

## WELDING PROGRAMS

### STEEL

	OP	MAT	WIRE	GAS
Fe 0.6	100	Fe	0,6/0,024"	Ar+18%-25% CO <sub>2</sub>
Fe 0.8	-	Fe	0,8/0,030"	Ar+18%-25% CO <sub>2</sub>
Fe 1.0	-	Fe	1,0/0,039"	Ar+18%-25% CO <sub>2</sub>
Fe 1.2	-	Fe	1,2/0,045"	Ar+18%-25% CO <sub>2</sub>
OP	102	Fe	0,9/0,035"	Ar+18%-25% CO <sub>2</sub>
OP	110	Fe	0,6/0,024"	CO <sub>2</sub> 100%
OP	111	Fe	0,8/0,030"	CO <sub>2</sub> 100%
OP	112	Fe	0,9/0,035"	CO <sub>2</sub> 100%
OP	113	Fe	1,0/0,039"	CO <sub>2</sub> 100%
OP	130	Fe FC no GAS	0,9mm	No Gas
OP	131	Fe FC no GAS	1,1mm	No Gas
OP	132	Fe FC no GAS	1,2mm	No Gas
OP	133	Fe FC no GAS	1,6mm	No Gas
OP	174	Fe FC rutilc	1,2mm	Ar+18%-25% CO <sub>2</sub>
OP	194	Fe FC basic	1,2mm	Ar+18%-25% CO <sub>2</sub>

### STAINLESS STEEL

	OP	MAT	WIRE	GAS
SS0.8	-	Ss-316	0,8/0,030"	Ar+2% CO <sub>2</sub>
SS1.0	-	Ss-316	1,0/0,039"	Ar+2% CO <sub>2</sub>
OP	221	Ss-309	0,8/0,030"	Ar+2% CO <sub>2</sub>
OP	222	Ss-309	0,9/0,035"	Ar+2% CO <sub>2</sub>
OP	223	Ss-309	1,1mm	Ar+2% CO <sub>2</sub>
OP	244	Fc-316	1,2mm	Ar+18%-25% CO <sub>2</sub>

### ALUMINIUM

	OP	MAT	WIRE	GAS
Al 0.8	-	Al-5356	0,8/0,030"	Ar 100%
Al 1.0	-	Al-5356	1,0/0,039"	Ar 100%
Al 1.2	-	Al-5356	1,2/0,045"	Ar 100%
OP	303	Al-4043	1,0	Ar 100%
OP	304	Al-4043	1,2	Ar 100%

### SPECIAL

	OP	MAT	WIRE	GAS
OP	401	CuSi 3	0,8	Ar 100%
OP	403	CuSi 3	1,0	Ar 100%
OP	411	CuSi 3	0,8	Ar+2% CO <sub>2</sub>
OP	413	CuSi 3	1,0	Ar+2% CO <sub>2</sub>

## ROLLERS

MAT.	WIRE	REF.
Fe	0,6 - 0,8	55606
	1,0 - 1,2	55607
	1,2 - 1,6	55608
Al	1,0 - 1,2	55609
	1,2 - 1,6	55610
Tub	1,0 - 1,2	55611
	1,2 - 1,6	55613

