

Alloy	Process	Product	Specifications		Page/s
			AWS	BS EN	

High toughness 1-3%Ni consumables for applications from -40°C down to about -75°C

1Ni	MMA	Tufmet 1 Ni.B	E8018-C3	E 46 6 1 Ni B 42	A54
	TIG/MIG	1Ni	ER80S-Ni1	(3Ni1)	
	FCW	Metcore DWA 55E	E71T-5	T 42 4 PM1 H5	
2Ni	MMA	Tufmet 2Ni.B	E8018-C1	E 46 6 2Ni B 42	A58
	TIG/MIG	2Ni	ER80S-Ni2	(2Ni2)	
3Ni	MMA	Tufmet 3Ni.B	E8018-C2	E 46 6 3Ni B 42	A61

Consumables for high strength low alloy steels requiring tensile strengths from 620MPa up to 825MPa

MnMo	MMA	E9018-D1	E9018-D1	BS: MnMo.Bh	A62
		E10018-D2	E10018-D2	E 624 MnM1NiMo B	
	TIG/MIG	MnMo	ER80S-D2	4Mo	
NiMo	MMA	Tufmet 1NiMo	E9016-G	--	A66
		E11018-M	E11018-M	--	
	Tufmet 3NiMo	E12016-G	--		
	TIG/MIG	ER110S-G	ER110S-G	Mn3Ni1CrMo	

Consumables for copper containing weathering steels eg. Corten

Corten	MMA	1NiCu.B	E8018-W2	E 55 18-NCC1 A	--
	TIG/MIG/SAW	ER80S-W	ER80S-G	(Mn3Ni1Cu)	

Electrode for the joining of rail steels using a slag-over-slag technique

Rail	MMA	Railrod	--	--	A72
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Black Point Power Station Hong Kong – regular users of Metrode Welding Consumables



Dockyard crane rails, typical application for Railrod electrodes