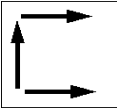
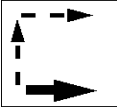
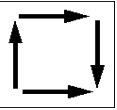
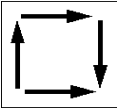
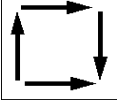
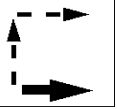

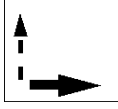


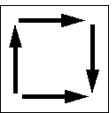
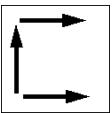
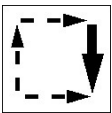
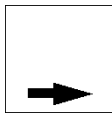
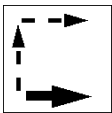
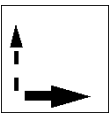
HILCO HARDMELT 620		
AWS A5.13: E Fe 5-B (mod.) EN 14700: E Fe4 DIN 8555: E 4-UM-60-ST	Rutile coated electrode for wear resistant surfacing tool steels subject to metal-to-metal wear at elevated temperatures up to 550°C. Deposit weld metal is a high speed steel (HSS). Hardness of pure weld metal is 62 HRc can be increased after tempering.	
HILCO HARDMELT 638		
EN 14700: E Z FeI4	Basic coated high efficiency (205%) electrode for wear resistant surfacing parts subject to grinding abrasion and moderate impact. Hardness of pure weld metal is 60 HRc.	
HILCO SUGARHARD		
EN 14700: E FeI4	Basic coated high efficiency (205%) electrode for roughening the wet mill rollers used in the sugar can crushing process. Hardness of pure deposit weld metal is 63 HRc.	
HILCO PURE NICKEL		
EN ISO 1071: E C Ni-CI I AWS A5.15: E Ni-CI	Basic coated electrode for cold welding grey and malleable cast iron grades and for joining these base metals to steel, copper and copper alloys. Recommended for usage on highly contaminated cast iron grades.	
HILCO NICKEL IRON		
EN ISO 1071: E C Ni Fe-I I AWS A5.15: E Ni Fe-CI	Basic coated electrode for repair, construction and production welding all commercial cast iron grades.	

ALUMINIUM ALLOYS

HILCO ALUMINIL Si5		
AWS A5.3: E 4043 EN ISO 18273: E Al 4043 (AlSi5) Werkstoffnr. 3.2245	The original all-purpose aluminium electrode for arc welding and brazing aluminium alloys containing up to 7% Si. Preheat at 150°C to 250°C thicker work-pieces prior to welding!	
HILCO ALUMINIL Si12		
EN ISO 18273: E Al 4047 (AlSi12) Werkstoffnr. 3.2585	Smooth welding aluminium electrode for welding aluminium castings, good colour match with base materials. Preheat thicker work-pieces prior to welding.	

COPPER ALLOYS

HILCO BRONSIL		
AWS A5.6: E CuSn-C (mod.) EN ISO 17777: Cu 5180B (CuSn7) Werkstoffnr. 2.1025	Basic coated tin-bronze electrode for joining and surfacing copper, copper alloys and bronze alloys. To be used for mechanical engineering and ship-building.	

Welding positions					
					
All positions	All positions, except vertical downwards	All positions, specifically in vertical down position	Flat butt and fillet welds only	Flat butt, fillet welds, limited vertical upwards and overhead	Flat butt and fillet welds, limited vertical upwards


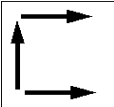
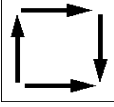
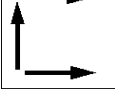
Other Hilco ready-to-weld consumables and accessories			
MIG/MAG welding wires for: <ul style="list-style-type: none">mild and high tensile steelslow alloy steelsstainless steelsaluminium & aluminium alloyscopper and copper alloys	TIG welding rods for: <ul style="list-style-type: none">mild and high tensile steelslow alloy steelsstainless steelsaluminium & aluminium alloyscopper and copper alloys	Accessories: <ul style="list-style-type: none">cutting and gouging electrodestungsten electrodeswelding cableswelding machinesabrasives	<ul style="list-style-type: none">oxy-acetylene gas welding rodsbrazing rods and fluxes for brazing

WELDING ELECTRODES


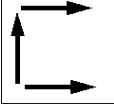
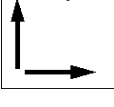
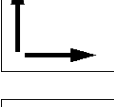
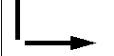


UN- AND LOW ALLOYED STEEL

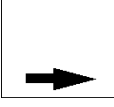

RUTILE COATED ELECTRODES

HILCO RED EXTRA		
AWS A5.1: E 6013 EN ISO 2560-A: E 42 0 RC 11	Universal electrode for all welding positions, including vertical down. This electrode is characterised by easy handling, smooth arc transfer, easy slag removal and a finely rippled bead surface. Especially suitable for construction work where the use of one single type of electrode is permissible.	
HILCO VELVETA		
AWS A5.1: E 6013 EN ISO 2560-A: E 42 0 RR 32	The quiet and easy controllable electrode, for smooth welding, especially vertical upwards. Designed for small diameter pipes, excellent X-ray quality. All-current type (AC/DC).	
HILCO BROWN		
AWS A5.1: E 6013 EN ISO 2560-A: E 42 0 RC 11	Fast freezing rutile coated electrode for all welding positions, especially vertical-down. Excellent for usage on rusty, primed and contaminated steels.	
HILCO VELORA		
AWS A5.1: E 6013 EN ISO 2560-A: E 42 0 RR 12	Slow freezing electrode for welding thin plate in downhand position. Spatter free type, less rework. Easy striking, even on transformers with low OCV, min. 42V.	

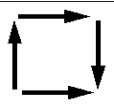
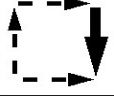
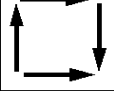
LOW HYDROGEN ELECTRODES

HILCO BASIC 55		
AWS A5.1: E 7016 EN ISO 2560-A: E 38 3 B 12 H10	Double coated rutile basic electrode for all position welding on both AC and DC current; except vertical down position. This electrode is characterised by easy handling, a well controllable arc, excellent root penetration, easy slag removal and excellent metallurgical properties up to -30°C.	
HILCO BASIC SUPER		
AWS A5.1: E 7018-I EN ISO 2560-A: E 42 5 B 32 H5	Universal low hydrogen electrode for all welding positions, except vertical down position. For applications where high demands on impact values (even at low temperatures, down to -40°C) are required. Operates on both AC and DC.	
HILCO BASIC		
AWS A5.1: E 7018-I EN ISO 2560-A: E 42 5 B 32 H5	General purpose low hydrogen electrode for all welding positions, except vertical down. Smooth, quiet arc, very low spatter: easy slag removal and excellent mechanical properties down to -50°C.	
HILCO B19CrMo		
AWS A5.5: E 8018-B2 H4 EN ISO 3580-A: E CrMo 1 B 32 H5	Basic-coated low hydrogen (HDM < 5 ml. / 100 gr: deposit weld metal) for welding low alloyed fine grain and creep resistant steels like 13CrMo4 5 up to a maximum operating temperature of 550°C.	
HILCO B20CrMo		
AWS A5.5: E 9018-B3 H4 EN ISO 3580-A: E CrMo 2 B 32 H5	Basic-coated low hydrogen (HDM < 5 ml. / 100 gr: deposit weld metal) electrode for welding Low alloyed fine grain and creep resistant steels like 10CrMo9.10 up to a maximum operating temperature of 600°C.	

HIGH EFFICIENCY ELECTRODES

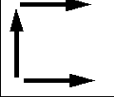
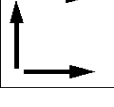
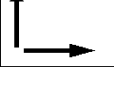
HILCO REGINA 150		
AWS A5.1: E 7024-I EN ISO 2560-A: E 42 2 RA 53	Rutile-acid coated (recovery 160%) electrode for making x-ray quality fillet welds in the flat and horizontal position. The electrode has a smooth quiet arc, very low spatter and easily removable slag (self-releasing even in narrow angles).	
HILCO REGINA 160		
AWS A5.1: E 7024-I EN ISO 2560-A: E 42 0 RR 53	Easy-to-handle high efficiency (recovery 160%) electrode for smooth fast fillet welding in the flat and horizontal position. An all-current type (AC/DC).	

CELLULOSE COATED ELECTRODES

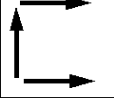
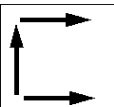

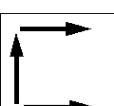
HILCO PIPEWELD 6010		
AWS A5.1: E 6010 EN ISO 2560-A: E 38 3 C 21	This electrode is recommended for all welding positions, particularly in vertical down and overhead position. Characterised by a deeply penetrating, forceful, spray type arc and readily removable slag.	
HILCO PIPEWELD 7010		
AWS A5.1: E 7010-PI EN ISO 2560-A: E 42 3 C 25	This electrode is recommended primarily for welding high-strenght pipe butt joints in the vertical down position. The electrode is characterised by a deeply penetrating, forceful, spray type arc and readily removable slag.	
HILCO E6011		
AWS A5.1: E 6011	Universal electrode for all welding positions. The electrode is characterised by a deeply penetrating, easy handling, forceful, spray type arc and readily removable slag. E6011 is the ideal choice for welding through light to medium amounts of dirty, rusty, painted or galvanized materials.	

STAINLESS STEEL

Corrosion and acid resistant

HILCO HILCHROME 308R		
AWS A5.4: E 308L-17 EN ISO 3581-A: E 19 9 L R 3 2 Werkstoffnr: 1.4316	Rutile coated electrode for welding low carbon 18Cr10Ni austenitic stainless steel grades like AISI 304, 304L. Typical applications include all industries where similar materials (incl. higher carbon types) as well as ferritic 13% Cr steels are used.	
HILCO HILCHROME 316R		
AWS A5.4: E316L-17 EN ISO 3581-A: E 19 12 3 L R 3 2 Werkstoffnr: 1.4430	Multi-purpose electrode for welding low carbon 17Cr12Ni3Mo austenitic acid resistant stainless steel grades like AISI 316, 316L. Universal in applications but typical for all industries where superior corrosion resistance is required.	
HILCO HILCHROME 347R		
AWS A5.4: E 347-17 EN ISO 3581-A: E 19 9 Nb R 3 2 Werkstoffnr: 1.4551	Stabilised electrode for welding low carbon 18Cr10NiNb (Cb) austenitic stainless steel grades like AISI 347, 321. Also suitable for unstabilised grades 304 and 304L. All-current type (AC/DC).	

REPAIR AND MAINTENANCE

HILCO HILCHROME 307R		
AWS A5.4: E 307-16 (mod.) EN ISO 3581-A: E 18 8 Mn R 12 Werkstoffnr: 1.4370	Rutile basic coated electrode for joining dissimilar steels and difficult-to-weld steels. Typical applications include joining 14Mn steels, spring steels, tool steels, and high carbon steels. This electrode is recommended for buffer layers prior to surfacing.	
HILCO HILCHROME 312R		
AWS A5.4: ~E312-17 EN ISO 3581-A: E 29 9 R 3 2 Werkstoffnr: 1.4337	Rutile coated electrode which is to be considered as a problem solver for all kinds of steel grades including stainless and difficult-to-weld steels. Typical applications for this WELD-ALL include joining hard manganese steels, tool steels, spring steels, buffering as well as joining dissimilar steel grades. The electrode deposits a crack-resistant weld metal with an increased ferrite content of approx. FN50.	
HILCO HILCHROME 309R		
AWS A5.4: E309L-17 EN ISO 3581-A: E 23 12 L R 3 2 Werkstoffnr: 1.4332	Rutile coated electrode for welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Typical applications include joining high-strength steels, un- and low alloyed heat treatable steels, stainless, ferritic chromium and austenitic chrome-nickel steels, austenitic manganese steels. The electrode suitable for joining clad steels.	
HILCO HILCHROME 309MoR		
AWS A5.4: E309MoL-17 EN ISO 3581-A: E 23 12 2 L R 3 2 Werkstoffnr: 1.4459	Rutile coated electrode for joining similar and dissimilar steels, buffering, joining hardenable and difficult-to-weld steels. Increased FN content ensuring maximum cracking resistance.	
HILCO HARDMELT 600		
EN 14700: E Fe8 DIN 8555 : E 6-UM-60	Basic coated electrode for wear resistant surfacing parts of steel, cast steel and high Mn-steel, subject to abrasion, metal-to-metal wear, impact and/or compression stress. Deposit can be machined by grinding only. Hardness of pure weld deposit approx. 600 HB.	