



**SAF-FRO**

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# SAFDUAL

SAF-FRO FLUX AND METAL CORED WIRES



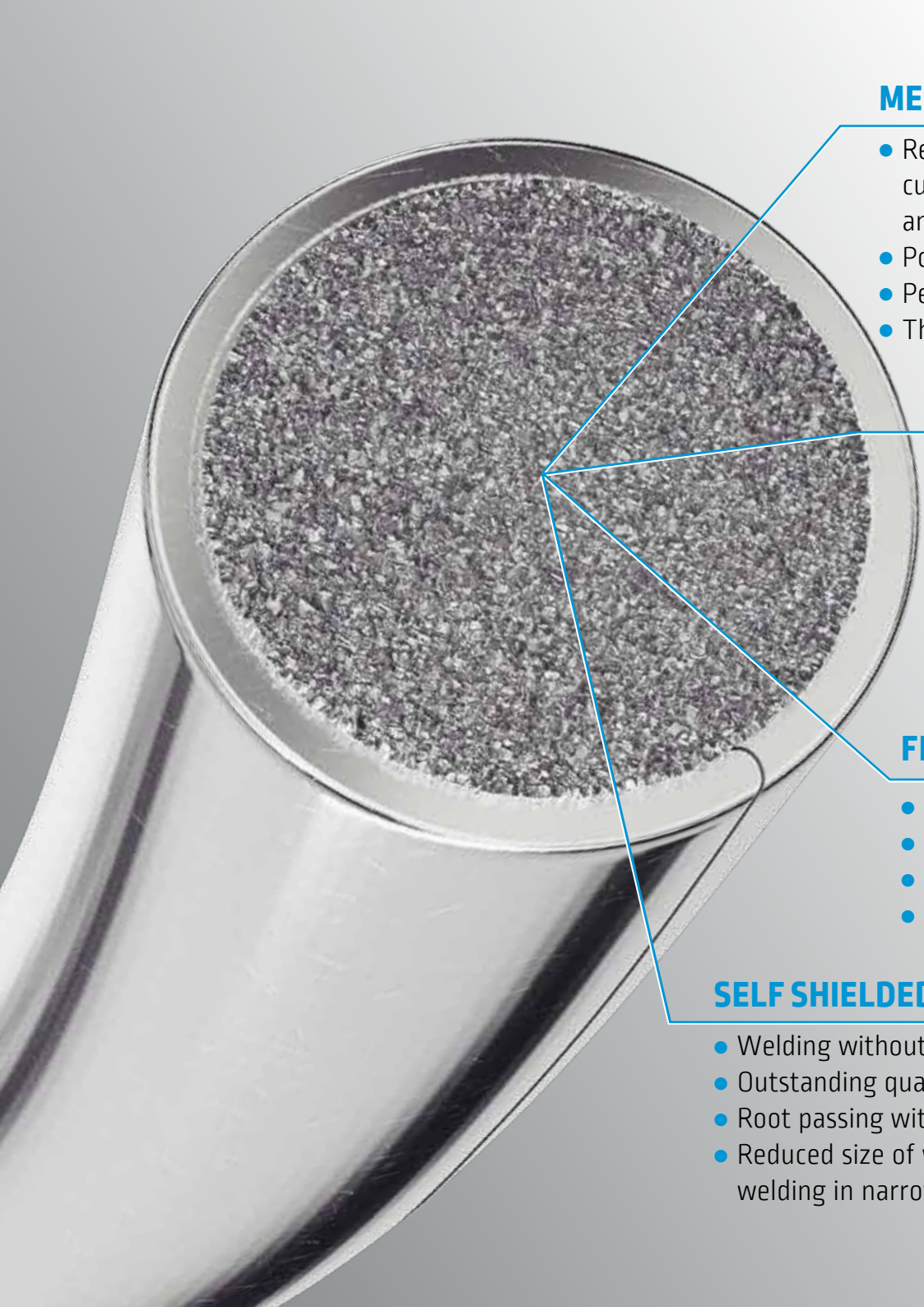
# SAFDUAL THE SAF-FRO CORED WIRE

Safdual flux and cored wires meet the highest industry weldability and reliability expectations through best in class manufacturing metal process, verified properties, metallurgy and responsible quality control process.



- Guaranteed diffusible hydrogen content.
- The highest deposition rate driven by optimal current density.
- Very consistent chemical composition.
- Well balanced yield and tensile strength.
- Impact down to  $-60^{\circ}\text{C}$ .
- Consumable and blend homogeneity.





### **METAL CORED [138]**

- Reduced welding cost in downhand positions cause of increased productivity, current density, superior quality of welds, tolerance of surface contamination, and easier welding combined reduced welders' training time.
- Positional and root passing capability with short and pulsed arc.
- Perfect for robotic and mechanized applications, regular slag free welds.
- The latest grades offer reduced welders' exposure to welding fumes.

### **FLUX CORED RUTILE [136]**

- Reduced welding cost in positional welding cause of high current density, quality of welds, tolerance of surface contamination, and easier welding combined with reduced welders' training time.
- The best solution for vertical up, slag supports the welding pool.
- Root passing with the ceramic backing.
- Suitable for robotic and mechanized applications, regular welds and self peeling slag.

### **FLUX CORED BASIC [136]**

- Superior mechanical properties cause of basic slag system.
- Root passing without or with ceramic backing
- All positional welding capability.
- Slag support when welding vertical up.

### **SELF SHIELDED [114]**

- Welding without shielding gas, outdoor applications
- Outstanding quality of welds in challenging environmental conditions.
- Root passing without and with ceramic backing.
- Reduced size of welding torch and long ESO enhance welding in narrow groves.

## Technical data

Product name	Note	Type	Gas	AWS A5.20/5.18/5.29	EN ISO 17632-A/18276-A /17634-A
<b>Mild Steels 275MPa&lt;Re&lt;460Mpa</b>					
SAFDUAL 100		R	M21/C1	E71T-1M-JH4 E71T-1C-H4"	T 42 3 P M 1 H5 T 42 2 P C 1 H5"
SAFDUAL R71		R	M21/C1	E71T-1/9M-H4 E71T-1/9C-H4"	T 46 2 P M 1 H10 T 42 2 P C 1 H10"
SAFDUAL 206A		MC	M21	E70C-6M-H8	T 42 2 M M 1 H5
STAR DUAL 206 HP	Reduced fume	MC	M21/14	E70C-6M-H8	T 42 3 M M 1 H5
SAFUNI 310	Self-shielded	N/A		E71T-7	T 42 Z Y 1 H15
SAFDUAL Zn	For Zn coat.	N/A	M21	E70C-GS	T3T Z M M 1 H15
<b>High Strength Steels 355MPa&lt;Re&lt;550MPa, impact at -40°C and -60°C</b>					
SAFDUAL 206	Impact at -40°C	MC	M21	E70C-6M-H4	T 46 4 M M 1 H5
SAFDUAL 200	Impact at -50°C	MC	M21	E70C-6M-H4	T 46 5 M M 1 H5
SAFDUAL 400	Impact at -50°C	B	M21/C1	E70T5-M/C-JH4	"T 42 5 B M 2 H5 T 42 5 B C 2 H5"
SAFDUAL 100 Ni	Impact at -40°C	R	M21/C1	E81T1-GM/C-H4	T 46 4 1Ni P M 1 H5 T 46 4 1Ni P C 1 H5"
SAFDUAL 128	Impact at -50°C	R	M21	E81T1-Ni1M-H4	T 46 5 1Ni P M 1 H5
<b>Hardfacing</b>					
SAFDUAL 560	57-60HRC	MC	M21	-	EN 14700: T Fe8

### CUSTOMER ASSISTANCE POLICY

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectriceurope.com](http://www.lincolnelectriceurope.com) for any updated information.

R: Rutile; B: Basic; MC: Metal Cored



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