DOPORUČENÍ PRO SVAŘOVÁNÍ VYBRANÝCH TYPŮ MATERIÁLŮ

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MMA																														
		E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 1 2 H5	E 46 6 Mn1Ni B 3 2 H5	E 42 2 R 1 2	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5							
		Filarc 27P	Filarc 48	Filarc 56S	Filarc 76S	Filarc 78	Filarc C6HH	OK Femax 33.60	OK Femax 33.80	OK Femax 38.65	OK Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	OK 53.16 Spezial	OK 53.70	OK 55.00						
1.0252	L235	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0458	L235GA	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0345	P235GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0112	P235S	●	○	●	●	○	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0253	P235TR1	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0254	P235TR2	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0114	S235J0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0115	S235J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0117	S235J2	●	○	●	●	○	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0119	S235J2C	●	○	●	●	○	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0116	S235J2G3	●	○	●	●	○	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0120	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0122	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0039	S235JRH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0038	S235JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0021	S240GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0459	L245GA	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0418	L245MB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0457	L245NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0352	P245GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0111	P245NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0460	P250GH (C22.8)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0452	P255QL	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●						
1.0971	S260NC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0425	P265GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0130	P265S	●		●	●		●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0423	P265NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0453	P265NL	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●						
1.0258	P265TR1	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0259	P265TR2	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0023	S270GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0260	L275	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0487	P275NH	○		●	○		●	○	○	●	●	○	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0488	P275NL1	○		○	●															●						●						
1.1104	P275NL2	○		○	●															●						●						
1.1100	P275SL	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	○						
1.0143	S275J0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0140	S275J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0149	S275J0H	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0145	S275J2	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MMA																																			
		E 46 4 B 4 1 H5		E 42 0 RC 1 1		E 42 5 B 1 2 H5	E 46 6 Mn1Ni B 3 2 H5	E 42 2 R 1 2		E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5							
		Filarc 27P		Filarc 48		Filarc 56S	Filarc 76S	Filarc 78		Filarc C6HH	OK Femax 33.60	OK Femax 33.80	OK Femax 38.65	OK Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	OK 53.16 Spezial	OK 53.70	OK 55.00							
1.0142	S275J2C	●		●	●	●	●	●	○	○	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●							
1.0138	S275J2H	●		●	●	●	●	●	○	○	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●							
1.0044	S275JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0128	S275JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8818	S275M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8843	S275MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8819	S275ML	○		●	●			○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●							
1.8844	S275MLH	○		●	●			○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●							
1.0490	S275N	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0493	S275NH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0491	S275NL	○		●	●			○	○	○	○	○	○	○	○	○	○	○	○	○	○	●	●	○	○	○	○	●							
1.0497	S275NLH	○		●	●			○	○	○	○	○	○	○	○	○	○	○	○	○	○	●	●	○	○	○	○	●							
1.0426	P280GH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0477	P285NH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0478	P285QH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0483	L290GA (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0429	L290MB (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0484	L290NB (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0050	E295 (St50-2)	●		●	●			●			●										●	●	●	●	●	●	●	●							
1.0481	P295GH (17Mn4)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0436	P305GH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0482	P310GH (19Mn5)	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0437	P310NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0972	S315MC	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0973	S315NC	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0046	S320GP	●	●	●	●	●	●	●	○	○	●	●	●	○	●	●	●	○	○	●	●	●	●	●	○	●	○	●							
1.0060	E335 (St60-2)	●		●	●			●			●										●	●	●	●	○	●	○	●							
1.0473	P355GH	●		●	●	●	●	●	○	○	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●							
1.8821	P355M	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.8832	P355ML1	○		○	●																	●						●							
1.8833	P355ML2	○		○	●																	●						●							
1.0562	P355N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0557	P355NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0565	P355NH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0566	P355NL1	○		○	●																	●						●							
1.1106	P355NL2	○		○	●																	●													
1.8866	P355Q	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.8867	P355QH	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.0571	P355QH1	●		●	●	●	●	●	○	○	●	●	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●							
1.8868	P355QL1	○		○	●																	●						●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		MMA																														
		E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 1 2 H5	E 46 6 MnNiB 3 2 H5	E 42 2 R 1 2	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5						
Svařovací materiál / Základní materiál		Filarc 27P	Filarc 48	Filarc 56S	Filarc 76S	Filarc 78	Filarc C6HH	OK Femax 33.60	OK Femax 33.80	OK Femax 38.65	OK Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	OK 53.16 Spezial	OK 53.70	OK 55.00						
1.8869	P355QL2	○		○	●															●						●					
1.8814	S355G1 (+N)	●		●	●		●			●									●	●	●		●		●	●					
1.8801	S355G2+N			●	●														●												
1.8802	S355G3+N			●	●														●												
1.8803	S355G4 (+M)			●	●														●												
1.8804	S355G5+M			●	●														●												
1.8805	S355G6+M			●	●														●												
1.8808	S355G7+M (+N)			●	●														●												
1.8810	S355G8+M (+N)			●	●														●												
1.8811	S355G9+M (+N)			●	●														●												
1.8813	S355G10+M (+N)			●	●														●												
1.8806	S355G11 (+M) (+N)			●	●														●												
1.8809	S355G12 (+M) (+N)			●	●														●												
1.1182	S355G13+N (+Q)			●	●														●												
1.1184	S355G14+N (+Q)			●	●														●												
1.1190	S355G15+N (+Q)			●	●														●												
1.0083	S355GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0554	S355J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0547	S355J0H	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0577	S355J2	●	○	●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0579	S355J2C	●	○	●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0570	S355J2G3	●	○	●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0576	S355J2H	●	○	●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0045	S355JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0551	S355JRC	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0596	S355K2	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0594	S355K2C	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0512	S355K2H	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.8823	S355M	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0976	S355MC	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.8845	S355MH	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.8834	S355ML	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●					
1.8846	S355MLH	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●					
1.0545	S355N	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0977	S355NC	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0539	S355NH	●		●	●	●	●	○	○	●	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●					
1.0546	S355NL	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●					
1.0549	S355NLH	○		●	●		○	○	○	○	○	○	○	○	○	○	○	○	○	●	○	○	○	○	●	●					
1.0070	E360 (St70-2)	○		●	●					○									●	●	●		○		○	●					
1.0499	L360GA (API 5L: X52)	●	○	●	●	●	●	○	○	○	○	●	○	○	○	○	○	●	●		●	●	●	●	●	●					

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MMA																														
		E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 1 2 H5	E 46 6 Mn1Ni B 3 2 H5	E 42 2 R 1 2	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5							
		Filarc 27P	Filarc 48	Filarc 56S	Filarc 76S	Filarc 78	Filarc C6HH	OK Femax 33.60	OK Femax 33.80	OK Femax 38.65	OK Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	OK 53.16 Speziál	OK 53.70	OK 55.00						
1.0578	L360MB (API 5L: X52)	●	○	●	●	●	●	○	○	○	○	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0582	L360NB (API 5L: X52)	●	○	●	●	●	●	○	○	○	○	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.8948	L360QB (API 5L: X52)	●	○	●	●	●	●	○	○	○	○	●	○	○	○	○	○	●	●	●	●	●	●	●	●	●						
1.0522	S390GP	●		●	●					●								●	●	●	●		●		●	●						
1.8973	L415MB (API 5L: X60)	●		●	●							●							●	●	●		●		●	●						
1.8972	L415NB (API 5L: X60)	●		●	●							●							●	●	●		●		●	●						
1.8947	L415QB (API 5L: X60)	●		●	●							●							●	●	●		●		●	●						
1.0428	BSt 420 S / B420N	●	●	●	○	●	●	○	○	●	●		●	●	●			●	●	●	●	●	●	●	●	●						
1.8824	P420M	●		●	●					●								●	●	●	●		●		●	●						
1.8835	P420ML1	○			●															●						●						
1.8828	P420ML2	○			●															●						●						
1.8932	P420NH	●		●	●					●								●	●	●	●		●		●	●						
1.8936	P420QH	●		●	●					●								●	●	●	●		●		●	●						
1.8830	S420G1+M (+Q)			●	●															●												
1.8857	S420G2+M (+Q)			●	●															●												
1.8851	S420G3 (+M)			●	●															●												
1.8859	S420G4 (+M)			●	●															●												
1.8853	S420G5+Q			●	●															●												
1.8852	S420G6+Q			●	●															●												
1.8825	S420M	●		●	●					●								●	●	●	●		●		●	●						
1.0980	S420MC	●		●	●					●								●	●	●	●		●		●	●						
1.8847	S420MH	●		●	●					●								●	●	●	●		●		●	●						
1.8836	S420ML	○		●	●														○	●	○		○		●	●						
1.8848	S420MLH	○		●	●														○	●	○		○		●	●						
1.8902	S420N	●		●	●					●								●	●	●	●		●		●	●						
1.0981	S420NC	●		●	●					●								●	●	●	●		●		●	●						
1.8750	S420NH	●		●	●					●								●	●	●	●		●		●	●						
1.8912	S420NL	○		●	●														○	●	○		○		●	●						
1.8751	S420NLH	○		●	●														○	●	○		○		●	●						
1.0523	S430GP	●		●	●					●								●	●	●	●		●		●	●						
1.8975	L450MB (API 5L: X65)	●										○								●					○	●						
1.8952	L450QB (API 5L: X65)	●										○								●					○	●						
1.8826	P460M	○																		●						●						
1.8837	P460ML1	○			●															●						●						
1.8831	P460ML2	○			●															●						●						
1.8905	P460N	○																		●						●						
1.8935	P460NH	○																		●						●						
1.8915	P460NL1	○			●															●						●						
1.8918	P460NL2	○			●															●						●						
1.8870	P460Q	○																		●						●						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MMA																												
		E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 1 2 H5	E 46 6 Mn1Ni B 3 2 H	E 42 2 R 1 2	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5				
		Filarc 27P	Filarc 48	Filarc 56S	Filarc 76S	Filarc 78	Filarc C6HH	Ok Femax 33.60	Ok Femax 33.80	Ok Femax 38.65	Ok Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	Ok 53.16 Spezial	OK 53.70	OK 55.00				
1.8871	P460QH	○																		●						●				
1.8872	P460QL1	○			●															●						●				
1.8864	P460QL2	○			●															●						●				
1.8878	S460G1+M (+Q)				●															●										
1.8887	S460G2+M (+Q)				●															●										
1.8883	S460G3 (+M)				●															●										
1.8889	S460G4 (+M)				●															●										
1.8885	S460G5+Q				●															●										
1.8884	S460G6+Q				●															●										
1.8827	S460M	○			●															●						●				
1.0982	S460MC	○			●															●						●				
1.8849	S460MH	○			●															●						●				
1.8838	S460ML	○			●															●						●				
1.4850	S460MLH	○			●															●						●				
1.8901	S460N	○			●															●						●				
1.8953	S460NH	○			●															●						●				
1.8903	S460NL	○			●															●						●				
1.8956	S460NLH	○			●															●						●				
1.8908	S460Q	○			●															●						●				
1.8906	S460QL	○			●															●						●				
1.8916	S460QL1	○			●															●						○				
1.8977	L485MB (API 5L: X70)	○										○													○					
1.8955	L485QB (API 5L: X70)	○										○													○					
1.0438	BSt 500 S / B500N	●	●	●	○	●	●	○	○	●	●		●	●	●			●	●	●	●	●	●	●	●	●				
1.0466	BSt 500 M / B500G3	●	●	●	○	●	●	○	○	●	●		●	●	●			●	●	●	●	●	●	●	●	●				
Stahlguss																														
1.0420	GE200 (GS-38)	●		●	●					●									●	●	●		●		●	●				
1.0449	GS200	●		●	●					●									●	●	●		●		●	●				
1.0445	GE240 (GS-45)	●		●	●					●									●	●	●		●		●	●				
1.0455	GS240	●		●	●					●									●	●	●		●		●	●				
1.0558	GE300 (GS-60)	●		●	●					●									●	●	●		●		●	●				
1.1131	G17Mn5	●		●	●					●									●	●	●		●		●	●				
Schienenstähle																														
1.0521	R200 (StSch 700)																				●									
1.0524	R220 (StSch 800)																				●									
1.0623	R260 (StSch 900A)																				●									
1.0624	R260Mn (StSch 900B)																				●									

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MMA																														
		E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 1 2 H5	E 46 6 Mn1Ni B 3 2 H5	E 42 2 R 1 2	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 4 B 7 3 H5	E 42 2 RA 5 3	E 38 2 C 2 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 38 0 RC 1 1	E 42 0 RR 1 2	E 42 2 RB 1 2	E 42 4 B 4 2 H5	E 46 5 1Ni B 3 2 H5	E 42 4 B 4 2 H10	E 38 2 B 4 2	E 42 4 B 2 2	E 38 2 B 3 2	E 42 5 B 1 2 H5	E 46 5 B 3 2 H5							
		Filarc 27P	Filarc 48	Filarc 56S	Filarc 76S	Filarc 78	Filarc C6HH	OK Femax 33.60	OK Femax 33.80	OK Femax 38.65	OK Femax 39.50	Pipeweld 6010	OK 46.00	OK 46.44	OK 46.64	OK 46.16	OK 43.32	OK 50.40	OK 48.00	OK 48.08	OK 48.30	OK 48.65	OK 53.05	OK 53.16 Spezial	OK 53.70	OK 55.00							
1.0440	GL-A (S235JRS1)	●	●	●	●	●	●	●	●	●	●		●	●	●	●	●		●	●	●		●	●		●						
1.0441	GL-A (S235JRS2)	●	●	●	●	●	●	●	●	●	●		●	●	●	●	●		●	●	●		●	●		●						
1.0442	GL-B (S235J0S)	●	●	●	●	●	●	●	●	●	●		●	●	●	●			●	●	●		●	●		●						
1.0474	GL-D (S235J2S2)	●	●	●	●	●	●	●	●	●	●		●	●	●	●			●	●	●		●	●		●						
1.0475	GL-D (S235J2S1)	●	●	●	●	●	●	●	●	●	●		●	●	●	●			●	●	●		●	●		●						
1.0476	GL-E (S235J4S)	●		●	●					●	●								●	●	●		●	●		●						
1.0513	GL-A 32 (S315G1S)	●	●	●	●		●			●	●			●					●	●	●		●	●		●						
1.0514	GL-D 32 (S315G2S)	●	●	●	●		●			●	●			●					●	●	●		●	●		●						
1.0515	GL-E 32 (S315G3S)	●		●	●		●			●	●								●	●	●		●	●		●						
1.8840	GL-F 32 (S315G4S)	●		●	●															●												
1.0583	GL-A 36 (S355G1S)	●	●	●	●		●			●	●			●					●	●	●		●	●		●						
1.0584	GL-D 36 (S355G2S)	●	●	●	●		●			●	●			●					●	●	●		●	●		●						
1.0589	GL-E 36 (S355G3S)	●		●	●		●			●	●								●	●	●		●	●		●						
1.8841	GL-F 36 (S355G4S)	●		●	●															●												
1.1151	C22E	●	○	●	●	○	●	○	○	●	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●	●						
1.1158	C25E	●	○	●	●	○	●	○	○	●	○	○	○	○	○	○	○	○	●	●	●	●	●	●	●	●						
1.0528	C 30	●		●	●		●			●									●	●	●	●	●	●	●	●						
1.1178	C30E	●		●	●		●			●									●	●	●	●	●	●	●	●						
1.0501	C 35	●		●	●		●			●									●	●	●		●		●	●						
1.1181	C35E	●		●	●		●			●									●	●	●		●		●	●						
1.0511	C 40	●		●	●		●			●									●	●	●		●		●	●						
1.1186	C40E	●		●	●		●			●									●	●	●		●		●	●						
1.0503	C 45	●		●	●		●			●									●	●	●		●		●	●						
1.1191	C45E	●		●	●		●			●									●	●	●		●		●	●						
1.0540	C 50	●		●	●		●												●	●	●		●		●	●						
1.1206	C50E	●		●	●		●												●	●	●		●		●	●						
1.0535	C 55	●		●	●		●												●	●	●		●		●	●						
1.1203	C55E	●		●	●		●												●	●	●		●		●	●						
1.0601	C 60	●		●	●		●												●	●	●		●		●	●						
1.1221	C60E	●		●	●		●												●	●	●		●		●	●						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG																WIG								
		G 42 4 M21 3Si1/G 38 3 C1 3Si1		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2Ti/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo								W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo							
		OK AristoRod 12.50		OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09								OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09							
1.0252	L235	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0458	L235GA	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0345	P235GH	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0112	P235S	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0253	P235TR1	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0254	P235TR2	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0114	S235J0	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0115	S235J0C	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0117	S235J2	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0119	S235J2C	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0116	S235J2G3	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0120	S235JRC	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0122	S235JRC	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0039	S235JRH	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0038	S235JR	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0021	S240GP	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0459	L245GA	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0418	L245MB	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0457	L245NB	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0352	P245GH	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0111	P245NB	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0460	P250GH (C22.8)	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0452	P255QL	●	●	○	○	○	●	●	●	○								○	●	○	○							
1.0971	S260NC	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0425	P265GH	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0130	P265S	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0423	P265NB	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0453	P265NL	●	●	○	○	○	●	●	●	●								○	●	●	○							
1.0258	P265TR1	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0259	P265TR2	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0023	S270GP	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0260	L275	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0487	P275NH	●	●	●	●	●	●	●	●	●								●	●	●	●							
1.0488	P275NL1	●	●					●	●	○								○	●	○	○							
1.1104	P275NL2	●	●					●	●	○								○	●	○	○							
1.1100	P275SL	●	●					●	●	○								○	●	○	○							
1.0143	S275J0	●	●	●	●	●	●	●	●	●								●	●	●	●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG																WIG											
		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2T/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo									W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo								
		OK AristoRod 12.50	OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09									OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09								
1.0140	S275J0C	●	●	●	●	●	●	●	●									●	●	●	●								
1.0149	S275J0H	●	●	●	●	●	●	●	●									●	●	●	●								
1.0145	S275J2	●	●	●	●	●	●	●	●									●	●	●	●								
1.0142	S275J2C	●	●	●	●	●	●	●	●									●	●	●	●								
1.0138	S275J2H	●	●	●	●	●	●	●	●									●	●	●	●								
1.0044	S275JR	●	●	●	●	●	●	●	●									●	●	●	●								
1.0128	S275JRC	●	●	●	●	●	●	●	●									●	●	●	●								
1.8818	S275M	●	●	●	●	●	●	●	●									●	●	●	●								
1.8843	S275MH	●	●	●	●	●	●	●	●									●	●	●	●								
1.8819	S275ML	●	●	○	○	○	●	●	●									○	●	●	○								
1.8844	S275MLH	●	●	○	○	○	●	●	○									○	●	●	○								
1.0490	S275N	●	●	●	●	●	●	●	●									●	●	●	●								
1.0493	S275NH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0491	S275NL	●	●	○	○	○	●	●	●									○	●	●	○								
1.0497	S275NLH	●	●	○	○	○	●	●	○									○	●	●	○								
1.0426	P280GH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0477	P285NH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0478	P285QH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0483	L290GA (API 5L: X42)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0429	L290MB (API 5L: X42)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0484	L290NB (API 5L: X42)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0050	E295 (St50-2)	○	○			●	○	○	●									○	○	○	●								
1.0481	P295GH (17Mn4)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0436	P305GH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0482	P310GH (19Mn5)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0437	P310NB	●	●	●	●	●	●	●	●									●	●	●	●								
1.0972	S315MC	●	●	●	●	●	●	●	●									●	●	●	●								
1.0973	S315NC	●	●	●	●	●	●	●	●									●	●	●	●								
1.0046	S320GP	●	●	●	●	●	●	●	●									●	●	●	●								
1.0060	E335 (St60-2)					●			○												○								
1.0473	P355GH	●	●	●	●	●	●	●	●									●	●	●	●								
1.8821	P355M	●	●	●	●	●	●	●	●									●	●	●	●								
1.8832	P355ML1	●	●				●	●	○									○	●	○	○								
1.8833	P355ML2	●	●				●	●	○									○	●	○	○								
1.0562	P355N	●	●	●	●	●	●	●	●									●	●	●	●								
1.0557	P355NB	●	●	●	●	●	●	●	●									●	●	●	●								
1.0565	P355NH	●	●	●	●	●	●	●	●									●	●	●	●								

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG																WIG								
		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2Ti/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo									W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo							
		OK AristoRod 12.50	OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09									OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09							
1.0566	P355NL1	●	●				●	●	○									○	●	○	○							
1.1106	P355NL2	●	●				●	●	○									○	●	○	○							
1.8866	P355Q	●	●	●	●	●	●	●	●									●	●	●	●							
1.8867	P355QH	●	●	●	●	●	●	●	●									●	●	●	●							
1.0571	P355QH1	●	●	●	●	●	●	●	●									●	●	●	●							
1.8868	P355QL1	●	●				●	●	○									○	●	○	○							
1.8869	P355QL2	●	●				●	●	○									○	●	○	○							
1.8814	S355G1 (+N)	●	●	●	●	●	●	●	●									●	●	●	●							
1.8801	S355G2+N	●	●			●	●	●	●									○	●	●	○							
1.8802	S355G3+N	●	●			●	●	●	●									○	●	●	○							
1.8803	S355G4 (+M)	●	●			●	●	●	●									○	●	●	○							
1.8804	S355G5+M	●	●			●	●	●	●									○	●	●	○							
1.8805	S355G6+M	●	●			●	●	●	●									○	●	●	○							
1.8808	S355G7+M (+N)	●	●			●	●	●	●									○	●	●	○							
1.8810	S355G8+M (+N)	●	●			●	●	●	●									○	●	●	○							
1.8811	S355G9+M (+N)	●	●			●	●	●	●									○	●	●	○							
1.8813	S355G10+M (+N)	●	●			●	●	●	●									○	●	●	○							
1.8806	S355G11 (+M) (+N)	●	●			●	●	●	●									○	●	●	○							
1.8809	S355G12 (+M) (+N)	●	●			●	●	●	●									○	●	●	○							
1.1182	S355G13+N (+Q)	●	●			●	●	●	●									○	●	●	○							
1.1184	S355G14+N (+Q)	●	●			●	●	●	●									○	●	●	○							
1.1190	S355G15+N (+Q)	●	●			●	●	●	●									○	●	●	○							
1.0083	S355GP	●	●	●	●	●	●	●	●									●	●	●	●							
1.0554	S355J0C	●	●	●	●	●	●	●	●									●	●	●	●							
1.0547	S355J0H	●	●	●	●	●	●	●	●									●	●	●	●							
1.0577	S355J2	●	●	●	●	●	●	●	●									●	●	●	●							
1.0579	S355J2C	●	●	●	●	●	●	●	●									●	●	●	●							
1.0570	S355J2G3	●	●	●	●	●	●	●	●									●	●	●	●							
1.0576	S355J2H	●	●	●	●	●	●	●	●									●	●	●	●							
1.0045	S355JR	●	●	●	●	●	●	●	●									●	●	●	●							
1.0551	S355JRC	●	●	●	●	●	●	●	●									●	●	●	●							
1.0596	S355K2	●	●	●	●	●	●	●	●									●	●	●	●							
1.0594	S355K2C	●	●	●	●	●	●	●	●									●	●	●	●							
1.0512	S355K2H	●	●	●	●	●	●	●	●									●	●	●	●							
1.8823	S355M	●	●	●	●	●	●	●	●									●	●	●	●							
1.0976	S355MC	●	●	●	●	●	●	●	●									●	●	●	●							
1.8845	S355MH	●	●	●	●	●	●	●	●									●	●	●	●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG																WIG											
		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2Ti/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo									W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo								
		OK AristoRod 12.50	OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09									OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09								
1.8834	S355ML	●	●	○	○	○	●	●	●									○	●	●	○								
1.8846	S355MLH	●	●	○	○	○	●	●	○									○	●	●	○								
1.0545	S355N	●	●	●	●	●	●	●	●									●	●	●	●								
1.0977	S355NC	●	●	●	●	●	●	●	●									●	●	●	●								
1.0539	S355NH	●	●	●	●	●	●	●	●									●	●	●	●								
1.0546	S355NL	●	●	○	○	○	●	●	●									○	●	●	○								
1.0549	S355NLH	●	●	○	○	●	●	●	○									○	●	●	○								
1.0070	E360 (St70-2)								○												○								
1.0499	L360GA (API 5L: X52)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0578	L360MB (API 5L: X52)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0582	L360NB (API 5L: X52)	●	●	●	●	●	●	●	●									●	●	●	●								
1.8948	L360QB (API 5L: X52)	●	●	●	●	●	●	●	●									●	●	●	●								
1.0522	S390GP	●	●			●	●	●	●										●	●	●								
1.8973	L415MB (API 5L: X60)	●	●			●	●	●	●										●	●	●								
1.8972	L415NB (API 5L: X60)	●	●			●	●	●	●										●	●	●								
1.8947	L415QB (API 5L: X60)	●	●			●	●	●	●										●	●	●								
1.0428	BSt 420 S / B420N	●	●			○	●	●	●										●	○	●								
1.8824	P420M	●	●			○	●	●	●										●	●	●								
1.8835	P420ML1	●	●				●	●	○										●	○	○								
1.8828	P420ML2	●	●				●	●	○										●	○	○								
1.8932	P420NH	●	●			●	●	●	●										●	●	●								
1.8936	P420QH	●	●			●	●	●	●										●	●	●								
1.8830	S420G1+M (+Q)	●	●			●	●	●	●										●	●	○								
1.8857	S420G2+M (+Q)	●	●			●	●	●	●										●	●	○								
1.8851	S420G3 (+M)	●	●			●	●	●	●										●	●	○								
1.8859	S420G4 (+M)	●	●			●	●	●	●										●	●	○								
1.8853	S420G5+Q	●	●			●	●	●	●										●	●	○								
1.8852	S420G6+Q	●	●			●	●	●	●										●	●	○								
1.8825	S420M	●	●			●	●	●	●										●	●	●								
1.0980	S420MC	●	●			●	●	●	●										●	●	●								
1.8847	S420MH	●	●			●	●	●	●										●	●	●								
1.8836	S420ML	●	●			○	●	●	●										●	●	○								
1.8848	S420MLH	●	●			○	●	●	○										●	●	○								
1.8902	S420N	●	●			●	●	●	●										●	●	●								
1.0981	S420NC	●	●			●	●	●	●										●	●	●								
1.8750	S420NH	●	●			●	●	●	●										●	●	●								
1.8912	S420NL	●	●			○	●	●	●										●	●	○								

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG														WIG								
		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2Ti/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo							W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo						
		OK AristoRod 12.50	OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09							OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09						
1.8751	S420NLH	●	●			○	●	●	○								●	●	○						
1.0523	S430GP	●	●			●	●	●	●								●	●	●						
1.8975	L450MB (API 5L: X65)					●	●	●	●									●	●						
1.8952	L450QB (API 5L: X65)					●	●	●	●									●	●						
1.8826	P460M					●	●	●	●									●	●						
1.8837	P460ML1						●	●	○									●	○						
1.8831	P460ML2						●	●	○									●	○						
1.8905	P460N					●	●	●	●									●	●						
1.8935	P460NH					●	●	●	●									●	●						
1.8915	P460NL1						●	●	○									●	○						
1.8918	P460NL2						●	●	○									●	○						
1.8870	P460Q					●	●	●	●									●	●						
1.8871	P460QH					●	●	●	●									●	●						
1.8872	P460QL1						●	●	○									●	○						
1.8864	P460QL2						●	●	○									●	○						
1.8878	S460G1+M (+Q)					●	●	●	●									●	○						
1.8887	S460G2+M (+Q)					●	●	●	●									●	○						
1.8883	S460G3 (+M)					●	●	●	●									●	○						
1.8889	S460G4 (+M)					●	●	●	●									●	○						
1.8885	S460G5+Q					●	●	●	●									●	○						
1.8884	S460G6+Q					●	●	●	●									●	○						
1.8827	S460M					●	●	●	●									●	●						
1.0982	S460MC					●	●	●	●									●	●						
1.8849	S460MH					●	●	●	●									●	●						
1.8838	S460ML					○	●	●	●									●	○						
1.4850	S460MLH					○	●	●	○									●	○						
1.8901	S460N					●	●	●	●									●	●						
1.8953	S460NH					●	●	●	●									●	●						
1.8903	S460NL					○	●	●	●									●	○						
1.8956	S460NLH					○	●	●	○									●	○						
1.8908	S460Q					●	●	●	●									●	●						
1.8906	S460QL					○	●	●	●									●	○						
1.8916	S460QL1						○	○	○									○	○						
1.8977	L485MB (API 5L: X70)						○	○	○									○	○						
1.8955	L485QB (API 5L: X70)						○	○	○									○	○						
1.0438	BSt 500 S / B500N	●	●			○	●	●	●								●	○	●						
1.0466	BSt 500 M / B500G3	●	●			○	●	●	●								●	○	●						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		MAG																WIG									
		G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 42 4 M21 3Si1/G 38 3 C1 3Si1	G 38 3 M21 2Si/G 35 2 C1 2Si	G 38 3 M21 2Si/G 35 2 C1 2Si	G 46 4 M21 2Ti/G 42 3 C1 2Ti	G 46 4 M21 4Si1/G 42 3 C1 4Si1	G 46 3 M21 4Si1/G 42 2 C1 4Si1	G 46 2 M21 2Mo/G 38 0 C1 2Mo									W 38 3 W2Si	W 42 3 W3Si1	W 46 3 W4Si1	W 46 2 W2Mo							
		OK AristoRod 12.50	OK Autrod 12.51	OK AristoRod 12.57	OK Autrod 12.58	OK AristoRod 12.62	OK AristoRod 12.63	OK Autrod 12.64	OK AristoRod 13.09									OK Tigrod 12.60	OK Tigrod 12.61	OK Tigrod 12.64	OK Tigrod 13.09							
1.0420	GE200 (GS-38)						○	○	●										○	○	●							
1.0449	GS200						○	○	●										○	○	●							
1.0445	GE240 (GS-45)						○	○	●											○	●							
1.0455	GS240						○	○	●											○	●							
1.0558	GE300 (GS-60)								●												●							
1.1131	G17Mn5						○	○	●										○	○	●							
1.0440	GL-A (S235JRS1)	●	●		●		●	●												●								
1.0441	GL-A (S235JRS2)	●	●		●		●	●												●								
1.0442	GL-B (S235J0S)	●	●		●		●	●												●								
1.0474	GL-D (S235J2S2)	●	●		●		●	●												●								
1.0475	GL-D (S235J2S1)	●	●		●		●	●												●								
1.0476	GL-E (S235J4S)	●	●		●		●	●												●								
1.0513	GL-A 32 (S315G1S)	●	●		●		●	●												●								
1.0514	GL-D 32 (S315G2S)	●	●		●		●	●												●								
1.0515	GL-E 32 (S315G3S)	●	●		●		●	●												●								
1.0583	GL-A 36 (S355G1S)	●	●		●		●	●												●								
1.0584	GL-D 36 (S355G2S)	●	●		●		●	●												●								
1.0589	GL-E 36 (S355G3S)	●	●		●		●	●												●								
1.1151	C22E	●	●	●	●	●	●	●	●									●	●	●	●							
1.1158	C25E	●	●	●	●	●	●	●	●									●	●	●	●							
1.0528	C 30						○	○	●										○	○	●							
1.1178	C30E						○	○	●										○	○	●							
1.0501	C 35						○	○	●										○	○	●							
1.1181	C35E						○	○	●										○	○	●							
1.0511	C 40								●												●							
1.1186	C40E								●												●							
1.0503	C 45								●												●							
1.1191	C45E								●												●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		FCAW																										
Svařovací materiál / Základní materiál		Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138							
		T 42 2 Y N 2	T 35 Z Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	T 42 5 Z M M 2 H5	T 46 2 1Ni R M 3 / T 42 2 1Ni R C 1	T 46 2 P M 1 H10 / T 42 2 P C 1 H5	T 46 3 P C 2 H5	T 46 4 P M 1 H5	T 46 4 P C 1 H5	T 46 6 1,5Ni P C 1 H5	T 42 6 1Ni B M 1 H5	T 42 4 B M 3 H5 / T 42 4 B C 5 H5	T 50 6 1Ni P M 1 H5							
1.0252	L235	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0458	L235GA	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0345	P235GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0112	P235S	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0253	P235TR1	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0254	P235TR2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0114	S235J0	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0115	S235J0C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0117	S235J2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0119	S235J2C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0116	S235J2G3	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0120	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0122	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0039	S235JRH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0038	S235JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0021	S240GP	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0459	L245GA	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0418	L245MB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0457	L245NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0352	P245GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0111	P245NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0460	P250GH (C22.8)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0452	P255QL	○	○	○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●							
1.0971	S260NC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0425	P265GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0130	P265S	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0423	P265NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0453	P265NL	○	○	○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●							
1.0258	P265TR1	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0259	P265TR2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0023	S270GP	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0260	L275	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0487	P275NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0488	P275NL1	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●							
1.1104	P275NL2	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Základní materiál		FCAW																												
		T 42 2 Y N 2	T 35 Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	T 42 5 Z M M 2 H5	T 46 2 1Ni R M 3 /T 42 2 1Ni R C	T 46 2 P M 1 H10 / T 42 2 P C 1 H	T 46 3 P C 2 H5	T 46 4 P M 1 H5	T 46 4 P C 1 H5	T 46 6 1,5Ni P C 1 H5	T 42 6 1Ni B M 1 H5	T 42 4 B M 3 H5 / T 42 4 B C 5 H5	T 50 6 1Ni P M 1 H5								
	Svařovací materiál	Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138								
1.1100	P275SL	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●								
1.0143	S275J0	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0140	S275J0C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0149	S275J0H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0145	S275J2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0142	S275J2C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0138	S275J2H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0044	S275JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0128	S275JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.8818	S275M	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.8843	S275MH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.8819	S275ML	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●								
1.8844	S275MLH	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●								
1.0490	S275N	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0493	S275NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0491	S275NL	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●								
1.0497	S275NLH	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●								
1.0426	P280GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0477	P285NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0478	P285QH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0483	L290GA (API 5L: X42)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0429	L290MB (API 5L: X42)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0484	L290NB (API 5L: X42)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0050	E295 (St50-2)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0481	P295GH (17Mn4)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0436	P305GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0482	P310GH (19Mn5)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0437	P310NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0972	S315MC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0973	S315NC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0046	S320GP	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.0060	E335 (St60-2)	●						●	●										●	●									
1.0473	P355GH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.8821	P355M	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●								
1.8832	P355ML1	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●								

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		FCAW																								
		T 42 2 Y N 2	T 35 Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138					
		Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14															
1.8833	P355ML2	○		○	○	○	○	○	●	○	○	●	●	○	○	○	○	●	●	○	●					
1.0562	P355N	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0557	P355NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0565	P355NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0566	P355NL1	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●					
1.1106	P355NL2	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●					
1.8866	P355Q	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.8867	P355QH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0571	P355QH1	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.8868	P355QL1	○		○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●					
1.8869	P355QL2	○		●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	○	●					
1.8814	S355G1 (+N)			○	○				●			●				○	○	●	●	○	●					
1.8801	S355G2+N			○	○				●			●				○	○	●	●	○	●					
1.8802	S355G3+N			○	○				●			●				○	○	●	●	○	●					
1.8803	S355G4 (+M)			○	○				●			●				○	○	●	●	○	●					
1.8804	S355G5+M			○	○				●			●				○	○	●	●	○	●					
1.8805	S355G6+M			○	○				●			●				○	○	●	●	○	●					
1.8808	S355G7+M (+N)			○	○				●			●				○	○	●	●	○	●					
1.8810	S355G8+M (+N)			○	○				●			●				○	○	●	●	○	●					
1.8811	S355G9+M (+N)			○	○				●			●				○	○	●	●	○	●					
1.8813	S355G10+M (+N)			○	○				●			●				○	○	●	●	○	●					
1.8806	S355G11 (+M) (+N)			○	○				●			●				○	○	●	●	○	●					
1.8809	S355G12 (+M) (+N)			○	○				●			●				○	○	●	●	○	●					
1.1182	S355G13+N (+Q)			○	○				●			●				○	○	●	●	○	●					
1.1184	S355G14+N (+Q)			○	○				●			●				○	○	●	●	○	●					
1.1190	S355G15+N (+Q)			○	○				●			●				○	○	●	●	○	●					
1.0083	S355GP	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0554	S355J0C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0547	S355J0H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0577	S355J2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0579	S355J2C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0570	S355J2G3	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0576	S355J2H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0045	S355JR	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0551	S355JRC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		FCAW																							
		T 42 2 Y N 2	T 35 Z Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	T 42 5 Z M M 2 H5	T 46 2 1Ni R M 3 /T 42 2 1Ni R C	T 46 2 P M 1 H10 / T 42 2 P C 1 H	T 46 3 P C 2 H5	T 46 4 P M 1 H5	T 46 4 P C 1 H5	T 46 6 1,5Ni P C 1 H5	T 42 6 1Ni B M 1 H5	T 42 4 B M 3 H5 / T 42 4 B C 5 H5	T 50 6 1Ni P M 1 H5				
		Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138				
1.0596	S355K2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0594	S355K2C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0512	S355K2H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8823	S355M	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0976	S355MC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8845	S355MH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8834	S355ML	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●				
1.8846	S355MLH	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●				
1.0545	S355N	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0977	S355NC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0539	S355NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0546	S355NL	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●				
1.0549	S355NLH	○	○	●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●				
1.0070	E360 (St70-2)							●	●										●	●					
1.0499	L360GA (API 5L: X52)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0578	L360MB (API 5L: X52)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0582	L360NB (API 5L: X52)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8948	L360QB (API 5L: X52)	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0522	S390GP	○		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8973	L415MB (API 5L: X60)			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8972	L415NB (API 5L: X60)			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8947	L415QB (API 5L: X60)			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.0428	BSt 420 S / B420N	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8824	P420M			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8835	P420ML1			○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●				
1.8828	P420ML2			○	○	○	○	○	●	○	○	●	○	○	○	○	○	●	●	○	●				
1.8932	P420NH			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8936	P420QH			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				
1.8830	S420G1+M (+Q)			○	○				●			●				○	○	●	●	○	●				
1.8857	S420G2+M (+Q)			○	○				●			●				○	○	●	●	○	●				
1.8851	S420G3 (+M)			○	○				●			●				○	○	●	●	○	●				
1.8859	S420G4 (+M)			○	○				●			●				○	○	●	●	○	●				
1.8853	S420G5+Q			○	○				●			●				○	○	●	●	○	●				
1.8852	S420G6+Q			○	○				●			●				○	○	●	●	○	●				
1.8825	S420M			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●				

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		FCAW																												
		T 42 2 Y N 2	T 35 Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	T 42 5 Z M M 2 H5	T 46 2 1Ni R M 3 / T 42 2 1Ni R C 1	T 46 2 P M 1 H10 / T 42 2 P C 1 H5	T 46 3 P C 2 H5	T 46 4 P M 1 H5	T 46 4 P C 1 H5	T 46 6 1,5Ni P C 1 H5	T 42 6 1Ni B M 1 H5	T 42 4 B M 3 H5 / T 42 4 B C 5 H5	T 50 6 1Ni P M 1 H5							
		Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138							
1.0980	S420MC			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8847	S420MH			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8836	S420ML			●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●							
1.8848	S420MLH			●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●							
1.8902	S420N			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.0981	S420NC			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8750	S420NH			●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8912	S420NL			●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●							
1.8751	S420NLH			●	●	○	○	○	●	○	○	●	○	○	○	●	●	●	●	●	●							
1.0523	S430GP	○		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●							
1.8975	L450MB (API 5L: X65)			●						●	●		●	●	●	●	●	●			●							
1.8952	L450QB (API 5L: X65)			●						●	●		●	●	●	●	●	●			●							
1.8826	P460M			●						●	●		●	●	●	●	●	●			●							
1.8837	P460ML1			○						○	○		○	○	○	○	○	●			●							
1.8831	P460ML2			○						○	○		○	○	○	○	○	●			●							
1.8905	P460N			●						●	●		●	●	●	●	●	●			●							
1.8935	P460NH			●						●	●		●	●	●	●	●	●			●							
1.8915	P460NL1			○						○	○		○	○	○	○	○	●			●							
1.8918	P460NL2			○						○	○		○	○	○	○	○	●			●							
1.8870	P460Q			●						●	●		●	●	●	●	●	●			●							
1.8871	P460QH			●						●	●		●	●	●	●	●	●			●							
1.8872	P460QL1			○						○	○		○	○	○	○	○	●			●							
1.8864	P460QL2			○						○	○		○	○	○	○	○	●			●							
1.8878	S460G1+M (+Q)			○												○	○	●			●							
1.8887	S460G2+M (+Q)			○												○	○	●			●							
1.8883	S460G3 (+M)			○												○	○	●			●							
1.8889	S460G4 (+M)			○												○	○	●			●							
1.8885	S460G5+Q			○												○	○	●			●							
1.8884	S460G6+Q			○												○	○	●			●							
1.8827	S460M			●						●	●		●	●	●	●	●	●			●							
1.0982	S460MC			●						●	●		●	●	●	●	●	●			●							
1.8849	S460MH			●						●	●		●	●	●	●	●	●			●							
1.8838	S460ML			○						○	○		○	○	○	○	○	●			●							
1.4850	S460MLH			○						○	○		○	○	○	○	○	●			●							
1.8901	S460N			●						●	●		●	●	●	●	●	●			●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ / Svařovací materiál / Základní materiál		FCAW																						
		T 42 2 Y N 2	T 35 Z Z Y N 1	T 46 4 M M 2 H5	T 42 4 M M 3 H5	T 42 2 M M 1 / T 42 2 M C 1	T 42 2 M M 2 H5	T 42 3 B M 2 H5 / T 42 3 B C 2 H5	T 42 6 1Ni B M 1 H5	T 46 2 P M 1 / T 42 2 P C 1 H5	T 46 2 P M 2 H5/T 46 2 P C 1 H5	T 42 5 Z M M 2 H5	T 46 2 1Ni R M 3 / T 42 2 1Ni R C 1 H5	T 46 2 P M 1 H10 / T 42 2 P C 1 H5	T 46 3 P C 2 H5	T 46 4 P M 1 H5	T 46 4 P C 1 H5	T 46 6 1,5Ni P C 1 H5	T 42 6 1Ni B M 1 H5	T 42 4 B M 3 H5 / T 42 4 B C 5 H5	T 50 6 1Ni P M 1 H5			
		Coreshield 8	Coreshield 15	OK Tubrod 14.10	OK Tubrod 14.11	OK Tubrod 14.12	OK Tubrod 14.13	OK Tubrod 15.00	OK Tubrod 15.06	OK Tubrod 15.13	OK Tubrod 15.14	PZ 6104	PZ 6111	PZ 6113	PZ 6113-S	PZ 6114	PZ 6114-S	PZ 6116-S	PZ 6125	PZ 6130 HS	PZ 6138			
1.0440	GL-A (S235JRS1)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0441	GL-A (S235JRS2)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0442	GL-B (S235J0S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0474	GL-D (S235J2S2)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0475	GL-D (S235J2S1)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0476	GL-E (S235J4S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0513	GL-A 32 (S315G1S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0514	GL-D 32 (S315G2S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0515	GL-E 32 (S315G3S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.8840	GL-F 32 (S315G4S)			●	●				●			●			●	●	●	●	●		●			
1.0583	GL-A 36 (S355G1S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0584	GL-D 36 (S355G2S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.0589	GL-E 36 (S355G3S)	●		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●			
1.8841	GL-F 36 (S355G4S)			●	●				●			●			●	●	●	●	●		●			
1.0532	GL-A 40 (S390G1S)				●							●			●			●						
1.0534	GL-D 40 (S390G2S)				●							●			●			●						
1.0560	GL-E 40 (S390G3S)				●							●			●			●						
1.8842	GL-F 40 (S390G4S)				●							●			●			●						
1.0521	R200 (StSch 700)							●																
1.0524	R220 (StSch 800)							●																
1.0623	R260 (StSch 900A)							●																
1.0624	R260Mn (StSch 900B)							●																

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																										
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 2 AR S2Si	S 46 2 AB S2Mo	S 46 3 AB S2Mo	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni	
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47	
Drát		OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00	OK Tubrod 15.00	OK Tubrod 15.24	
Základní materiál																												
1.0252	L235	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0458	L235GA	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0345	P235GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0112	P235S	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0253	P235TR1	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0254	P235TR2	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0114	S235J0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0115	S235J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0117	S235J2	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0119	S235J2C	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0116	S235J2G3	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0120	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0122	S235JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0039	S235JRH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0038	S235JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0021	S240GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0459	L245GA	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0418	L245MB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0457	L245NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0352	P245GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0111	P245NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0460	P250GH (C22.8)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0452	P255QL		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.0971	S260NC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0425	P265GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0130	P265S	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0423	P265NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0453	P265NL		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.0258	P265TR1	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0259	P265TR2	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●	
1.0023	S270GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0260	L275	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0487	P275NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0488	P275NL1		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.1104	P275NL2		○	○					○	○	●		○		●	○	●		○	●	○	○	●	●	○	○	●	
1.1100	P275SL		○	○					○	○	●		○		●	○	●		○	●	○	○	●	●	○	○	●	
1.0143	S275J0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																									
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 Z AR S2Si	S 46 2 AB S2Mo	S 46 3 AB S2Mo	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47
Drát		OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00	OK Tubrod 15.00	OK Tubrod 15.24
Základní materiál																											
1.0140	S275J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0149	S275J0H	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0145	S275J2	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●
1.0142	S275J2C	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●
1.0138	S275J2H	○	●	●	○	○	○	○	●	●	●	○	●	●	●	●	●	○	●	●	●	●	●	●	●	●	●
1.0044	S275JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0128	S275JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8818	S275M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8843	S275MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8819	S275ML		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●
1.8844	S275MLH		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●
1.0490	S275N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0493	S275NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0491	S275NL		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●
1.0497	S275NLH		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●
1.0426	P280GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0477	P285NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0478	P285QH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0483	L290GA (API 5L: X42)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●
1.0429	L290MB (API 5L: X42)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●
1.0484	L290NB (API 5L: X42)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●
1.0050	E295 (St50-2)								●	●	●				●	●	●		●	●	●	●	●	●	●	●	●
1.0481	P295GH (17Mn4)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0436	P305GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0482	P310GH (19Mn5)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0437	P310NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0972	S315MC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0973	S315NC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0046	S320GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0060	E335 (St60-2)																		●	●	●	●	●	●		●	●
1.0473	P355GH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8821	P355M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8832	P355ML1		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●
1.8833	P355ML2		○	○					○	○	●		○		●	●	●		○	●	○	○	●	●	○	○	●
1.0562	P355N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0557	P355NB	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0565	P355NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																														
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 2 AR S2Si	S 46 2 AB S2Mo	S 46 3 AB S2Mo	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni1					
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47					
Drát				OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.20			OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20		OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00S	OK Tubrod 15.00S						
Základní materiál																																
1.0566	P355NL1		o	●					o	●	●		o		●	●	●		o	●	o	●	●	o	●	●					
1.1106	P355NL2		o	o					o	o	●		o		●	o	●		o	●	o	o	●	o	o	●					
1.8866	P355Q	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.8867	P355QH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0571	P355QH1	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.8868	P355QL1		o	●					o	●	●		o		●	●	●		o	●	o	●	●	●	o	●					
1.8869	P355QL2		o	o					o	o	●		o		●	●	●		o	●	o	o	●	●	o	●					
1.8814	S355G1 (+N)			●						●	●				●	●	●		●	●	●	●	●	●	●	●					
1.8801	S355G2+N										●						●						●	●		●					
1.8802	S355G3+N										●						●						●	●		●					
1.8803	S355G4 (+M)										●						●						●	●		●					
1.8804	S355G5+M										●						●						●	●		●					
1.8805	S355G6+M										●						●						●	●		●					
1.8808	S355G7+M (+N)										●						●						●	●		●					
1.8810	S355G8+M (+N)										●						●						●	●		●					
1.8811	S355G9+M (+N)										●						●						●	●		●					
1.8813	S355G10+M (+N)										●						●						●	●		●					
1.8806	S355G11 (+M) (+N)										●						●						●	●		●					
1.8809	S355G12 (+M) (+N)										●						●						●	●		●					
1.1182	S355G13+N (+Q)										●						●						●	●		●					
1.1184	S355G14+N (+Q)										●						●						●	●		●					
1.1190	S355G15+N (+Q)										●						●						●	●		●					
1.0083	S355GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0554	S355J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0547	S355J0H	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0577	S355J2	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0579	S355J2C	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0570	S355J2G3	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0576	S355J2H	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0045	S355JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0551	S355JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0596	S355K2	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0594	S355K2C	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.0512	S355K2H	o	●	●	o	o	o	o	●	●	●	o	●	●	●	●	●	o	●	●	●	●	●	●	●	●					
1.8823	S355M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.0976	S355MC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					
1.8845	S355MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●					

● = nejvhodnější přídavný svařovací materiál

o = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																														
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 Z AR S2Si	S 46 2 AB S2Mo	S 46 3 AB S2Mo	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni	
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47	
Drát				OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10		OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20		OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00	OK Tubrod 15.00		
Základní materiál																												
1.8834	S355ML		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.8846	S355MLH		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.0545	S355N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0977	S355NC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0539	S355NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	
1.0546	S355NL		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.0549	S355NLH		○	●					○	●	●		○		●	●	●		○	●	○	●	●	●	○	●	●	
1.0070	E360 (St70-2)																						○	○		○	○	
1.0499	L360GA (API 5L: X52)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●	
1.0578	L360MB (API 5L: X52)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●	
1.0582	L360NB (API 5L: X52)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●	
1.8948	L360QB (API 5L: X52)		●	●					●	●	●		●	●	●	●	●		●	●	●	●	●	●	●	●	●	
1.0522	S390GP				●	●		●		●	●	●	●	●	●	●	●	●	●	●		●	●	●	●	●	●	
1.8973	L415MB (API 5L: X60)																		●	●		●	●	●	●	●	●	
1.8972	L415NB (API 5L: X60)																		●	●		●	●	●	●	●	●	
1.8947	L415QB (API 5L: X60)																		●	●		●	●	●	●	●	●	
1.8824	P420M																		●	●		●	●	●	●	●	●	
1.8835	P420ML1																		○	●		○	●	●	○	●	●	
1.8828	P420ML2																		○	●		○	●	●	○	○	●	
1.8932	P420NH																		●	●		●	●	●	●	●	●	
1.8936	P420QH																		●	●		●	●	●	●	●	●	
1.8830	S420G1+M (+Q)																						●	●			●	
1.8857	S420G2+M (+Q)																						●	●			●	
1.8851	S420G3 (+M)																						●	●			●	
1.8859	S420G4 (+M)																						●	●			●	
1.8853	S420G5+Q																						●	●			●	
1.8852	S420G6+Q																						●	●			●	
1.8825	S420M																		●	●		●	●	●	●	●	●	
1.0980	S420MC																		●	●		●	●	●	●	●	●	
1.8847	S420MH																		●	●		●	●	●	●	●	●	
1.8836	S420ML																		○	●		○	●	●	○	●	●	
1.8848	S420MLH																		○	●		○	●	●	○	●	●	
1.8902	S420N																		●	●		●	●	●	●	●	●	
1.0981	S420NC																		●	●		●	●	●	●	●	●	
1.8750	S420NH																		●	●		●	●	●	●	●	●	
1.8912	S420NL																		○	●		○	●	●	○	●	●	
1.8751	S420NLH																		○	●		○	●	●	○	●	●	

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																												
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 Z AR S2Si	S 46 2 AB S2M	S 46 3 AB S2M	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni		
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47		
Drát				OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.20			OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20		OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00	OK Tubrod 15.00				
Základní materiál																														
1.0523	S430GP																		●	●		●	●	●	●	●	●		
1.8975	L450MB (API 5L: X65)																		●	●		●		●			●		
1.8952	L450QB (API 5L: X65)																		●	●		●		●			●		
1.8826	P460M																		●	●		●		●			●		
1.8837	P460ML1																		○	●		○		●			●		
1.8831	P460ML2																		○	●		○		●			●		
1.8905	P460N																		●	●		●		●			●		
1.8935	P460NH																		●	●		●		●			●		
1.8915	P460NL1																		○	●		○		●			●		
1.8918	P460NL2																		○	●		○		●			●		
1.8870	P460Q																		●	●		●		●			●		
1.8871	P460QH																		●	●		●		●			●		
1.8872	P460QL1																		○	●		○		●			●		
1.8864	P460QL2																		○	●		○		●			●		
1.8878	S460G1+M (+Q)																							●			●		
1.8887	S460G2+M (+Q)																							●			●		
1.8883	S460G3 (+M)																							●			●		
1.8889	S460G4 (+M)																							●			●		
1.8885	S460G5+Q																							●			●		
1.8884	S460G6+Q																							●			●		
1.8827	S460M																		●	●		●		●			●		
1.0982	S460MC																		●	●		●		●			●		
1.8849	S460MH																		●	●		●		●			●		
1.8838	S460ML																		○	●		○		●			●		
1.4850	S460MLH																		○	●		○		●			●		
1.8901	S460N																		●	●		●		●			●		
1.8953	S460NH																		●	●		●		●			●		
1.8903	S460NL																		○	●		○		●			●		
1.8956	S460NLH																		○	●		○		●			●		
1.8908	S460Q																		●	●		●		●			●		
1.8906	S460QL																		○	●		○		●			●		
1.8916	S460QL1																		○	○		○		●			○		
1.8977	L485MB (API 5L: X70)																		●										
1.8955	L485QB (API 5L: X70)																		●										

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování nelegovaných a nízkolegovaných ocelí (Re ≤ 485 MPa)

Typ		SAW																														
		S 35 0 MS S1	S 35 2 MS S1	S 35 4 AB S1	S 38 0 CS S1	S 42 A AR S1	S 35 A AR S1	S 38 0 MS S2	S 35 3 AB S2	S 38 4 AB S2	S 38 5 AB S2	S 46 0 AR S2	S 42 2 AR S2	S 38 2 MS S2Si	S 38 5 FB S2Si	S 38 4 AB S2Si	S 38 5 AB S2Si	S 42 Z AR S2Si	S 46 2 AB S2Mo	S 46 3 AB S2Mo	S 35 2 FB S3	S 46 3 AB S3	S 42 5 FB S3Si	S 46 6 FB S3Si	S 42 2 AB T3	S 42 4 AB T3	S 46 5 AB T3Ni					
Tavidlo		10.40	10.45	10.71	10.80	10.81	10.87	10.40	10.47	10.71	10.72	10.81	10.88	10.45	10.62	10.71	10.72	10.83	10.71	10.72	10.61	10.71	10.61	10.62	10.71	10.71	10.47					
Drát				OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10	OK Autrod 12.10		OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.20	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.22	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.30	OK Autrod 12.30	OK Autrod 12.32	OK Autrod 12.32	OK Tubrod 14.00	OK Tubrod 15.00						
Základní materiál																																
1.1151	C22E				○	○	○	○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.1158	C25E				○	○	○	○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0528	C 30								●	●	●				●	●	●		●	●	●	●	●	●	●	●	●					
1.1178	C30E								●	●	●				●	●	●		●	●	●	●	●	●	●	●	●					
1.0501	C 35																		●	●	●	●	●	●	●	●	●					
1.1181	C35E																		●	●	●	●	●	●	●	●	●					
1.0511	C 40																									●	●					
1.1186	C40E																									●	●					
1.0503	C 45																									●	●					
1.1191	C45E																									●	●					
1.0420	GE200 (GS-38)							○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0449	GS200							○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0445	GE240 (GS-45)							○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0455	GS240							○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0558	GE300 (GS-60)								●	●	●				●	●	●		●	●	●	●	●	●	●	●	●					
1.1131	G17Mn5							○	●	●	●	○	○	○	●	●	●	○	●	●	●	●	●	●	●	●	●					
1.0440	GL-A (S235JRS1)			●				●		●	○	●	○		●	○	○		●	○				○	●	●						
1.0441	GL-A (S235JRS2)			●				●		●	○	●	○		●	○	○		●	○				○	●	●						
1.0442	GL-B (S235J0S)			●				●		●	○	●	○		●	○	○		●	○				○	●	●						
1.0474	GL-D (S235J2S2)			●				●		●	○	●	○		●	○	○		●	○				○	●	●						
1.0475	GL-D (S235J2S1)			●				●		●	○	●	○		●	○	○		●	○				○	●	●						
1.0476	GL-E (S235J4S)			●				●		●	○		○		●	○	○			○				○								
1.0513	GL-A 32 (S315G1S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.0514	GL-D 32 (S315G2S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.0515	GL-E 32 (S315G3S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.8840	GL-F 32 (S315G4S)															●	○							●								
1.0583	GL-A 36 (S355G1S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.0584	GL-D 36 (S355G2S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.0589	GL-E 36 (S355G3S)							●		●	○	●	○		●	●	○		●	○				●	●	●						
1.8841	GL-F 36 (S355G4S)															●	○							●								
1.0532	GL-A 40 (S390G1S)															●	○							●								
1.0534	GL-D 40 (S390G2S)															●	○							●								
1.0560	GL-E 40 (S390G3S)															●	○							●								
1.8842	GL-F 40 (S390G4S)															●	○							●								

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování ocelí odolných atmosférické kozozi

		MMA						MAG						FCAW						SAW					
Typ							E 46 5 Z B 3 2						G 46 4 M21 Z 3Ni1Cu / G 42 0 C1 Z 3Ni1Cu						T 42 2 Z P C 1 H5 / T 46 2 Z P M 1 H					S A AB 1 67 AC H5				
Svařovací materiál / Základní materiál		OK 73.08						OK AristoRod 13.26						PZ 6112	OK Tubrod 14.01					**OK Flux 10.71**	OK Autrod 13.36		**OK Flux 10.81**	OK Autrod 13.36	
1.8945	S355J0WP	●						●						●	●					●				O	
1.8946	S355J2WP	●						●						●	●					●				O	
1.8958	S235J0W	●						●						●	●					●				●	
1.8959	S355J0W	●						●						●	●					●				O	
1.8960	S235JRW (WTSt 37-2)	●						●						●	●					●				●	
1.8961	S235J2W	●						●						●	●					●				●	
1.8962	9CrNiCuP3-2-4	●						●						●	●					●				O	
1.8963	S355J2G1W (S355J2W / WTSt52-3)	●						●						●	●					●				O	
1.8965	S355J2W	●						●						●	●					●				O	
1.8966	S355K2G1W (S355K2W)	●						●						●	●					●				O	
1.8967	S355K2W	●						●						●	●					●				O	

● = nejvhodnější přídavný svařovací materiál

O = použitelný přídavný svařovací materiál

Doporučení pro svařování vysokopevných ocelí (Re ≥ 485 MPa)

Typ		MMA										MAG					FCAW					SAW				
		E 50 6 Mn1Ni B 1 2 H5	E 55 6 Mn1NiMo B T 3 2 H	E 55 4 1,5NiMo B 4 2	E 50 4 Z B 4 2 H5	E 55 4 MnMo B 3 2 H5	E 62 4 Z B T 3 2 H5	E 69 4 Mn2NiCrMo B 4 2 H	E 89 6 Z B 32 H5			G 55 4 M mn3NiCrMo	G 69 4 M Mn3Ni1CrMo	G 79 3 M Mn4Ni2CrMo	G89 4 M Mn4Ni2CrMo		T 50 5 Mn1Ni B M 1 H5	T 69 4 Mn2NiMo M M 2 H5	T 69 4 2NiMo P M 2 H5	T 89 4 Z MM 3 H5		**S A FB 1 55 AC H5**	S 62 6 FB S3Ni1Mo	S 69 6 FB S3Ni2,5CrMo		
Základní materiál / Svařovací materiál		Filarc 88S	Filarc 98S	OK 73.46	OK 74.70	OK 74.78	OK 74.86	OK 75.75	OK 75.78			OK AristoRod 55	OK AristoRod 69	OK AristoRod 79	OK AristoRod 89		PZ 6145	OK Tubrod 14.03	OK Tubrod 15.09	Coreweld 89		**OK Flux 10.62**	OK Autrod 13.40	OK Autrod 13.43			
1.8977	L485MB (API 5L: X70)	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8955	L485QB (API 5L: X70)	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8873	P500Q	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8874	P500QH	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8875	P500QL1	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8865	P500QL2	●	●	○	○	○	○	○	●			●	○	○			○	○	○				●	●		
1.0984	S500MC	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8924	S500Q	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8909	S500QL	●	●	●	●	●	●	●	●			●	○	○			●	●	●				●	●		
1.8984	S500QL1	●	●	○	○	○	○	○	●			●	○	○			○	○	○				●	●		
1.0986	S550MC		●	●		●	●	●	●			●	●	○				●	●				●	●		
1.8904	S550Q		●	●		●	●	●	●			●	●	○				●	●				●	●		
1.8926	S550QL		●	●		●	●	●	●			●	●	○				●	●				●	●		
1.8986	S550QL1		●	○		○	○	○	●			●	○	○				○	○				●	●		
1.8978	L555MB (API 5L: X80)		○	○		○	●	●	●			●	●	○				●	●				●	●		
1.8957	L555QB (API 5L: X80)		○	○		○	●	●	●			●	●	○				●	●				●	●		
1.8969	S600MC						●	●	●				●	○				●	●				●	●		
1.8876	P620Q						●	●	●				●	○				●	●				●	●		
1.8877	P620QH						●	●	●				●	○				●	●				●	●		
1.8914	S620Q						●	●	●				●	○				●	●				●	●		
1.8927	S620QL						●	●	●				●	○				●	●				●	●		
1.8987	S620QL1						○	○	●				●	○				○	○				●	●		
1.8976	S650MC							●	●				●	●				●	●					●		
1.8879	P690Q							●	●				●	●				●	●					●		
1.8880	P690QH							●	●				●	●				●	●					●		
1.8890	P620QL							●	●				●	●				●	●					●		
1.8881	P690QL1							●	●				●	○				●	●					●		
1.8888	P690QL2							○	●				●	○				○	○					●		
1.8931	S690Q							●	●				●	●				●	●					●		
1.8928	S690QL							●	●				●	○				●	●					●		
1.8988	S690QL1							○	●				○	○				○	○					●		
1.8974	S700MC							●	●				●	●				●	●					●		
1.8940	S890Q								●						●					●						
1.8983	S890QL								●						●					●						
1.8925	S890QL1								●						●					●						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

K

Doporučení pro svařování ocelí pracujících za nízkých teplot (≤ - 60°C)

Označení			-	1.4316	1.4316	1.4316	1.4430	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 / 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							S A FB 1 55 AC H5	S 46 7 FB S2Ni2	S 46 8 FB S2Ni3		S A AF 2 56 54 DC	S 19 9 L	S 19 12 3 L		S A AF 2 55 53 MnNi DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625	
Svařovací materiál			OK Tubrod 15.25	Shield-Bright 308L X-tra	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-tra	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 NiCrMo-13	OK Autrod NiCrMo-3	
Základní materiál		Stránka v katalogu																								
		Pracovní teplota (°C)	-60	-80	-120	-196	-60 (-110)	-120	-60 (-196)							-90	-101			-196	-196			-196	-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					●	●	●												●			●	●	

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

Doporučení pro svařování materiálu pracujících za zvýšených teplot

Typ / Svařovací materiál / Základní materiál		MMA												MAG					WIG						
		E 55 4 1,5NiMo B 4 2	E Mo B 4 2 H5	E Mo B 3 2 H5	E CrMo1 B 4 2 H5	E CrMo1 B 4 2 H5	E CrMo2 B 3 2 H5	E CrMo2 B 4 2 H5	E CrMo5 B 4 2 H5	E CrMo5 B 4 2 H5	E CrMo5 B 4 2 H5	E CrMo91 B 4 2 H5		G MoSi	G CrMo1Si	G CrMo2Si			W MoSi	W CrMo1Si	W CrMo2Si	W CrMo5Si	W CrMo91		
		OK 73.46	Filarc KV2	OK 74.46	OK 76.16	OK 76.18	OK 76.26	OK 76.28	Filarc KV4L	OK 76.35	OK 76.98			OK AristoRod 13.09	OK AristoRod 13.12	OK AristoRod 13.22			OK Tigrod 13.09	OK Tigrod 13.12	OK Tigrod 13.22	OK Tigrod 13.32	OK Tigrod 13.38		
1.0345	P235GH (HI)		●	●										●					●						
1.0460	P250GH (C22.8)		●	●										●					●						
1.0425	P265GH (HII)		●	●										●					●						
1.0481	P295GH (17Mn4)	●	●	●										●					●						
1.0482	P310GH (19Mn5)	●	●	●										●					●						
1.0571	P355QH1	●	●	●										●					●						
1.8932	P420NH	●	●	●										●					●						
1.8936	P420QH	●	●	●										●					●						
1.8935	P460NH	●	●											●											
1.8871	P460QH	●	●											●											
1.7380	10CrMo9-10 (T/P22)						●	●								●				●					
1.7383	11CrMo9-10						●	●								●				●					
1.7375	12CrMo9-10						●	●								●				●					
1.7335	13CrMo4-5 (T/P11)				●	●									●					●					
1.7336	13CrMoSi5-5 (T/P11)				●	●									●					●					
1.6368	15NiCuMoNb5-6-4 (WB 36)	●	●																○						
1.5415	16Mo3 (T/P1)	○	●	●										●					●						
1.5403	17MnMoV6-4 (WB 35)	●	●																○						
1.6311	20MnMoNi4-5	●																							
1.7218	25CrMo4				●	●									●					●					
1.4903	X10CrMoVNb9-1 (T/P91)										●												●		
1.7362	X11CrMo5 (T/P5)								●	●												●			
1.7386	X11CrMo9-1 (T/P9)										●												●		
1.7362	X12CrMo5 (T/P5)								●	●												●			
1.7366	X16CrMo5-1								●	●												●			
Stahlguss für erhöhte Temperaturen nach EN 10213-2																									
1.0619	GP240GH (GS-C 25)		●	●										●					●						
1.0625	GP280GH		●	●										●					●						
1.7357	G17CrMo5-5				●	●									●					●					
1.7379	G17CrMo9-10						●	●								●					●				
1.5422	G18Mo5		●	●										●					●						
1.5419	G20Mo5		●	●										●					●						
1.7365	GX15CrMo5								●	●												●			

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiál

K

Doporučení pro svařování materiálu pracujících za zvýšených teplot

Typ / Tavidlo / Drát / Základní materiál		FCAW							SAW																				
		T Mo B M 2 H5	T MoL P M 2 H5	T MoL P M 2 H5	T CrMo1 P M 2 H5	T CrMo2 P M 2 H5			S Mo FB	S Mo FB	S Mo AB	S Mo AB	S Mo AR		S CrMo1 AB	S CrMo1 FB	S CrMo1 FB		S CrMo2 FB	S CrMo2 FB	S CrMo2 FB		S CrMo5 FB		S CrMo91 FB		S 62 6 FB S3Ni1Mo		
		PZ 6202	PZ 6222	Dual Shield MoL	Dual Shield CrMo1	Dual Shield CrMo2			10.61	10.62	10.71	10.72	10.81		10.47	10.61	10.62		10.61	10.62	10.63		10.63		10.62		10.62		
									OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.24	OK Autrod 12.24		OK Autrod 13.10 SC	OK Autrod 13.10 SC	OK Autrod 13.10 SC		OK Autrod 13.20 SC	OK Autrod 13.20 SC	OK Autrod 13.20 SC		OK Autrod 13.33		OK Autrod 13.35		OK Autrod 13.40		
1.0345	P235GH (HI)	●	●	●					●	●	●	●	●														●		
1.0460	P250GH (C22.8)	●	●	●					●	●	●	●	●														●		
1.0425	P265GH (HII)	●	●	●					●	●	●	●	●																
1.0481	P295GH (17Mn4)	●	●	●					●	●	●	●	●														●		
1.0482	P310GH (19Mn5)	●	●	●					●	●	●	●	●														●		
1.0571	P355QH1	●	●	●					●	●	●	●	●														●		
1.8932	P420NH								●	●	●	●	●														●		
1.8936	P420QH								●	●	●	●	●														●		
1.8935	P460NH									●	●	●	●														●		
1.8871	P460QH									●	●	●	●														●		
1.7380	10CrMo9-10 (T/P22)					●													●	●	●								
1.7383	11CrMo9-10					●													●	●	●								
1.7375	12CrMo9-10					●													●	●	●								
1.7335	13CrMo4-5 (T/P11)				●										●	●	●												
1.7336	13CrMoSi5-5 (T/P11)				●										●	●	●												
1.6368	15NiCuMoNb5-6-4 (WB 36)																										●		
1.5415	16Mo3 (T/P1)	●	●	●					●	●	●	●	●														○		
1.5403	17MnMoV6-4 (WB 35)																										●		
1.6311	20MnMoNi4-5																										●		
1.7218	25CrMo4				●										●	●	●												
1.4903	X10CrMoVNb9-1 (T/P91)																								●				
1.7362	X11CrMo5 (T/P5)																						●						
1.7386	X11CrMo9-1 (T/P9)																												
1.7362	X12CrMo5 (T/P5)																						●						
1.7366	X16CrMo5-1																						●						
1.0619	GP240GH (GS-C 25)	●	●	●					●	●	●	●	●																
1.0625	GP280GH	●	●	●					●	●	●	●	●																
1.7357	G17CrMo5-5				●										●	●	●												
1.7379	G17CrMo9-10					●													●	●	●								
1.5422	G18Mo5	●	●	●					●	●	●	●	●																
1.5419	G20Mo5	●	●	●					●	●	●	●	●																
1.7365	GX15CrMo5																						●						

● = nejvhodnější přídavný svařovací materiál
○ = použitelný přídavný svařovací materiál

Doporučení pro svařování žárovzdorných materiálů

		MMA								WIG					MAG						FCAW				SAW					
Označení dle EN		~1.494	~1.494	1.4551	~1.482	1.4842	1.4842	2.4807		~1.494	1.4842	1.4502	2.4806		~1.494	1.4829	1.4842	1.4502	2.4806		~1.494					~1.494			2.4806	
Typ		E 19 9 H B 2 2	E 19 9 H R 1 2	E 19 9 Nb 3 2	~E 22 12 R 1 2	E 25 20 R 1 2	E 25 20 B 4 2	E Ni 6182 (NiCr15Fe6Mn)		W 19 9 H	W 25 20	W Z 17 Ti	S Ni 6082 (NiCr20Mn3Nb)		G 19 9 H	G 22 12 H	G 25 20	G Z 17 Ti	S Ni 6082 (NiCr20Mn3Nb)		T Z 19 9 H P M 2 / C 2					S A AF 2 56 54 DC	S 19 9 H	SA AF 2 CrNi DC	S Ni 6082 (NiCr20Mn3Nb)		
Základní materiál \ Svařovací materiál		OK 61.25	OK 61.50	OK 61.81	OK 62.53	OK 67.13	OK 67.15	OK NiCrFe-3		OK Tigrod 308H	OK Tigrod 310	OK Tigrod 430Ti	OK Tigrod 19.85		OK Autrod 308H	OK Autrod 309Si	OK Autrod 310	OK Autrod 430Ti	OK Autrod NiCr-3		Shield-Bright 308H					**OK Flux 10.93**	OK Autrod 308H	**OK Flux 10.90**	OK Autrod NiCr-3		
1.4558	X2NiCrAlTi32-20							●					●						●										●	
1.4710	GX30CrSi7				○							●				○		●												
1.4712	X10CrSi6				○							●				○		●												
1.4713	X10CrAlSi7				○							●				○		●												
1.4720	X7CrTi12	○	○	○	○					○		●			○	○		●			○					○				
1.4724	X10CrAlSi13				○							●				○		●												
1.4729	GX40CrSi13				○							●				○		●												
1.4740	GX40CrSi17				○							●				○		●												
1.4742	X10CrAlSi18				○							●				○		●												
1.4745	GX40CrSi24				○	○	○				○					○	○													
1.4746	X8CrTi15				○	○	○				○					○	○													
1.4762	X10CrAlSi25					○	○				○						○													
1.4815	GX8CrNi19-10	●	●							●					●						●					●				
1.4818	X6CrNiSiNCe19-10				●																									
1.4821	X15CrNiSi25-4					○	○				○						○													
1.4825	GX25CrNi18-9				●											●														
1.4826	GX40CrNiSi22-9				●											●														
1.4827	GX8CrNiNb19-10	●	●	●						●					●						●					●				
1.4828	X15CrNiSi20-12				●	●	●				●					●	●													
1.4832	GX25CrNiSi20-14				●	●	●				●					●	●													
1.4833	X12CrNi23-13					●	●				●						●													
1.4835	X9CrNiSiNCe21-11-2				●																									

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiá

K

Doporučení pro svařování žárovzdorných materiálů

		MMA								WIG					MAG						FCAW			SAW					
Označení dle EN		~1.494	~1.494	1.4551	~1.482	1.4842	1.4842	2.4807		~1.494	1.4842	1.4502	2.4806		~1.494	1.4829	1.4842	1.4502	2.4806		~1.494				~1.494			2.4806	
Typ		E 19 9 H B 2 2	E 19 9 H R 1 2	E 19 9 Nb 3 2	~E 22 12 R 1 2	E 25 20 R 1 2	E 25 20 B 4 2	E Ni 6182 (NiCr15Fe6Mn)		W 19 9 H	W 25 20	W Z 17 Ti	S Ni 6082 (NiCr20Mn3Nb)		G 19 9 H	G 22 12 H	G 25 20	G Z 17 Ti	S Ni 6082 (NiCr20Mn3Nb)		T Z 19 9 H P M 2 / C 2			S A AF 2 56 54 DC	S 19 9 H	S A AF 2 CrNi DC	S Ni 6082 (NiCr20Mn3Nb)		
Svařovací materiál / Základní materiál		OK 61.25	OK 61.50	OK 61.81	OK 62.53	OK 67.13	OK 67.15	OK NiCrFe-3		OK Tigrod 308H	OK Tigrod 310	OK Tigrod 430Ti	OK Tigrod NiCr-3		OK Autrod 308H	OK Autrod 309Si	OK Autrod 310	OK Autrod 430Ti	OK Tigrod NiCr-3		Shield-Bright 308H			**OK Flux 10.93**	OK Autrod 308H	**OK Flux 10.90**	OK Autrod NiCr-3		
1.4840	GX15CrNi25-20					●	●				●						●												
1.4841	X15CrNiSi25-21					●	●				●						●												
1.4845	X8CrNi25-21					●	●				●						●												
1.4859	GX10NiCrNb32-20							●					●						●										
1.4861	X10NiCr32-20							●					●						●										
1.4876	X10NiCrAlTi32-21							●					●						●										
1.4877	X6NiCrNbCe32-27							●					●						●										
1.4878	X8CrNiTi18-10	●	●	●	●					●					●	●					●				●				
1.4885	X12CrNiMoNb20-15					●	●	●			●					●	●												
1.4893	X8CrNiSiN21-11				●																								
1.4912	X7CrNiNb18-10	●	●	●						●					●						●				●				
1.4940	X7CrNiTi18-10	●	●	●						●					●						●				●				
1.4948	X6CrNi18-10	●	●							●					●						●				●				
1.4949	X3CrNiN18-11	●	●							●					●						●				●				
1.4951	X6CrNi25-20					●	●				●							●											
1.4958	X5NiCrAlTi31-20							●					●						●										
1.4959	X8NiCrAlTi32-21							●					●						●										
1.4961	X8CrNiNb16-13							●					●						●										
1.4968	GX7CrNiNb16-13							●					●						●										
1.4981	X8CrNiMoNb16-16							●					●						●										
1.4988	X8CrNiMoVNb16-13							●					●						●										

● = nejvhodnější přídavný svařovací materiál

○ = použitelný přídavný svařovací materiá

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		MMA																													
		1.4316	1.4316	1.4316	1.4551	1.4551	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 L R 1 2	E 19 9 L R 1 2	E 19 9 L B 2 2	E 19 9 Nb R 1 2	E 19 9 Nb 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 Nb R 3 2	E 19 12 3 Nb B 4 2	E 18 8 Mn B 1 2	E 13 B 4 2	E 13 4 R 3 2	E 13 4 B 4 2 H5	E Z 16 6 B 4 2 H5	E 20 25 5 Cu N L R 3 2	E Ni 6182 (NiCr15Fe6Mn)	E Ni 6625 (NiCr22Mo9Nb)	E Ni 6059 (NiCr23Mo16)								
Základní materiál / Svařovací materiál		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 NiCrFe-3	OK NiCrMo-3	OK NiCrMo-13								
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	○	○	○	○	○	○	○	○	○	○	○	○	○	○																

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

K

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		MMA																														
		1.4316	1.4316	1.4316	1.4551	1.4551	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 L R 1 2	E 19 9 L R 1 2	E 19 9 L B 2 2	E 19 9 Nb R 1 2	E 19 9 Nb 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 Nb R 3 2	E 19 12 3 Nb B 4 2	E 18 8 Mn B 1 2	E 13 B 4 2	E 13 4 R 3 2	E 13 4 B 4 2 H5	E Z 16 6 B 4 2 H5	E 20 25 5 Cu N L R 3 2	E Ni 6182 (NiCr15Fe6M	E Ni 6625 (NiCr22Mo9N	E Ni 6059 (NiCr23Mo16									
Svařovací materiál / Základní materiál		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 NiCrFe-3	OK NiCrMo-3	OK NiCrMo-13									
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	X6CrNiT18-10	●	●	●	●	●	○	○	○	○	○	○	○	○																		
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	○	○	○	○	○									○																	

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		MAG															WIG													
		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	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	S Ni 6082 (NiCr20Mn3N				
Svařovací materiál / Základní materiál		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 NiCrMo-13	OK Autrod NiCrMo-3	OK Autrod NiCr-3					OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod NiCrMo-13	OK Tigrod NiCrMo-3	OK Tigrod NiCr-3				
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		●	●		●												●	●		●									

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

K

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		MAG															WIG												
		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	S Ni 6082 (NiCr20Mn3N				
Svařovací materiál / Základní materiál		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 NiCrMo-13	OK Autrod NiCrMo-3	OK Autrod NiCr-3					OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod NiCrMo-13	OK Tigrod NiCMo-3	OK Tigrod NiCr-3				
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	○	○	○	○		●	●	○								○	○	○	○		●	○							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		MAG															WIG													
		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	S Ni 6082 (NiCr20Mn3N				
Svařovací materiál / Základní materiál		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 NiCrMo-13	OK Autrod NiCrMo-3	OK Autrod NiCr-3					OK Tigrod 308LSi	OK Tigrod 316LSi	OK Tigrod 318Si	OK Tigrod 347Si	OK Tigrod 385	OK Tigrod 430Ti	OK Tigrod 16.95	OK Tigrod NiCrMo-13	OK Tigrod NiCrMo-3	OK Tigrod NiCr-3				
1.4512	X2CrTi12	o	o	o	o		●	●	o								o	o	o	o		●	o							
1.4513	X2CrMoTi17-1	o	o	o	o		●	●	o								o	o	o	o		●	o							
1.4520	X2CrTi17	o	o	o	o		●	●	o								o	o	o	o		●	o							
1.4521	X2CrMoTi18-2	o	o	o	o		●	●	o								o	o	o	o		●	o							
1.4526	X6CrMoNb17-1	o	o	o	o		●	●	o								o	o	o	o		●	o							
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	X6CrNiT18-10	●	o	o	●												●	o	o	●										
1.4547	X1CrNiMoCuN20-18-7					●				●	●											●			●	●					
1.4550	X6CrNiNb18-10	●	o	o	●												●	o	o	●										
1.4552	GX5CrNiNb19-11	●	o	o	●												●	o	o	●										
1.4559	GX7NiCrMoCuNb41-20									o	o														o	o					
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	o			o		o	o	o								o			o		o	o							

● = nejvhodnější přídavný svařovací materiál

o = použitelný svařovací materiál

K

Doporučení pro svařování korozivzdorných ocelí

		FCAW											SAW										
Označení dle EN		1.4316	1.4316	1.4316	1.4430	1.4430	1.4430	1.4370	1.4351	~1.4405				1.4316	1.4430	1.4576	1.4551			1.4316	1.4430	1.4576	1.4551	1.4519					
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 Mn M M 2	T 13 4 M M 2 H5	T Z 16 5 M M 2 H5			S A CS 2 57 53 DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	S A AF 2 56 54 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	S A AF 2 CrNi DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)	
Svařovací materiál / Základní materiál		Shield-Bright 308L X-tra	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-tra	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 NiCrMo-13	OK Autrod NiCrMo-3	
Stránka v katalogu		H 35	H 36	H 37	H 52	H 53	H 54	H 29	H 20	H 22			P	H 38	H 55	H 60	H 43			P	H 38	H 55	H 60	H 43	H 64		P	L	L	
1.4000	X6Cr13	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4001	X7Cr14	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4002	X6CrAl13	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4003	X2CrNi12	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4006	X12Cr13	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4008	GX7CrNiMo12-1							o	●																					
1.4011	GX12Cr12							o																						
1.4016	X6Cr17	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4021	X20Cr13							o																						
1.4024	X15Cr13							o																						
1.4027	GX20Cr14							o																						
1.4028	X30Cr13							o																						
1.4057	X17CrNi16-2									o																				
1.4107	GX8CrNi12								●																					
1.4113	X6CrMo17-1	o	o	o	o	o	o	o						o	o	o	o				o	o	o	o						
1.4120	X20CrMo13							o	●																					
1.4301	X5CrNi18-10	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4303	X4CrNi18-12	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4306	X2CrNi19-11	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4307	X2CrNi18-9	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4308	GX5CrNi19-10	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4309	GX2CrNi19-11	●	●	●	o	o	o							●	o	o	●				●	o	o	●						
1.4313	X3CrNiMo13-4								●	o																				
1.4317	GX4CrNi13-4								●	o																				
1.4318	X2CrNiN18-7	o	o	o										o			o				o				o					
1.4371	X2CrMnNiN17-7-5							●																						
1.4401	X5CrNiMo17-12-2				●	●	●								●	●						●	●		●					
1.4404	X2CrNiMo17-12-2				●	●	●								●	●						●	●		●					

● = nejvhodnější přídavný svařovací materiál

o = použitelný svařovací materiál

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		FCAW										SAW											
		1.4316	1.4316	1.4316	1.4430	1.4430	1.4430	1.4370	1.4351	~1.4405			1.4316	1.4430	1.4576	1.4551		1.4316	1.4430	1.4576	1.4551	1.4519			2.4607	2.4831	
Typ		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 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 Mn M M 2	T 13 4 M M 2 H5	T Z 16 5 M M 2 H5		S A CS 2 57 53 DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	S A AF 2 56 54 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	S A AF 2 CrNi DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)	
Základní materiál \ Svařovací materiál		Shield-Bright 308L X-tra	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-tra	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 NiCrMo-13	OK Autrod NiCrMo-3	
1.4405	GX4CrNiMo16-5-1									●																	
1.4406	X2CrNiMoN17-11-2				●	●	●							●	●					●	●		●				
1.4407	GX5CrNiMo13-4								●	○																	
1.4408	GX5CrNiMoNb19-11-2				●	●	●							●	●					●	●		●				
1.4409	GX2CrNiMo19-11-2				●	●	●							●	●					●	●		●				
1.4412	GX5CrNiMoNb19-11-3				●	●	●							●	●					●	●		●				
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																										

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

K

Doporučení pro svařování korozivzdorných ocelí

Označení dle EN		FCAW										SAW													
		1.4316	1.4316	1.4316	1.4430	1.4430	1.4430	1.4370	1.4351	~1.4405			1.4316	1.4430	1.4576	1.4551			1.4316	1.4430	1.4576	1.4551	1.4519					
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 Mn M M 2	T 13 4 M M 2 H5	T Z 16 5 M M 2 H5			S A CS 2 57 53 DC	S 19 9 L	S 19 12 3 L	S 19 12 3 Nb	S 19 9 Nb	S A AF 2 56 54 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	S A AF 2 CrNi DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)		
Základní materiál \ Svařovací materiál		Shield-Bright 308L X-tra	Shield-Bright 308L	OK Tubrod 15.30	Shield-Bright 316L X-tra	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 NiCrMo-13	OK Autrod NiCrMo-3		
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	X6CrNiT18-10	●	●	●	○	○	○						●	○	○	●			●	○	○	●						
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	○	○	○				○		○			○			○			○			○						

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

Doporučení pro svařování feriticko austenitických ocelí (Duplex / Super-Duplex)

		MMA						MAG			WIG			FCAW			SAW						
Označení dle EN		~1.4462	~1.4462	~1.4462	~1.4410	~1.4410		~1.4462	~1.4410		~1.4462	~1.4410		~1.4462	~1.4410	~1.4462		~1.4462	~1.4410			~1.4410	
Typ		E 22 9 3 N L R 3 2	E 22 9 3 N L R 1 2	E 22 9 3 N L B 2 2	E 25 9 4 N L R 3 2	E 25 9 4 N L B 4 2		G 22 9 3 N L / W 22 9 3 N	W 25 9 4 N L / G 25 9 4 N		W 22 9 3 N L	W 25 9 4 N L		T 22 9 3 N L P M 2 / C 2	~T 25 9 4 N L P M 2	T 22 9 3 N L M M 2		S A AF 2 56 54 DC	S 22 9 3 N L	S 25 9 4 N L		S A AF 2 56 64 DC	S 25 9 4 N L	
Svařovací materiál / Základní materiál		OK 67.50	OK 67.53	OK 67.55	OK 68.53	OK 68.55		OK Autrod 2209	OK Autrod 2509		OK Tigrod 2209	OK Tigrod 2509		OK Tubrod 14.2	OK Tubrod 15.3	OK Tubrod 14.2		**OK Flux 10.93**	OK Autrod 2209	OK Autrod 2509		**OK Flux 10.94**	OK Autrod 2509	
1.4162	X2CrMnNiN22-5-2	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4347	GX6CrNiN26-7	○	○	○	○	○		○	○		○	○		○	○	○			○	○			○	
1.4362	X2CrNiN23-4	○	○	○	○	○		○	○		○	○		○	○	○			○	○			○	
1.4410	X2CrNiMoN25-7-4				●	●			●			●				●				●			●	
1.4417	GX2CrNiMoN25-7-3	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4460	X3CrNiMoN27-5-2	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4462	X2CrNiMoN22-5-3	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4463	GX6CrNiMo24-8-2	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4467	X2CrMnNiMoN26-5-4				●	●			●			●				●				●			●	
1.4468	GX2CrNiMoN25-6-3				●	●			●			●				●				●			●	
1.4469	GX2CrNiMoN26-7-4				●	●			●			●				●				●			●	
1.4470	GX2CrNiMoN22-5-3	●	●	●	○	○		●	○		●	○		●	●	○			●	○			○	
1.4471	GX3CrNiMoWCuN27-6-3-1				●	●			●			●				●				●			●	
1.4477	X2CrNiMoN29-7-2				●	●			●			●				●				●			●	
1.4501	X2CrNiMoCuWN25-7-4				●	●			●			●				●				●			●	
1.4507	X2CrNiMoCuN25-6-3				●	●			●			●				●				●			●	
1.4515	GX2CrNiMoCuN26-6-3				●	●			●			●				●				●			●	
1.4517	GX2CrNiMoCuN25-6-3-3				●	●			●			●				●				●			●	
1.4573	GX3CrNiMoCuN24-6-5				●	●			●			●				●				●			●	
1.4593	GX3CrNiMoCuN24-6-2-3				●	●			●			●				●				●			●	

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

K

Doporučení pro svařování niklu a jeho slitin

			MMA							MAG							WIG							SAW						
Označení dle EN			2.4156	2.4807	2.4621	2.4609	2.4366			2.4607	2.4831	2.4806	2.4155	2.4377			2.4607	2.4831	2.4806	2.4155	2.4377				2.4607	2.4831	2.4806			
Typ			E Ni 2061 (NiTi 3)	E Ni 6182 (NiCr15Fe6Mn)	E Ni 6625 (NiCr22Mo9Nb)	E Ni 6059 (NiCr23Mo16)	E Ni 4060 (NiCu30Mn3Ti)			S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)	S Ni 6082 (NiCr20Mn3Nb)	S Ni 2061 (NiTi3)	S Ni 4060 (NiCu30Mn3Ti)			S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)	S Ni 6082 (NiCr20Mn3Nb)	S Ni 2061 (NiTi3)	S Ni 4060 (NiCu30Mn3Ti)			S A AF 2 55 53 MnNi DC	S Ni 6059 (NiCr23Mo16)	S Ni 6625 (NiCr22Mo9Nb)	S Ni 6082 (NiCr20Mn3Nb)			
Svařovací materiál / Základní materiál			OK Ni-1	OK NiCrFe-3	OK NiCrMo-3	OK NiCrMo-13	OK NiCu-7			OK Autrod NiCrMo-13	OK Autrod NiCrMo-3	OK Autrod NiCr-3	OK Autrod Ni-1	OK Autrod NiCu-7			OK Tigrod NiCrMo-13	OK Tigrod NiCrMo-3	OK Tigrod NiCr-3	OK Tigrod Ni-1	OK Tigrod NiCu-7			**OK Flux 10.90**	Ok Autrod NiCrMo-13	OK Autrod NiCrMo-3	OK Autrod NiCr-3			
W.-Nr.	Typ																													
2.4060		Ni 99,6	●										●							●										
2.4061	205	LC-Ni 99,6	●										●							●										
2.4062		Ni 99,4 Fe	●										●							●										
2.4066	200	Ni 99,2	●										●							●										
2.4068	201	LC-Ni 99	●										●							●										
2.4360	400	NiCu30Fe					●							●							●									
2.4361		LC-NiCu30Fe					●							●							●									
2.4365		G-NiCu30Nb					●							●							●									
2.4375	K-500	NiCu30Al					●							●							●									
2.4602	C-22	NiCr21Mo14W				●				●							●								●					
2.4605	59	NiCr23Mo16Al				●				●							●								●					
2.4610	C-4	NiMo16Cr16Ti				●				●							●								●					
2.4618	G	NiCr22Mo6Cu			●						●							●								●				
2.4619	G-3	NiCr22Mo7Cu			●						●							●								●				
2.4641		NiCr21Mo6Cu			●						●							●								●				
2.4660	20	NiCr20CuMo			●	●				●	●						●	●							●	●				
2.4669	X-750	NiCr15Fe7AlTi		●								●							●								●			
2.4694	751	NiCr16Fe7TiAl		●								●							●								●			
2.4816	600	NiCr15Fe		●	●						●	●						●	●								●	●		
2.4817	600L	LC-NiCr15Fe		●								●							●								●			
2.4819	C-276	NiMo16Cr15W				●				●							●								●					
2.4850	50+	NiCr20Fe14Mo11WN				●				●							●								●					
2.4856	625	NiCr22Mo9Nb			●						●							●								●				
2.4858	825	NiCr21Mo			●						●							●								●				
2.4867		NiCr6015		●								●							●								●			
2.4869		NiCr8020		●								●							●								●			
2.4951	75	NiCr20Ti		●								●							●								●			
2.4952	80A	NiCr20TiAl		●								●							●								●			

● = nejvhodnější přídavný svařovací materiál

Doporučení pro svařování mědi a jejích slitin

				MAG								WIG						MMA	
Označení dle EN				2.1006	2.1461	2.0921	2.0922	2.1367	2.0837	2.4377		2.1006	2.1461	2.0837	2.4377			2.4366	
Typ				CuSn1	CuSi3Mn1	CuAl7	S Cu 6327 (CuAl8Ni2Fe2Mn2)	S Cu 6338 (CuMn13Al8Fe3Ni2)	S Cu 7158 (CuNi30Mn1FeTi)	S Ni 4060 (NiCu30Mn3Ti)		S Cu 1898 (CuSn1)	S Cu 6560 (CuSi3Mn1)	S Cu 7158 (CuNi30Mn1FeTi)	S Ni 4060 (NiCu30Mn3Ti)			E Ni 4060 (NiCu30Mn3Ti)	
Svařovací materiál / Základní materiál				OK Autrod 19.12	OK Autrod 19.30	OK Autrod 19.40			OK Autrod 19.49	OK Autrod NiCu-7		OK Tigrod 19.12	OK Tigrod 19.30	OK Tigrod 19.49	OK Tigrod NiCu-7			OK NiCu-7	
Označení																			
CC331G	CuAl10Fe2-C	2.0940	G-CuAl10Fe				●												
CC332G	CuAl10Ni3Fe2-C	2.0970	G-CuAl9Ni				●	●											
CC333G	CuAl10Fe5Ni5-C	2.0975	G-CuAl10Ni				●	●											
CC334G	CuAl11Fe6Ni6-C	2.0980	G-CuAl11Ni				●	●											
CC380H	CuNi10Fe1Mn1-C	2.0815	G-CuNi10						●	●				●	●		●		
CC383H	CuNi30Fe1Mn1NbSi-C	2.0835	G-CuNi30						●	●				●	●		●		
CC761S	CuZn16Si4	2.0492	G-CuZn15Si4		●								●						
CC762S	CuZn25Al5Mn4Fe3-C	2.0598	G-CuZn25Al5		●								●						
CC764S	CuZn34Mn3Al2Fe1-C	2.0596	G-CuZn34Al2		●								●						
CC765S	CuZn35Mn2Al1Fe1-C	2.0592	G-CuZn35Al1		●								●						
CR008A	Cu-OF	2.0040	OF-Cu	●	○							●	○						
CR020A	Cu-PHC	2.0070	SE-Cu	●	○							●	○						
CR021A	Cu-HCP	2.0070	SE-Cu	●	○							●	○						
CR023A	Cu-DLP	2.0076	SW-Cu	●	○							●	○						
CR024A	Cu-DHP	2.0090	SF-Cu	●	○							●	○						
CW008A	Cu-OF	2.0040	OF-Cu	●	○							●	○						
CW020A	Cu-PHC	2.0070	SE-Cu	●	○							●	○						
CW021A	Cu-HCP	2.0070	SE-Cu	●	○							●	○						
CW023A	Cu-DLP	2.0076	SW-Cu	●	○							●	○						
CW024A	Cu-DHP	2.0090	SF-Cu	●	○							●	○						
CW109C	CuNi1Si	2.0853	CuNi1,5Si		●								●						
CW111C	CuNi2Si	2.0855	CuNi2Si		●								●						
CW112C	CuNi3Si1	2.0857	CuNi3Si		●								●						
CW119C	CuZn0,5	2.0205	CuZn0,5	●	○							●	○						
CW303G	CuAl8Fe3	2.0932	CuAl8Fe3			○	●												

● = nejvhodnější přídavný svařovací materiál
○ = použitelný svařovací materiál

K

Doporučení pro svařování mědi a jejích slitin

				MAG								WIG							MMA	
Označení dle EN				2.1006	2.1461	2.0921	2.0922	2.1367	2.0837	2.4377		2.1006	2.1461	2.0837	2.4377				2.4366	
Typ				CuSn1	CuSi3Mn1	CuAl7	S Cu 6327 (CuAl8Ni2Fe2Mn2)	S Cu 6338 (CuMn13Al8Fe3Ni2)	S Cu 7158 (CuNi30Mn1FeTi)	S Ni 4060 (NiCu30Mn3Ti)		S Cu 1898 (CuSn1)	S Cu 6560 (CuSi3Mn1)	S Cu 7158 (CuNi30Mn1FeTi)	S Ni 4060 (NiCu30Mn3Ti)				E Ni 4060 (NiCu30Mn3Ti)	
Svařovací materiál / Základní materiál				OK Autrod 19.12	OK Autrod 19.30	OK Autrod 19.40			OK Autrod 19.49	OK Autrod NiCu-7		OK Tigrod 19.12	OK Tigrod 19.30	OK Tigrod 19.49	OK Tigrod NiCu-7				OK NiCu-7	
Označení																				
CW304G	CuAl9Ni3Fe2	2.0971	CuAl9Ni3Fe2				●	●												
CW306G	CuAl10Fe3Mn2	2.0936	CuAl10Fe3Mn2				●													
CW307G	CuAl10Ni5Fe4	2.0966	CuAl10Ni5Fe4				●	●												
CW308G	CuAl11Fe6Ni6	2.0978	CuAl11Ni6Fe5				●	●												
CW350H	CuNi25	2.0830	CuNi25						●	●				●	●				●	
CW352H	CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn						●	●				●	●				●	
CW354H	CuNi30Mn1Fe	2.0882	CuNi30Mn1Fe						●	●				●	●				●	
CW403J	CuNi12Zn24	2.0730	CuNi12Zn24						●	●				●	●				●	
CW409J	CuNi18Zn20	2.0740	CuNi18Zn20						●	●				●	●				●	
CW500L	CuZn5	2.0220	CuZn5		●								●							
CW501L	CuZn10	2.0230	CuZn10		●								●							
CW502L	CuZn15	2.0240	CuZn15		●								●							
CW503L	CuZn20	2.0250	CuZn20		○								○							
CW504L	CuZn28	2.0261	CuZn28		○								○							
CW505L	CuZn30	2.0265	CuZn30		○								○							
CW506L	CuZn33	2.0280	CuZn33		○								○							
CW507L	CuZn36	2.0335	CuZn36		○								○							
CW508L	CuZn37	2.0321	CuZn37		○								○							
CW509L	CuZn40	2.0360	CuZn40		○								○							
CW708R	CuZn31Si1	2.0490	CuZn31Si1		●								●							
CW716R	CuZn38Mn1Al	2.0510	CuZn37Al1		●								●							
CW719R	CuZn39Sn1	2.0530	CuZn38Sn1		●								●							
CW723R	CuZn40Mn2Fe1	2.0572	CuZn40Mn2		●								●							

● = nejvhodnější přídavný svařovací materiál

○ = použitelný svařovací materiál

Doporučení pro svařování hliníku a jeho slitin

Typ		MIG										WIG									
		S Al 1450 (Al99,5Ti)	S Al 4043 (AlSi5)	S Al 4047 (AlSi12)	S Al 5554 (AlMg2,7Mn)	S Al 5754 (AlMg3)	S Al 5356 (AlMg5Cr(A))	S Al 5183 (AlMg4,5Mn0,7(A))	S Al 5087 (AlMg4,5MnZr)	S Al 5556A (AlMg5Mn)		S Al 1450 (Al99,5Ti)	S Al 4043 (AlSi5)	S Al 4047 (AlSi12)	S Al 5554 (AlMg2,7Mn)	S Al 5754 (AlMg3)	S Al 5356 (AlMg5Cr(A))	S Al 5183 (AlMg4,5Mn0,7(A))	S Al 5087 (AlMg4,5MnZr)	S Al 5556A (AlMg5Mn)	
Přídavný materiál / Základní materiál		OK Autrod 1450	OK Autrod 4043	OK Autrod 4047	OK Autrod 5554	OK Autrod 5754	OK Autrod 5356	OK Autrod 5183	OK Autrod 5087	OK Autrod 5556		OK Tigrod 1450	OK Tigrod 4043	OK Tigrod 4047	OK Tigrod 5554	OK Tigrod 5754	OK Tigrod 5356	OK Tigrod 5183	OK Tigrod 5087	OK Tigrod 5556	
Označení ZM dle EN																					
EN AW-1050A	EN AW-Al 99,5	●										●									
EN AW-1070A	EN AW-Al 99,7	○										○									
EN AW-1080A	EN AW-Al 99,8(A)	○										○									
EN AW-1200	EN AW-Al 99,0	●										●									
EN AW-5005	EN AW-Al Mg1(B)					●	▲									●	▲				
EN AW-5005A	EN AW-Al Mg1(C)					●	▲									●	▲				
EN AW-5010	EN AW-Al Mg0,5Mn						▲										▲				
EN AW-5019	EN AW-Al Mg5						●	●	●	●							●	●	●	●	
EN AW-5049	EN AW-Al Mg2Mn0,8				●	▲	▲	▲	▲	▲					●	▲	▲	▲	▲	▲	
EN AW-5051A	EN AW-Al Mg2(B)					●	▲									●	▲				
EN AW-5083	EN AW-Al Mg4,5Mn0,7						○	●	●	●							○	●	●	●	
EN AW-5086	EN AW-Al Mg4						●	●	●	●							●	●	●	●	
EN AW-5149	EN AW-Al Mg2Mn0,8(A)				●	▲		▲	▲	▲					●	▲		▲	▲	▲	
EN AW-5454	EN AW-Al Mg3Mn				●	▲	▲	▲	▲	▲					●	▲	▲	▲	▲	▲	
EN AW-5754	EN AW-Al Mg3				●	●	●	○	○	○					●	●	●	○	○	○	
EN AW-6005A	EN AW-Al SiMg(A)		■	□		■	●	■	■	■			■	□		■	●	■	■	■	
EN AW-6060	EN AW-Al MgSi		■	□		■	●	■	■	■			■	□		■	●	■	■	■	
EN AW-6061	EN AW-Al Mg1SiCu		■	□			●	■	■	■			■	□			●	■	■	■	
EN AW-6063	EN AW-Al Mg0,7Si		■	□		■	●	■	■	■			■	□		■	●	■	■	■	
EN AW-6082	EN AW-Al Si1MgMn		■	□			●	■	■	■			■	□			●	■	■	■	
EN AW-7020	EN AW-Al Zn4,5Mg1						●	●	●	●							●	●	●	●	
AA 5059	"ALUSTAR"							○	●	●								○	●	●	

● = optimální řešení

○ = lze použít

■ = optimální řešení, v případě povrchové úpravy může dojít k rozdílné barvě povrchu

□ = lze použít, v případě povrchové úpravy může dojít k rozdílné barvě povrchu

▲ = lze použít, ale dojde ke zkoršení korozní odolnosti

Doporučení pro svařování hliníku a jeho slitin

		MIG-Drahtelektroden										WIG-Schweißstäbe									
Typ		S Al 1450 (Al99,5Ti)	S Al 4043 (AlSi5)	S Al 4047 (AlSi12)	S Al 5554 (AlMg2,7Mn)	S Al 5754 (AlMg3)	S Al 5356 (AlMg5Cr(A))	S Al 5183 (AlMg4,5Mn0,7(A))	S Al 5087 (AlMg4,5MnZr)	S Al 5556A (AlMg5Mn)		S Al 1450 (Al99,5Ti)	S Al 4043 (AlSi5)	S Al 4047 (AlSi12)	S Al 5554 (AlMg2,7Mn)	S Al 5754 (AlMg3)	S Al 5356 (AlMg5Cr(A))	S Al 5183 (AlMg4,5Mn0,7(A))	S Al 5087 (AlMg4,5MnZr)	S Al 5556A (AlMg5Mn)	
Přídavný materiál		OK Autrod 1450	OK Autrod 4043	OK Autrod 4047	OK Autrod 5554	OK Autrod 5754	OK Autrod 5356	OK Autrod 5183	OK Autrod 5087	OK Autrod 5556		OK Tigrod 1450	OK Tigrod 4043	OK Tigrod 4047	OK Tigrod 5554	OK Tigrod 5754	OK Tigrod 5356	OK Tigrod 5183	OK Tigrod 5087	OK Tigrod 5556	
Označení ZM dle EN																					
EN AC-42000	EN AC-Al Si7Mg		o	o									o	o							
EN AC-42100	EN AC-Al Si7Mg0,3		o	o									o	o							
EN AC-43000	EN AC-Al Si10Mg(a)			o										o							
EN AC-43100	EN AC-Al Si10Mg(b)			o										o							
EN AC-43200	EN AC-Al Si10Mg(Cu)			o										o							
EN AC-43300	EN AC-Al Si9Mg			o										o							
EN AC-44000	EN AC-Al Si11			●										●							
EN AC-44100	EN AC-Al Si12(b)			●										●							
EN AC-44200	EN AC-Al Si12(a)			●										●							
EN AC-45000	EN AC-Al Si6Cu4		●	o									●	o							
EN AC-46000	EN AC-Al Si9Cu3(Fe)			o										o							
EN AC-46200	EN AC-Al Si8Cu3			●										●							
EN AC-47000	EN AC-Al Si12(Cu)			●										●							
EN AC-51000	EN AC-Al Mg3(b)				o	●	●	o	o	o					o	●	●	o	o	o	
EN AC-51100	EN AC-Al Mg3(a)				o	●	●	o	o	o					o	●	●	o	o	o	
EN AC-51300	EN AC-Al Mg5						●	●	●	●							●	●	●	●	
EN AC-51400	EN AC-Al Mg5(Si)						●	●	●	●							●	●	●	●	

● = nejvhodnější přídavný svařovací materiál

o = použitelný svařovací materiál

Doporučení pro svařování hliníku a jeho slitin

ZM 1 \ ZM 2		AlSiMg	AlSiCu	AlZnMg	AlMgSi	AlMg5	AlMg3	AlMg (Mg<1%)	AlMn	Al
Al	M	4	4	5	4 / 5	5	4 / 5	4 / 5	4 / 5	4
	K	4	4	5	5	5	5	1	1	1
	S	4	4	5	4	5	4 / 5	4	4	4
AlMn	M	4	4	5	4 / 5	5	5	4	3 / 4	
	K	4	4	5	5	5	5	4	3	
	S	4	4	5	4	5	4	4	4	
AlMg (Mg<1%)	M	4	4	5	4 / 5	5	5	4		
	K	4	4	5	5	5	5	4		
	S	4	4	5	4	5	4	4		
AlMg3	M	4	4	5	5	5	5			
	K	4	4	5	5	5	5			
	S	4	4	5	4	5	5			
AlMg5	M	4	4	5	5	5				
	K	4	4	5	5	5				
	S	4	4	5	4	5				
AlMgSi	M	4	4	5	5 / 4					
	K	4	4	5	5					
	S	4	4	5	4					
AlZnMg	M	4	4	5						
	K	4	4	5						
	S	4	4	5						
AlSiCu	M	4	4							
	K	4	4							
	S	4	4							
AlSiMg	M	4								
	K	4								
	S	4								

M = optimální řešní z pohledu mechanických hodnot
K = optimální řešení pro zajištění dobré korozní odolnosti
S = optimální řešení z pohledu svařovacích vlastností

1 = S Al 1450 = OK Autrod / Tigrod 1450
3 = S Al 3103
4 = S Al 4043 = OK Autrod / Tigrod 4043
4 = S Al 4047 = OK Autrod / Tigrod 4047
5 = S Al 5754 = OK Autrod / Tigrod 5754
5 = S Al 5554 = OK Autrod / Tigrod 5554
5 = S Al 5356 = OK Autrod / Tigrod 5356
5 = S Al 5183 = OK Autrod / Tigrod 5183
5 = S Al 5087 = OK Autrod / Tigrod 5087
5 = S Al 5556 = OK Autrod / Tigrod 5556