

SUGGESTED OPERATING PARAMETERS FOR WELDING

INTERNAL CODE	WERKSTOFF	EN	WELDING TECHNIQUES		
			MMA	TIG	LASER
EskyLos 2083	1.2083	X40Cr14	AWS A5.4 E410-15 EN 1600 E 13 B 53	AWS A5.9 ER410	SALTEX Cr13 INOX
BeyLos 2083 / II40	1.2083	X40Cr14			
II33	1.2085	X33CrS16	welding is not recommended due to the presence of sulfur		
KeyLos 2311 / BP35	1.2311	40CrMnMo7	AWS A5.5 E8018	AWS A5.28 ER 80S	SALTEX 300 SALTEX 300 PHOTO SALTEX 300 MIRROR
KeyLos 2312 / BS35	1.2312	40CrMnMoS8-6			
BeyLos 2329	1.2329	46CrSiMoV7	1) 4)	1) 4)	--
EskyLos 2343 / BP 37	1.2343	X37CrMoV5-1	DIN 8555 E3-UM-50-ST 1)	AWS A5.28 ER80S-B6	SALTEX 400 SALTEX 460 SALTEX Hot Work
EskyLos 2344 / BP40	1.2344	X40CrMoV5-1			
BP30	1.2365	32CrMoV12-28	QRO 90 WELD		
EskyLos 2367 ESR	1.2367	X38CrMoV5-3	DIN 8555 E3-UM-50-ST 1)	AWS A5.28 ER80S-B6	SALTEX 400 SALTEX 460 SALTEX Hot Work
BP57	1.2711	54NiCrMoV6	UTP 73G4	UTP 73G4 – ESAB OK	
BeyLos 2714 / BP56	1.2714	55NiCrMoV7	DIN 8555 E1-UM-350	AWS A5.28 ER 80S-B2 AWS A5.28 ER 90S-B3	SALTEX 400 SALTEX 300 PHOTO
KeyLos 2738 / BP36	1.2738	40CrMnNiMo8-6-4	AWS A5.5 E9018-B3	AWS A5.28 ER 80S-B2	SALTEX 300
BF40	1.2767	45NiCrMo16	1) 4)	1) 4)	
KeyLos 6959	1.6959	35NiCrMoV12-5	1) 4)	1) 4)	
ABP20	Euras		1) 4)	1) 4)	
EskyLos 2001	Lucchini RS		2)		
KeyLos 2002	Lucchini RS		AWS A5.5 E9018-B3	AWS A5.28 ER 80S-B2 AWS A5.28 ER 90S-B3	SALTEX 300 SALTEX 300 PHOTO SALTEX 300 MIRROR
KeyLos 2003	Lucchini RS				
KeyLos 2005	Lucchini RS		AWS A5.5 E8018-B2	AWS A5.28 ER 80S-B2	
KeyLos on	Lucchini RS		AWS A5.5 E8018-B2	AWS A5.28 ER 80S-B2	
KeyLos up	Lucchini RS		AWS A5.5 E8018-B2	AWS A5.28 ER 80S-B2	
KeyLos plus	Lucchini RS		AWS A5.5 E8018-B2	AWS A5.28 ER 80S-B2	
Toolox33	SABB		2)	WL 10	
B205	1.2080	X210Cr12		INCONEL 625 UTPA 67S – UTPA 73G2	
B155	1.2379	X153CrMoV12	INCONEL 625 UTP 67S – CASTOLIN 6		
B110	1.2516	120WV4	UTP 75	UTP A696	
BF90	1.2842	90MnCrV8	UTP: 65D, 73 G2, 673		
B TEN	TENASTEEL		INCONEL 625 UTP 67S – CASTOLIN 6		
S355J2G3	1.0577	S355J2G3	AWS A5.5 E8018-C1		
C20	1.1151 ~	C20E	AWS A5.1 E6013		
C25E	1.1158	C25E	AWS A5.1 E6013		
C30E	1.1178	C30E	AWS A5.1 E6013		
C45E BC45	1.1191	C45E	AWS A5.1 E7018 AWS A5.1 E7018-1	AWS A5.18 ER 70S-6 EN 1668 W3Si1	
C50E	1.1206	C50E	AWS A5.1 E7018		
39NiCrMo3 / BC39 30CrNiMo8 42CrMo4	1.6510 1.6580 1.7225	39NiCrMo3 30CrNiMo8 42CrMo4	AWS A5.5 E8018-B2 AWS A5.5 E9018-B3	AWS A5.28 ER 80S-B2	SALTEX 300 SALTEX 300 PHOTO SALTEX 300 MIRROR
41CrAlMo7-10	1.8509	41CrAlMo7-10	1) 3) 4)	1) 3) 4)	
18NiCrMo5	UNI		1) 3) 4)	1) 3) 4)	
41CrAlMo7-10	1.8509	41CrAlMo7-10	1) 3) 4)	1) 3) 4)	
52SiCrNi5	1.7117	52SiCrNi5	not recommended		

1) please address qualified producers. 2) MMA Welding Repairing is not recommended. 3) please carry out welding before superficial hardening and by using filler material with chemical composition similar to mold. 4) UTP 641 KB (HB 250) - UTP 73G4 (HRC 40) - UTP 73G3 (HRC 45) - UTP 641 73G2 (HRC 55).