 17 Ti	G 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)					W 19 9 L Si	W 19 12 3 L Si	W 19 12 3 Nb Si	W 19 9 Nb Si	W 20 25 5 Cu L	W Z 17 Ti	W 18 8 Mn	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9N)	S Ni 6082 (NiCr20Mn3N)					
Materiał dodatkowy		OK Autrod 308LSi	OK Autrod 316LSi	OK Autrod 318Si	OK Autrod 347Si	OK Autrod 385	OK Autrod 430LNb	OK Autrod 430Ti	OK Autrod 16.95	OK Autrod 19.81	OK Autrod 19.82	OK Autrod 19.85					OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod 19.81	OK Tigrod 19.82	OK Tigrod 19.85					
Materiał rodzimy																															
1.4512	X2CrTi12	○	○	○	○	●	●	○									○	○	○	○		●	○								
1.4513	X2CrMoTi17-1																														
1.4520	X2CrTi17	○	○	○	○	●	●	○									○	○	○	○		●	○								
1.4521	X2CrMoTi18-2	○	○	○	○	●	●	○									○	○	○	○		●	○								
1.4526	X6CrMoNb17-1	○	○	○	○	●	●	○									○	○	○	○		●	○								
1.4529	X1NiCrMoCuN25-20-7									●	●															●	●				
1.4531	GX2NiCrMoCuN20-18					●				●	●											●				●	●				
1.4536	GX2NiCrMoCuN25-20					●				●	●											●				●	●				
1.4537	X1CrNiMoCuN25-25-5					●				●	●											●				●	●				
1.4538	GX1NiCrMoCuN25-20-5					●				●	●											●				●	●				
1.4539	X1NiCrMoCu25-20-5					●				●	●											●				●	●				
1.4541	X6CrNiTi18-10	●	○	○	○	●											●	○	○	○		●									
1.4547	X1CrNiMoCuN20-18-7					●				●	●											●				●	●				
1.4550	X6CrNiNb18-10	●	○	○	○	●											●	○	○	○		●									
1.4552	GX5CrNiNb19-11	●	○	○	○	●											●	○	○	○		●									
1.4559	GX7NiCrMoCuNb41-20									○	○															○	○				
1.4562	X1NiCrMoCu32-28-7									●	●															●	●				
1.4563	X1NiCrMoCu31-27-4									●	●															●	●				
1.4565	X2CrNiMnMoN25-18-6-5									●	●															●	●				
1.4571	X6CrNiMoTi17-12-2		●	●															●	●											
1.4580	X6CrNiMoCuNb17-12-2		●	●															●	●											
1.4581	GX5CrNiMoNb19-11-2		●	●															●	●											
1.4583	X10CrNiMoNb18-12		●	●															●	●											
1.4584	GX2NiCrMoCu25-20-5					●				●	●											●				●	●				
1.4585	GX7CrNiMoCuNb18-18					●				●	●											●				●	●				
1.4586	X5NiCrMoCuNb22-18					●				●	●											●				●	●				
1.4589	X5CrNiMoTi15-2	○			○			○	○								○				○		○	○							

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

Gatunek		FCAW										SAW													
		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 18 8 M n M M 2	T 13 4 M M 2 H 5	T Z 16 5 M M 2 H 5		SA CS 2 Cr DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	SA AF 2 DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	S 20 25 5 Cu L	SA AF 2 Cr Ni DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)
Typ		Materiał dodatkowy										Materiał rodzimy													
		H 35 Shield-Bright 308L X-tRa	H 36 Shield-Bright 308L	H 37 OK Tubrod 15.30	H 52 Shield-Bright 316L X-tRa	H 53 Shield-Bright 316L	H 54 OK Tubrod 15.31	H 29 OK Tubrod 15.34	H 20 PZ 6166	H 22 PZ 6176		P OK Flux 10.92	H 38 OK Autrod 308L	H 55 OK Autrod 316L	H 60 OK Autrod 318	H 43 OK Autrod 347	P OK Flux 10.93	H 38 OK Autrod 308L	H 55 OK Autrod 316L	H 60 OK Autrod 318	H 43 OK Autrod 347	H 64 OK Autrod 385	P OK Flux 10.90	OK Autrod 19.81	OK Autrod 19.82
1.4000	X6Cr13	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4001	X7Cr14	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4002	X6CrAl13	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4003	X2CrNi12	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4006	X12Cr13	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4008	GX7CrNiMo12-1							○	●																
1.4011	GX12Cr12							○																	
1.4016	X6Cr17	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4021	X20Cr13							○														○			
1.4024	X15Cr13							○																	
1.4027	GX20Cr14							○																	
1.4028	X30Cr13							○																	
1.4057	X17CrNi16-2								○																
1.4107	GX8CrNi12								○																
1.4113	X6CrMo17-1	○	○	○	○	○	○	○					○	○	○	○		○	○	○	○				
1.4120	X20CrMo13							○	●																
1.4301	X5CrNi18-10	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4303	X4CrNi18-12	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4306	X2CrNi19-11	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4307	X2CrNi18-9	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4308	GX5CrNi19-10	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4309	GX2CrNi19-11	●	●	●	○	○	○						●	○	○	○		●	○	○	○				
1.4313	X3CrNiMo13-4								●	○															
1.4317	GX4CrNi13-4								●	○															
1.4318	X2CrNiN18-7	○	○	○												○						○			
1.4371	X2CrMnNiN17-7-5							●																	
1.4401	X5CrNiMo17-12-2				●	●	●						●	●								●	●		
1.4404	X2CrNiMo17-12-2				●	●	●						●	●								●			

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



Gatunek		FCAW										SAW												
		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 18 8 M n M M 2	T 13 4 M M 2 H 5	T Z 16 5 M M 2 H 5	SA GS 2 Cr DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	SA AF 2 DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	S 20 25 5 Cu L	SA AF 2 C Ni DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)
Typ		Material dodatkowy										Material rodzimy												
		Shield-Bright 308L X-1ra	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-1ra	Shield-Bright 316L	OK Tubrod 15.31	OK Tubrod 15.34	PZ 6166	PZ 6176	OK Flux 10.92	OK Autrod 308L	OK Autrod 316L	OK Autrod 318	OK Autrod 347	OK Flux 10.93	OK Autrod 308L	OK Autrod 316L	OK Autrod 318	OK Autrod 347	OK Autrod 385	OK Flux 10.90	OK Autrod 19.81	OK Autrod 19.82
1.4405	GX4CrNiMo16-5-1									●														
1.4406	X2CrNiMoN17-11-2				●	●	●						●	●					●	●				
1.4407	GX5CrNiMo13-4								●	○														
1.4408	GX5CrNiMo19-11-2				●	●	●												●	●				
1.4409	GX2CrNiMo19-11-2				●	●	●												●	●				
1.4412	GX5CrNiMo19-11-3				●	●	●						●	●					●	●				
1.4413	X4CrNiMo13-4								●	○														
1.4414	GX4CrNiMo13-4								●	○														
1.4416	GX2NiCrMoN25-20-5																				●		●	●
1.4418	X4CrNiMo16-5-1									●														
1.4421	GX4CrNiMo16-4									●														
1.4425	X2CrNiMo18-13-3				○	○	○						○	○					○	○				
1.4429	X2CrNiMoN17-13-3				●	●	●												●	●			●	●
1.4432	X2CrNiMo17-12-3				●	●	●																●	●
1.4434	X2CrNiMoN18-12-4																						●	●
1.4435	X2CrNiMo18-14-3				●	●	●						●	●					●	●			●	●
1.4436	X3CrNiMo17-13-3				●	●	●						●	●					●	●			●	●
1.4437	GX6CrNiMo18-12				●	●	●						●	●					●	●			●	●
1.4438	X2CrNiMo18-15-4									●													○	○
1.4439	X2CrNiMoN17-13-5																						○	○
1.4446	GX2CrNiMoN17-13-4																						○	○
1.4448	GX6CrNiMo17-13																						○	○
1.4500	GX7NiCrMoCuNb25-20																						●	●
1.4505	X4NiCrMoCuNb20-18-2																						●	●
1.4506	X5NiCrMoCuTi20-18																						●	●
1.4509	X2CrTiNb18	○	○	○	○	○	○	○			○	○	○	○		○	○	○	○	○			○	○
1.4510	X3CrTi17	○	○	○	○	○	○	○			○	○	○	○		○	○	○	○	○			○	○
1.4511	X3CrNb17																							

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Gatunek		FCAW										SAW																
		1.4316	1.4316	1.4316	1.4430	1.4430	1.4370	1.4351	~1.4405			1.4316	1.4316	1.4430	1.4576	1.4551	1.4519			2.4607	2.4831							
Typ		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 18.8 M n M M 2	T 13.4 M M 2 H 5	T Z 16.5 M M 2 H 5		SA CS 2 Cr DC	S 19.9 L	S 19.12.3 L	S 19.12.3 Nb	S 19.9 Nb	SA AF 2 DC	S 19.9 L	S 19.12.3 L	S 19.12.3 Nb	S 19.9 Nb	S 20.25.5 Cu L		SA AF 2 Cr Ni DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)		
Materiał dodatkowy		Shield-Bright 308L X-tral	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-tral	Shield-Bright 316L	OK Tubrod 15.31	OK Tubrod 15.34	PZ 6166	PZ 6176		OK Flux 10.92	OK Autrod 308L	OK Autrod 316L	OK Autrod 318	OK Autrod 347		OK Flux 10.93	OK Autrod 308L	OK Autrod 316L	OK Autrod 318	OK Autrod 347	OK Autrod 385		OK Flux 10.90	OK Autrod 19.81	OK Autrod 19.82	
Materiał rodzimy																												
1.4512	X2CrTi12																											
1.4513	X2CrMoTi17-1																											
1.4520	X2CrTi17																											
1.4521	X2CrMoTi18-2																											
1.4526	X6CrMoNb17-1																											
1.4529	X1NiCrMoCuN25-20-7																											
1.4531	GX2NiCrMoCuN20-18																											
1.4536	GX2NiCrMoCuN25-20																											
1.4537	X1CrNiMoCuN25-25-5																											
1.4538	GX1NiCrMoCuN25-20-5																											
1.4539	X1NiCrMoCu25-20-5																											
1.4541	X6CrNiTi18-10																											
1.4547	X1CrNiMoCuN20-18-7																											
1.4550	X6CrNiNb18-10																											
1.4552	GX5CrNiNb19-11																											
1.4559	GX7NiCrMoCuNb41-20																											
1.4562	X1NiCrMoCu32-28-7																											
1.4563	X1NiCrMoCu31-27-4																											
1.4565	X2CrNiMnMoN25-18-6-5																											
1.4571	X6CrNiMoTi17-12-2																											
1.4580	X6CrNiMoCuNb17-12-2																											
1.4581	GX5CrNiMoNb19-11-2																											
1.4583	X10CrNiMoNb18-12																											
1.4584	GX2NiCrMoCu25-20-5																											
1.4585	GX7CrNiMoCuNb18-18																											
1.4586	X5NiCrMoCuNb22-18																											
1.4589	X5CrNiMoTi15-2																											

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

