

The product data-sheets of the individual HILCO Welding Consumables contain a detailed description of each respective product. The data-sheets are subdivided as follows:

Product identification

Brandname: mentioning the typical name of the respective product

Product ID: in sequence process - steel grade - typical application (optional)

Standard designation: classification according to AWS/ASME (Section II part C), EN and DIN-EN Werkstoffnr. In case an EN standard does not exist the DIN standard is mentioned.

Typical characteristics of the product

Gives information about the specific product, the product properties and our recommendations for welding current, polarity, welding positions, approvals and arc voltage which is the voltage at which you can strike the arc of the stick electrodes. The different welding positions which according to AWS and EN are indicated by code digits are symbolized in the product data-sheet as follows:



AWS: 1G, 2G, 3G, 4G, 5G, 6G
EN: PA, PB, PC, PD, PE, PF, PG
"All positions"



AWS: 1G, 2G, 3G, 4G, 5Gu
EN: PA, PB, PC, PD, PE, PF
"All positions, except vertical down"



AWS: 1G, 1F, 2G, 2F
EN: PA, PB, PC
"Flatt butt and fillet welds only"

Application / properties

A written description of the typical characteristics of the specific product, base materials to be welded mentioning the most important base metals for which the consumable is intended and its typical applications. In case the base metal or application is not included in the product data-sheet, or if you have any questions on the subject, your local HILCO Distributor or HILCO's customer service desk and our Technical Service Department will be pleased to help you. Call HILCO at +31-(0)23-531 91 00, Fax +31-(0)23-532 59 06, email: hilco@-welding.com

Equivalent product in alternative welding process

HILCO offers you package solutions for the entire range of welding techniques for a large number of our products. These package solutions comprise HILCO Stick electrodes for SMAW, MIG/MAG Solid wires for GMAW, Cored wires for FCAW, TIG Solid wires for GTAW, Fluxes and wires for SAW, OAW Solid wires for Oxy-acetylene gas welding and brazing rods. The mentioned product indicates the first choice in an alternative welding process.

Chemical composition

The weld metal analysis (with the exception of SAW Solid wires) indicates the chemical composition of the deposit weld metal in weight % per element. The values indicated in the product data-sheets were determined by routine testing by our quality assurance department.

Mechanical properties

The specified mechanical properties are typical values and refer to all-weld metal. It must be taken into account that the mechanical properties of welded joints, depending on the base materials, dimensions of the component, welding position, welding parameters, preheating, interpass temperatures, post-weld-heat-treatment (PWHT), may deviate from those of the all-weld metal. The mechanical properties indicated in the product data-sheets are to be considered as general guidelines and they may vary according to the variations of product batches.

Disclaimer

The products and information in this handbook is based on today's knowledge about welding, welding techniques and product development. All technical data mentioned is not binding, alterations are possible at any time. If required please contact us for the latest developments.

© Hilarius Haarlem Holland BV – May 2010