

# 23. WELDING

Welding equipment	p. 644
Electrodes	p. 645
Stainless threads	p. 646
Coated Electrodes	p. 646





>>> **Welding equipment**



**Electrode welding equipment. AC welding transformer groups**

At www.rodavigo.net Family: Welding  
Product: Praxair material



Code **TRANSFORMER A-142**



Code **TRANSFORMER A-182**



Code **TRANSFORMER A-173 MINI**

5322400016	Continuous magnetic regulation: 4-140 A 230 / 400V. With intensity indicator Monophase Portable Weight 20.5 Kg For electrodes up to 2.5 mm Includes accessories: Sets of ground clamp and electrode holder, pickaxe, brush and screen	5322400031	Continuous magnetic regulation: 55-180 A 230 / 400V. Monophase Portable Weight 23 Kg with intensity indicator For electrodes up to 3.25 mm Includes accessories: Sets of ground clamp and electrode holder, pickaxe, brush and screen	5322400333	Regulation by selectors: 30-170 A 230 / 400V. 16 regulation points Monophase Portable Auxiliary outputs 12 and 220 V Fiberglass body, shock resistant Weight 41 Kg For electrodes up to 3.25 mm RECOMMENDED ACCESSORIES: Basic accessories set: pickaxe, brush, screen, dough clamp sets and connector electrode holder 10-25
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Code **TRANSFORMER A-223 MINI**



Code **TRANSFORMER A-212.1**



Code **TRANSFORMER A-262.1**

5322400344	Regulation by selectors: 35-220 A 230 / 400V. 16 regulation points Monophase Portable Auxiliary outputs 12 and 220 V Fiberglass body, shock resistant Weight 50 Kgs For electrodes up to 4 mm	5322400300	Continuous magnetic regulation: 35-210 A 230 / 400V. Monophase Intensity indicator, wheels and handle Weight 53.2 Kgs For electrodes up to 4 mm Includes accessories: Set of clamp and electrode holder connector 35-50, brush, pickaxe and mask.	5322400311	Continuous regulation by handle: 35-260 A 230 / 400V. Monophase Intensity indicator, wheels and handle Weight 68 Kgs For electrodes up to 5 mm Includes accessories: Set of clamp and electrode holder connector 35-50, brush, pickaxe and mask.
5322400930	RECOMMENDED ACCESSORIES: Basic accessories set: pickaxe, brush, screen, dough clamp sets and connector electrode holder 10-25				

**Electrode welding equipment. Converter rectifier groups for DC welding**



Code **MICRO RECTIFIER DC-124 i**  
5322401055 with carrying case and accessories



Code **MICRO RECTIFIER DC-144 i**  
5322400064



Code **MICRO RECTIFIER DC-164 i**

5322407300	230 V. (+15%, -40%) Monophase 50 / 60 Hz. F. 16 A.
5322408766	Multivoltage 115 / 230 V. 115 V ( ±15%) 230 V. (+15%, -20%) Monophase. 50 - 60 Hz.

Continuous regulation: TIG 10 - 160 A. Weight 4.8 kg. IP23 protection for outdoors and class S. Plastic front and aluminum sides. Inverter technology with exceptional priming and weldability. With thermal protector. Allows connection to Generator Sets (8.1 kVA) without restrictions and extensions of up to 50 m. Hot-Star, Arc Force, Antistick. Electrodes up to 4mm. and TIG Liftarc.	RECOMMENDED ACCESSORIES Code 5322400160 Electrode holder clamp set with 3m cable. 5322400204 Mass clamp set with 3m cable. 5322407510 Carrying case with accessories: Screen, pickaxe brush, a pack with 5 electrodes of 2.5 and 5 electrodes of 3, 2, ground clamps and connector electrode holder 10-25.
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230 V. (+13%, -13%). Monophase. 50 / 60 Hz. F. 16 A. Continuous regulation: 3 - 120 A. F. U. 40% 120 A. Vo: 90 V. Weight 5.3 kg. IP23 protection for outdoors and class H. With full protection against voltage fluctuations. Connection to generators and very extensive extensions. Hot-Start, Arc Force. Includes accessory case: Screen, pickaxe brush, a pack with 5 electrodes of 2.5 and 5 electrodes of 3.2, clamps mass and connector electrode holder 10-25. Electrodes up to 3.2 mm. and TIG Liftarc.
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230 V. (+13%, -13%) Monophase. 50 / 60 Hz. F. 16 A. Continuous regulation: Weight 5.3 kg. IP23 protection for outdoors and class H. With full protection against voltage fluctuations. Connection to generators and extensions up to 50 m. Hot-Start, Arc Force. Electrodes up to 4 mm. and TIF Liftarc.
RECOMMENDED ACCESSORIES Code 5322407510 Accessories case consisting of a screen, pickaxe brush, a package with 5 electrodes of 2.5 and 5 electrodes of 3.2, ground clamps and 10-25 connector electrode holder.



## >>> Welding equipment

At [www.rodavigo.net](http://www.rodavigo.net) Family: Welding  
Product: Praxair material

Portable inverter rectifier groups for continuous welding (DC)

Code	MICRO RECTIFIER DC-184i	Code	MICRO RECTIFIER DC-204i
5322401346	230 V. (+15%, -15%) Monophase 50 / 60 Hz. Continuous regulation: 5-180 A. F.U. al 60%. 180 A. Vo: 85 V. Weight 6.3 Kg. Connection to generators (5.9 kVA). Hot Start and Antistick selector, Arc Force and TIG Liftarc to weld rutile, basic and special electrodes up to 5 mm. RECOMMENDED ACCESSORIES:	5322400090	230 V. (+15%, -15%) Monophase. 50 / 60 Hz. Continuous regulation: 5-180 A. F.U. al 60%. 200 A. Vo: 75 V. Weight 6.3 Kg. Connection to generators (5.9 kVA). Hot Start and Antistick selector, Arc Force and TIG Liftarc to weld rutile, basic and special electrodes up to 5 mm. RECOMMENDED ACCESSORIES:
5322400171	Set of electrode holder clamp and 3 m cable. Connector 35-50.	5322400171	Set of electrode holder clamp and 3 m cable. Connector 35-50.
5322400215	Set of 250 A ground clamp. 3 m cable. Connector 35-50.	5322400215	Set of 250 A ground clamp. 3 m cable. Connector 35-50.
Code	MICRO RECTIFIER DC-214i	Code	MICRO RECTIFIER DC-254i
5322408711	230 V. (+13%) Monophase. 50 / 60 Hz. F. 20 A. Continuous regulation: 33200 A.F.U. to 70% 200 A A. Weight 14.7 Kg. Adjustable Hot Start and Arc Force times. Antistick. Digital screen. Full protection against voltage fluctuations. Connection to extensions and generators (10.53 kVA). Front and rear impact and water resistant panels. For electrodes up to 5 mm and TIG Liftarc. RECOMMENDED ACCESSORIES:	5322408685	3 X 400 V. (+10%) Three-phase. 50 / 60 Hz. F. (3 X 16A). Continuous regulation: 33250 A.F.U. to 60% 250 A A. Weight 15.3 Kg. Adjustable Hot Start and Arc Force times. Digital screen. Total protection against voltage fluctuations. with constant monitoring of the loss of a phase. It allows connecting generators (14.10 kVA) and extensions. Front and rear impact and water resistant panels. Welds electrodes up to 6mm and TIG Liftarc. RECOMMENDED ACCESSORIES:
5322400171	Electrode holder clamp and 3 m cable set. Connector 35-50.	5322400171	Electrode holder clamp and 3 m cable set. Connector 35-50.
5322400215	Set clamp ground cable 3m. Connector 35-50.	5322400215	Set clamp ground cable 3m. Connector 35-50.
5322412410	Intensity regulation remote control. 10 m. cable.	5322412410	Intensity regulation remote control. 10 m. cable.



### Welding equipment. Mobile rectifiers for continuous welding (DC)

Code	RECTIFIER D-245	Code	RECTIFIER D-345
5322401162	230 / 400 V. Three-phase. 50 Hz. Regulation by selectors with 20 positions: 19 - 240 A. F.U. to 40% 195 A. Vo = 75 V. Weight 83 Kg. With wheels, handles and hooks. Low minimum intensity. For electrodes up to 4 mm and TIG. RECOMMENDED ACCESSORIES:	5322401173	230 / 400 V. Three-phase. Regulation by selectors with 30 positions: 34 - 340 A. F.U. to 40% 250 A. Vo = 78 V. Weight 105 Kg. With wheels, handles and hooks. Low minimum intensity. For electrodes up to 5 mm and TIG. RECOMMENDED ACCESSORIES:
5322400171	Electrode holder clamp and 3 m cable set. (1 X 35).	5322400182	Electrode holder clamp and 3 m cable set. (1 X 35).
5322400215	Set clamp ground cable 3m. (1 X 25).	5322400226	Set clamp ground cable 3m. (1 X 25).
Code	RECTIFIER D-252	Code	RECTIFIER D-302
5322401033	230 / 400 V Three-phase. Continuous regulation by handle: 55 - 250 A F.U. to 35% 230 A. Vo = 65 V. Weight 62 Kg. With wheels, handles and eyebolts and intensity indicator. Electrodes up to 4 mm and TIG. RECOMMENDED ACCESSORIES:	5322401044	230 / 400 V. Three-phase. Continuous regulation by handle: 55 - 250 A F.U. to 35% 260 A. Vo = 65 V. Weight 67 Kg. With wheels, handles and eyebolts and intensity indicator. Electrodes up to 5 mm and TIG. RECOMMENDED ACCESSORIES:
5322400171	Electrode holder clamp and 3 m cable set. (1 X 25).	5322400182	Electrode holder clamp and 3 m cable set. (1 X 35).
5322400215	Set ground clamp 350 cable 3 m. (1 X 25)	5322400226	Set ground clamp 350 cable 3 m. (1 X 35)



## >>> Electrodes

Carbon steel welding electrodes

### PRAXAIR B-52 ELECTRODE

Basic coating electrode with high mechanical properties for welding in all positions, except vertical down. Recommended for use with C.C.

Code	Description	Units. Lot
5322525106	PR. B-52 2,5 X 350 mm	175
5322525110	PR. B-52 3,2 X 350 mm	115
5322525121	PR. B-52 3,2 X 450 mm	115
5322525143	PR. B-52 4,0 X 450 mm	80
5322525165	PR. B-52 5,0 X 450 mm	55



### PRAXAIR B-69 ELECTRODE

Vacuum packed basic coating electrode with high mechanical properties. Special for assemblies. Recommended for use with C.C.

Code	Description	Units. Lot
5322525460	PR. B-69 2,5 X 350 mm	75
5322525471	PR. B-69 3,2 X 350 mm	52
5322525482	PR. B-69 3,2 X 450 mm	52
5322525504	PR. B-69 4,0 X 450 mm	36
5322525515	PR. B-69 5,0 X 450 mm	24



### RANGE OF CASTOMAG STAINLESS THREADS

Code	DIN standard	Features and Applications	Coils 15 Kg Ø mm.
57545500S08 57545500S10 57545500S12	DIN 8556: SG-X 2 Cr Ni 19 12 3L AWS A5.9: ER 316L Si	For mixed joints between austenitic stainless steels. Austenitic welding deposit. Peeling resistance up to 850°C.	0,8 - 1,0 - 1,2
57545503S08 57545503S10 57545503S12	DIN 8556: SG-X2 Cr Ni 19.9 AWS A5.9: ER 308L Si	For welding of stabilized and non-stabilized stainless steels. Peeling resistance up to 850°C. Austenitic weld deposit.	0,8 - 1,0 - 1,2
575500EC20 575500EC25 575500EC32	AWS A5.4 E 316 L-16	Electrode developed for welding on stainless steels containing molybdenum. Recommended for Cr-Ni-Mo stainless steels	Packages 4,5 Kg 2,0 - 2,5 - 3,2
575503EC20 575503EC25 575503EC32	AWS A5.4 E 308 L-16	Electrode made for welding austenitic stainless steels that do not contain molybdenum. Recommended for Cr-Ni stainless steels	Packages 4,5 Kg 2,0 - 2,5 - 3,2

### EUTECTRODE RANGE

Reference	DIN standard	Features and Applications	Coils 15 Kg Ø mm.
EutecTrode 307-17	AWS A5.9 E 307 - 17 EN 1600 E 18 9 MnMo R 32	Deposit highly alloyed to Cr-Ni-Mo for joints that are difficult to weld or that are thick. Ideal for steels with high mechanical resistance.	2,5 - 3,2 4,0 - 5,0
EutecTrode 308L-17	AWS A5.9 E 308L - 17 EN 1600 E 19 9 L R 32	Rutile-coated electrode, with a performance of 110%. For welding of stabilized and non-stabilized stainless steels.	2,0 - 2,5 3,2 - 4,0 - 5,0
EutecTrode 309L - 17	AWS A5.9 E 309L - 17 EN 1600 E 23 12 L R 32	Rutile-coated electrode with an approximate efficiency of 115%. Maximum service temperature for mixed joints of 300°C.	2,5 - 3,2 - 4,0
EutecTrode 310 E - 17	AWS A5.9 E 310- 17 EN 1600 E 25 20 R 32	Rutile-coated electrode with approximately 120% efficiency. Maximum service temperature for mixed joints of 300°C.	2,5 - 3,2 - 4,0
EutecTrode 312 E- 17	AWS A5.9 E 312 - 17 EN 1600 E 29 9 R 32	Rutile-coated electrode with 120% efficiency. Resistant to cavitation and impact.	2,5 - 3,2 - 4,0
EutecTrode 316L-17	AWS A5.4 E 316 - 17 EN 1600 E 19 12 3 L R 32	Rutile-coated electrode with a performance of 110%. Austenitic welding deposit. Ideal for mixed joints between stainless steels	2,0 - 2,5 - 3,2 4,0 - 5,0

### Coated electrodes for high-quality joints XUPER RUT



#### Description:

Rutile-coated electrode for joint welding in all positions, in general construction steels, thin sheets, steel tubes.

- High mechanical characteristic values.
- Easy priming.
- Automatic lifting of the slag.

#### Characteristics:

Tensile strength: 470-550 N / mm<sup>2</sup>

Elastic limit: 470 N / mm<sup>2</sup>

Lengthening (Lm5D): > 22%

Resilience (ISO-V): 100 - 50 J

ASTW-AWS: E - 6013

EN 499: E 38 0 RC 11

#### Applications

Steel welding ST 34, St 52, St 35, 4, St 45, 4; GS 38, GS 45; SI - SIII.

Usable in construction of machinery-steel structures, construction of tanks and naval building.

Code	Dimensions	PACKAGE		Box (Minimum quantity for sale)	
		Electrodes	Weight Kg	Electrodes	Weight Kg
575XUPERRUT25	2.5 x 350mm	115	2.3	690	13.8
575XUPERRUT32	3.2 x 350mm	75	2.25	450	13.6
575XUPERRUT40	4.0 x 350mm	50	2.18	300	13.0