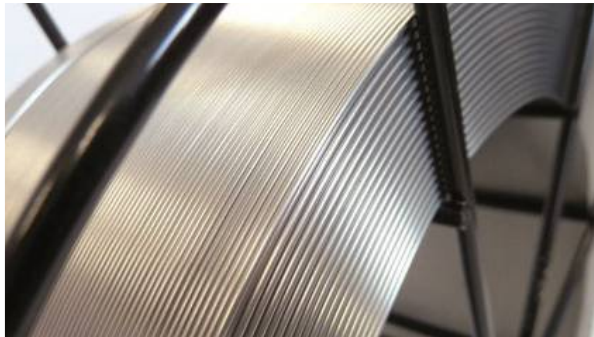
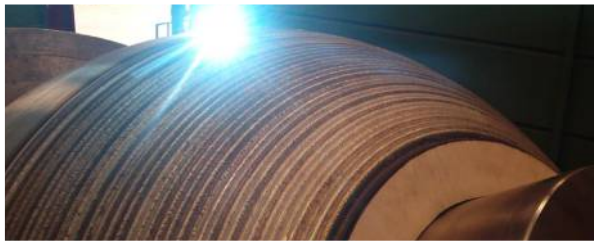


**DAIKO**<sup>®</sup>  
welding consumables

**HIGH QUALITY  
PRODUCTS  
FOR WELDING  
AND CLADDING**





## DAIKO WELDING CONSUMABLES

It has always been Nicros' policy to select the largest and most qualified world producers of special alloys creating a solid partnership with them. This choice has allowed to develop, through strict and rigorous testing, a wide range of welding and cladding consumables under DAIKO brand: covered electrodes, solid wires and flux cored wires, strips and fluxes .

In this large range of products, particular attention is paid to Corrosion Resistant Alloys (CRA) and, especially, nickel alloys whereof our Top Product Daiko SF 625 is the absolute protagonist.

Another strength of the company is the large stock that ensures customers fast delivery of supplies.

Nicros is today a reliable and punctual partner, qualified by major and prestigious customers worldwide in: oil & gas, chemical and petrochemical, pressure vessels, valves, and generally wherever reliable and high quality consumable products are required.



# NICKEL ALLOY **DAIKO SF 625**

The highest performance of our **DAIKO SF 625**, reached in many years of experience all around the world, are the best guarantees of a top quality product.

We ensure:

- analysis conforming to AwsA5.14, ERNiCrMo-3
- every batch made with strictly controlled chemical composition
- Fe content 0,3% max
- high quality weldability for all batches

**Daiko 625** is approved by the biggest worldwide users of 625 alloys, particularly where robot welding system applications are needed.

## DATA SHEET

## **DAIKO SF 625**

ERNiCrMo-3

**Available in:** Mig - Tig - Saw

**Specifications:** AWS A5.14      DIN 1736      EN ISO 18274  
ER NiCrMo-3      SG-NiCr21 Mo9Nb      Ni6625  
(2.4831)

**Approvals:** TÜV (Mig-Tig), CE

### Applications:

Daiko SF 625 is designed to match the composition and properties of 625. This alloy is used for the high temperature strength and structural stability and is also used for its resistance to general corrosion, pitting, crevice and stress corrosion cracking in severe chloride media. Useful proprieties from -269°C to above 1000°C are achieved.

It is used for welding of alloy 625, alloy 825, alloy 25-6MO, and a range of high alloy austenitic and super austenitic stainless steels. It is also used for surfacing of steel, for welding 9% Ni steels, and for welding various corrosion-resistant alloys such as alloy 20. Applications include furnace equipment, petrochemical and power generation plants and also overlays on pumps, valves and shafts in offshore and marine environments where high pitting resistance (PRE = 50) is essential. Widely used in oil & gas production and process.

### Typical composition %

C	Mn	Si	S	P	Cr	Ni	Mo	Nb+Ta	Cu	Al	Ti	Fe
0.02	0.02	0.10	0.005	0.005	22.0	65.0	9.0	3.50	0.05	0.20	0.20	<0.3

### TYPICAL PROPERTIES "AS WELDED"

tensile strength	750 N/mm2
0,2% proof stress	500 N/mm2
elongation on 4D.	38%
impact energy	at -196°C = 80J
PRE	50
hardness "as welded"	250 HV
hard drawn hardness	450 HV

**Shielding gas:** TIG: pure argon with back protection  
MIG: pure argon or mixture Ar + 25-50% He

### Complementary products:

**Smaw Electrode:** Daiko 112      AWS A5.11      ENiCrMo-3  
**Flux Cored Wire:** Daiko FCW 625P      AWS A5.34      ENiCrMo3T1-4  
**Strip:** Daiko Strip 625      AWS A5.14      EQNiCrMo-3  
**SAW Flux:** Daikoflux 982 - 626W - 960W - 961W  
**ESW Flux:** Daikoflux 940 - 944

### Packaging:

MIG	BS300	RANGE Ø 0,80 ÷ 1,60 mm	Kg 15-18
SAW	K415	RANGE Ø 2,00 ÷ 4,00 mm	Kg 25
ROD	CARTON BOX	RANGE Ø 1,20 ÷ 4,00 mm	Kg 5-10
TOURET	DIN760	RANGE Ø 1,00 ÷ 2,40 mm	Kg 150-250
DRUM		RANGE Ø 1,20 ÷ 1,60 mm	Kg 150-250

Other packaging available upon request.

# PRODUCTS RANGE

## NICKEL ALLOYS

ALLOY	NAME	PROCESS	AWS
625	Daiko SF 625	Mig - Tig - Saw	A5.14 - ERNiCrMo-3
	Daiko 112	Smaw	A5.11 - ENiCrMo-3
	Daiko FCW 625P	FCAW	A5.34 - ENiCrMo3T1-4
	Daiko Strip 625	Strip	A5.14 - EQNiCrMo-3
	Daiko 625-W	Mig - Tig - Saw	A5.14 - ERNiCrMo-20
82	Daiko SF 82	Mig - Tig - Saw	A5.14 - ERNiCr-3
	Daiko 182	Smaw	A5.11 - ENiCrFe-3
	G-Tech 840 (SX/B)	Smaw	A5.11 - ENiCrFe-3
	Daiko FCW 82	FCAW	A5.34 - ENiCr3T0-4
	Daiko Strip 82	STRIP	A5.14 - EQNiCr-3
C276	Daiko SF 276	Mig - Tig - Saw	A5.14 - ERNiCrMo-4
	Daiko C276	Smaw	A5.11 - ENiCrMo-4
	Daiko FCW C276	FCAW	A5.34 - ENiCrMo4T0-4
	Daiko Strip C276	Strip	A5.14 - EQNiCrMo-4
Alloy C	Daiko 1002C	Smaw	A5.11 - ENiCrMo-5
	Daiko 1002Co	Smaw	A5.11 - (ENiCrMo-5)
C22	Daiko SF 622	Mig - Tig - Saw	A5.14 - ERNiCrMo-10
	Daiko 122	Smaw	A5.11 - ENiCrMo-10
59	Daiko SF 59	Mig - Tig - Saw	A5.14 - ERNiCrMo-13
	Daiko 59K	Smaw	A5.11 - ENiCrMo-13
	Daiko Strip 59	Strip	A5.14 - EQNiCrMo-13
686	Daiko 686	Mig - Tig - Saw	A5.14 - ERNiCrMo-14
	Daiko 686k	Smaw	A5.11 - ENiCrMo-14
	Daiko Strip 686	Strip	A5.14 - EQNiCrMo-14
825	Daiko SF 825	Mig - Tig	A5.14 - ERNiFeCr-1
	Daiko 135	Smaw	A5.4 - (E383-15)
	Daiko Strip 825	Strip	A5.14 - EQNiFeCr-1
Weld-A	Daiko Weld A	Smaw	A5.11 - ENiCrFe-2
617	Daiko SF 617	Mig - Tig - Saw	A5.14 - ERNiCrCoMo-1
	Daiko 117	Smaw	A5.11 - ENiCrCoMo-1
718	Daiko SF 718	Mig -Tig	A5.14 - ERNiFeCr-2
Pure Nickel	Daiko 208	Mig - Tig	A5.14 - ERNi-1
	Daiko 141	Smaw	A5.11 - ENi-1
	Daiko Strip 208	Strip	A5.14 - EQNi-1
Monel 400	Daiko SF 418	Mig - Tig - Saw	A5.14 - ERNiCu-7
	Daiko 190	Smaw	A5.11 - ENiCu-7
	Daiko Strip 418	Strip	A5.14 - EQNiCu-7
CuNi 70-30	Daiko 413	Mig - Tig - Saw	A5.7 - ERCuNi
	Daiko 187	Smaw	A5.6 - ECuNi
	Daiko Strip 413	Strip	A5.7 - EQCuNi
CuNi 90-10	Daiko 412	Mig - Tig - Saw	DIN 1733 - SG-CuNi10Fe
690	Daiko SF 652	Mig - Tig - Saw	A5.14 - ERNiCrFe-7
	Daiko 152	Smaw	A5.11 - ENiCrFe-7
	Daiko SF 652M	Mig - Tig - Saw	A5.14 - ERNiCrFe-7A
	Daiko Strip 652M	Strip	A5.14 - EQNiCrFe-7A
92	Daiko 92	Mig - Tig	A5.14 - ERNiCrFe-6
601	Daiko 601	Mig - Tig	A5.14 - ERNiCrFe-11
B2	Daiko B2	Tig	A5.14 - ERNiMo-7
	Daiko B2	Smaw	A5.11 - ENiMo-7
36 INV	Daiko 36 INV	Mig - Tig - Saw	NO AWS
657	Daiko 657	Mig - Tig	A5.14 - ERNiCr-4
	G-Tech 657	Smaw	A5.11 - ENiCr-4
657M	Daiko 657M	Mig - Tig	A5.14 - ERNiCr-7

## DUPLEX • SUPERDUPLEX

ALLOY	NAME	PROCESS	AWS
2209	Daiko SF 2209	Mig - Tig - Saw	A5.9 - ER2209
	G-Tech 2209B	Smaw	A5.4 - E2209-15
	G-Tech 2209	Smaw	A5.4 - E2209-16
	G-Tech 2209R	Smaw	A5.4 - E2209-17
	Daiko MCW 2209	FCAW	A5.22 - EC2209
	Daiko FCW 2209P	FCAW	A5.22 - E2209T1-1/4
	Daiko FCW 2209	FCAW	A5.22 - E2209T0-1/4
2507	Daiko Strip 2209	Strip	A5.9 - EQ2209
	Daiko SF 2594	Mig - Tig - Saw	A5.9 - ER2594
	G-Tech 2594B	Smaw	A5.4 - E2594-15
	G-Tech 2594	Smaw	A5.4 - E2594-16
	Daiko FCW 2594P	FCAW	A5.22 - E2594T1-4
Zeron 100®	Daiko FCW 2594	FCAW	A5.22 - E2594T0-4
	Daiko Strip 2594	Strip	A5.9 - EQ2594
	Daiko SF 2594Cu	Mig - Tig - Saw	A5.9 - ER2594
2553	G-Tech 2595B	Smaw	A5.4 - E2595-15
	Daiko FCW 2595P	FCAW	A5.22 - E2594T1-4
	Daiko SF 2553	Mig - Tig - Saw	A5.9 - ER2553
2553	G-Tech 2553	Smaw	A5.4 - E2553-16
	Daiko FCW 2553	FCAW	A5.22 - (E2553T0-4)
	Daiko FCW 2553P	FCAW	A5.22 - (E2553T1-4)
	Daiko MCW 2553	FCAW	A5.22 - (EC2553)

## SUPERAUSTENIC STEELS

ALLOY	NAME	PROCESS	AWS
Alloy 20	Daiko 320LR	Mig - Tig	A5.9 - ER320LR
	G-Tech 320LR	Smaw	A5.4 - E320LR-15
904L	Daiko 385	Mig - Tig - Saw	A5.9 - ER385
	G-Tech 385B	Smaw	A5.4 - E385-15
	G-Tech 385	Smaw	A5.4 - E385-16
	Daiko FCW 904L	FCAW	A5.22 - NO AWS
	Daiko FCW 904LP	FCAW	A5.22 - NO AWS
	Daiko MCW 385	FCAW	A5.22 - EC385
310	Daiko Strip 385	FCAW	A5.9 - EQ385
	Daiko SF 310	Mig - Tig - Saw	A5.9 - ER310
	Daiko SF 310Mn	Mig - Tig	A5.9 - (ER310)
	G-Tech 310	Smaw	A5.4 - E310-16
	G-Tech 310B	Smaw	A5.4 - E310-15
	G-Tech 310Mn	Smaw	EN ISO 3581-A - E 25 20 R 32
	G-tech 310MnMo	Smaw	No AWS
Daiko FCW 310	FCAW	A5.22 - E310T0-1/4	
310H	Daiko Strip 310LMo	Daiko Strip 310LMo	A5.9 - (EQ310)
	G-Tech 310H	Smaw	A5.4 - E310H-15





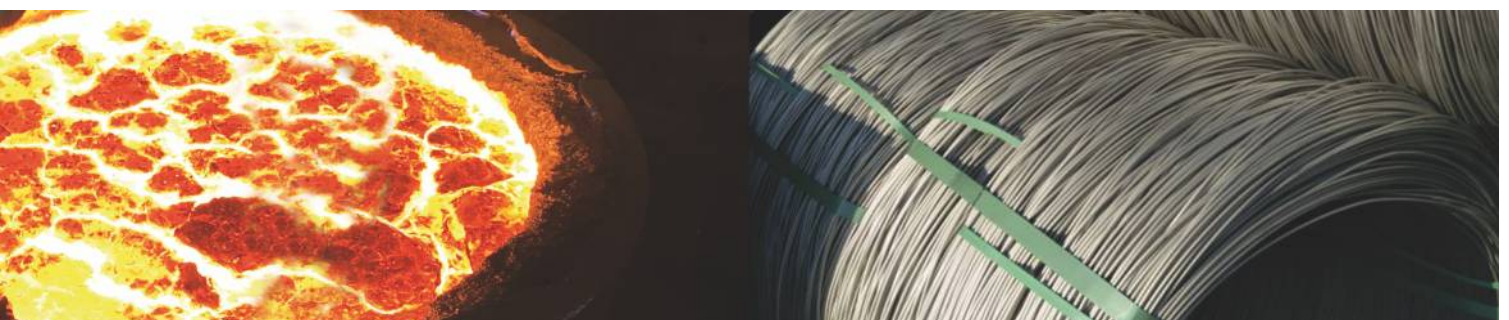
## FERRITIC • MARTENSITIC STAINLESS STEELS

ALLOY	NAME	PROCESS	AWS
409Nb	Daiko SF 409Nb	Mig - Tig - Saw	A5.9 - ER409Nb
410	Daiko 410 G-Tech 410B G-Tech 410HR G-Tech 410 Daiko FCW 410	Mig - Tig - Saw Smaw Smaw Smaw FCAW	A5.9 - ER410 A5.4 - E410-15 A5.4 - E410-26 A5.4 - E410-16 AWS A5.22 - E410T1-1/4
410NiMo	Daiko SF 410NiMo G-Tech 410NiMoB G-Tech 410NiMo Daiko FCW 410NiMo Daiko MCW 410NiMo	Mig - Tig - Saw Smaw Smaw FCAW FCAW	A5.9 - ER410 A5.4 - E410NiMo-15 A5.4 - E410NiMo-16 A5.22 - E410NiMoT1-1/4 A5.22 - EC410NiMo
420	Daiko 420B Daiko 420C	Mig-Tig-Saw Mig-Tig-Saw	AWS A5.9 - ER420 AWS A5.9 - (ER420)
430	Daiko SF 430 Daiko SF 430LNb Daiko SF 430LNbTi Daiko SF 430Ti G-Tech 430 G-Tech 430B Daiko MCW 430 Daiko Strip 430	Mig - Tig - Saw Mig - Tig - Saw Mig-Tig Mig-Tig Smaw Smaw FCAW Strip	AWS A5.9 - ER430 AWS A5.9 - (ER430) AWS A5.9 - (ER430) AWS A5.9 - (ER430) AWS A5.4 - E430-16 AWS A5.4 - E430-15 AWS A5.22 - NO AWS AWS A5.9 - EQ430
630 (17-4-PH)	Daiko 630 G-Tech 630 Daiko MCW 630	Mig - Tig - Saw Smaw FCAW	AWS A5.9 - ER630 AWS A5.4 - E630-16 AWS A5.22 - NO AWS
4122	Daiko 4122 G-Tech 4122	Mig - Tig - Saw Smaw	AWS A5.9 - NO AWS AWS A5.4 - NO AWS

## AUSTENITIC STAINLESS STEELS

ALLOY	NAME	PROCESS	AWS
308L	Daiko SF 308L Daiko SF 308LSi G-Tech 308LB G-Tech 308L G-Tech 308LR Daiko FCW 308LP Daiko FCW 308L Daiko Strip 308L	Mig - Tig - Saw Mig - Tig Smaw Smaw Smaw FCAW FCAW Strip	A5.9 - ER308L A5.9 - ER308LSi A5.4 - E308L-15 A5.4 - E308L-16 A5.4 - E308L-17 A5.22 - E308LT1-1/4 A5.22 - E308LT0-1/4 A5.9 - EQ308L
308LCF	Daiko 308LCF G-Tech 308LCF-15 G-Tech 308LCF-16 Daiko FCW 308LCF	Tig - Saw Smaw Smaw FCAW	A5.9 - ER308L A5.4 - E308L-15 A5.4 - E308L-16 A5.22 - E308LT1-1/4J
308H	Daiko 308H G-Tech 308HB G-Tech 308H Daiko FCW 308HP Daiko FCW 308H	Mig - Tig - Saw Smaw Smaw FCAW FCAW	A5.9 - ER308H A5.4 - E308H-15 A5.4 - E308H-16 A5.22 - E308HT1-1/4 A5.22 - E308HT0-1/4
316L	Daiko SF 316L Daiko SF 316LSi G-Tech 316LB G-Tech 316L G-Tech 316LR Daiko FCW 316LP Daiko FCW 316L Daiko Strip 316L	Tig - Saw Mig - Tig Smaw Smaw Smaw FCAW FCAW Strip	A5.9 - ER316L A5.9 - ER316LSi A5.4 - E316L-15 A5.4 - E316L-16 A5.4 - E316L-17 A5.22 - E316LT1-1/4 A5.22 - E316LT0-1/4 A5.9 - EQ316L
316LCF	Daiko 316LCF G-Tech 316LCF-15 G-Tech 316LCF-16 Daiko FCW 316LCF	Tig - Saw Smaw Smaw FCAW	A5.9 - ER316L A5.4 - E316L-15 A5.4 - E316L-16 A5.22 - E316LT1-1/4
316NF	Daiko 316MnNF G-Tech 316LMn-15 G-Tech 316LMn-16 Daiko FCW 316NF	Mig - Tig - Saw Smaw Smaw FCAW	A5.9 - ER316LMn A5.4 - (E316LMn-15) A5.4 - (E316LMn-16) A5.22 - (E316LT0-4)

316H	Daiko 316H G-Tech 316H	Mig - Tig - Saw Smaw	A5.9 - ER316H A5.4 - E316H-16
16.8.2	Daiko 16.8.2 G-Tech 16.8.2B G-Tech 16.8.2R Daiko FCW 16.8.2P Daiko FCW 16.8.2	Tig - Saw Smaw Smaw FCAW FCAW	A5.9 - ER16.8.2 A5.4 - E16.8.2-15 A5.4 - E16.8.2-17 A5.22 - (E16.8.2T1-1/4) A5.22 - (E16.8.2T0-1/4)
317L	Daiko SF 317L G-Tech 317L Daiko FCW 317P Daiko FCW 317 Daiko Strip 317L	Mig - Tig - Saw Smaw FCAW FCAW Strip	A5.9 - ER317L A5.4 - E317L-16 A5.22 - E317LT1-1/4 A5.22 - E317LT0-1/4 A5.9 - EQ317L
318	Daiko 318 Daiko 318Si G-Tech 318R Daiko FCW 318P	Mig - Tig - Saw Mig - Tig - Saw Smaw FCAW	A5.9 - ER318 A5.9 - (ER318) A5.4 - E318-17 A5.22 NO AWS
347	Daiko SF 347 Daiko SF 347Si G-Tech 347B G-Tech 347 Daiko FCW 347 Daiko Strip 347	Mig - Tig - Saw Mig - Tig Smaw Smaw FCAW Strip	A5.9 - ER347 A5.9 - ER347Si A5.4 - E347-15 A5.4 - E347-16 A5.22 - E347T0-1/4 A5.9 - EQ347
347H	Daiko SF 347H G-Tech 347HB G-Tech 347H Daiko FCW 347HP	Tig - Saw Smaw Smaw FCAW	A5.9 - ER347 A5.4 - E347-15 A5.4 - E347-16 A5.22 - E347T1-1/4
309L	Daiko SF 309L Daiko SF 309LSi G-Tech 309LB G-Tech 309L G-Tech 309LR Daiko FCW 309LP Daiko FCW 309L Daiko Strip 309L	Mig - Tig - Saw Mig - Tig Smaw Smaw Smaw FCAW FCAW Strip	A5.9 - ER309L A5.9 - ER309LSi A5.4 - E309L-15 A5.4 - E309L-16 A5.4 - E309L-17 A5.22 - E309LT1-1/4 A5.22 - E309LT0-1/4 A5.9 - EQ309L
309LMo	Daiko SF 309LMo G-Tech 309LMoB G-Tech 309LMoR Daiko FCW 309LMoP Daiko FCW 309LMo Daiko Strip 309LMo	Mig - Tig - Saw Smaw Smaw FCAW FCAW Strip	A5.9 - (ER309LMo) A5.4 - E309LMo-15 A5.4 - E309LMo-17 A5.22 - E309LMoT1-1/4 A5.22 - E309LMoT0-1/4 A5.9 - (EQ309LMo)
309LNb	G-Tech 309Nb Daiko Strip 309LNb	Smaw Strip	A5.4 - E309Cb-16 A5.9 - EQ309LNb
307	Daiko 307 Daiko 307Si G-Tech 307B G-Tech 307 Daiko FCW 307	Tig - Saw Mig - Tig Smaw Smaw FCAW	A5.9 - ER307 A5.9 - ER307Si A5.4 - E307-15 A5.4 - E307-17 A5.22 - (E307T0-1/4)
312	Daiko SF 312 G-Tech 312R G-Tech 312 Daiko FCW 312	Mig - Tig - Saw Smaw Smaw FCAW	A5.9 - ER312 A5.4 - E312-17 AWS A5.4 E312-16 A5.22 - E312T0-4



## CREEP RESISTING STEELS

ALLOY	NAME	PROCESS	AWS
0.5Mo	Daiko Mo.B	Mig - Tig	A5.28 - ER70S-A1
	Daiko Saw Mo.B	Saw	A5.23 - EA2
	G-Tech Mo.B	Smaw	A5.5 - E7018-A1
	Daiko FCW Mo.B	FCAW	A5.29 - E81T5-A1
	Daiko MCW Mo.B	FCAW	A5.28 - E80C-G
1¼Cr ½Mo	Daiko 1CrMo	Mig - Tig	A5.28 - ER80S-B2
	Daiko 1CrMoS	Mig - Tig	A5.28 - ER80S-G
	Daiko Saw 1CrMo	Saw	A5.23 - EB2
	G-Tech 1CrMo	Smaw	A5.5 - E8018-B2
	G-Tech 1CrMoL	Smaw	A5.5 - E7015-B2L
	Daiko FCW 1CrMoB	FCAW	A5.29 - E81T5-B2
	Daiko FCW 1CrMoR	FCAW	A5.29 - E81T1-B2
Daiko MCW 1CrMo	FCAW	AWS A5.28 - E80C-B2	
CrMoV	G-Tech 1CrMoV	Smaw	A5.5 - E9018-G
	Daiko FCW 1CrMoV	FCAW	A5.36 - E91T1-C1(M21)PZ-G
2¼Cr 1Mo	Daiko 2CrMo	Mig - Tig	A5.28 - ER90S-B3
	Daiko 2CrMoS	Mig - Tig	A5.28 - ER90S-G
	Daiko Saw 2CrMo	Saw	A5.23 - EB3
	G-Tech 2CrMo	Smaw	A5.5 - E9018-B3
	G-Tech 2CrMoL	Smaw	A5.5 - E8015-B3L
	Daiko FCW 2CrMo	FCAW	A5.29 - E91T5-B3
	Daiko FCW 2CrMoR	FCAW	A5.29 - E91T1-B3
Daiko MCW 2CrMo	FCAW	AWS A5.28 - E90C-B3	
5CrMo	Daiko 5CrMo	Mig - Tig	A5.28 - ER80S-B6
	Daiko Saw 5CrMo	Saw	A5.23 - EB6
	G-Tech 5CrMo	SMAW	A5.5 - E8015-B6 / E8016-B6
	Daiko FCW 5CrMo	FCAW	A5.29 - E81T1-B6 / B8
9CrMo	Daiko 9CrMo	Mig - Tig	A5.28 - ER80S-B8
	Daiko Saw 9CrMo	Saw	A5.23 - EB8
	G-Tech 9CrMo	Smaw	A5.5 - E8015-B8
	Daiko FCW 9CrMo	FCAW	A5.29 - E81T1-B8
9CrMoV	Daiko 9CrMoV	Tig	A5.28 - ER90S-B9
	Daiko Saw 9CrMoV	Saw	A5.23 - EB9
	G-Tech 9CrMoV	Smaw	A5.5 - E9015-B9
	Daiko FCW 9CrMoV	FCAW	A5.29 - E91T1-B9
	Daiko MCW 9CrMoV	FCAW	A5.28 - E90C-B9
10CrMoW	G-Tech 10CrMoW	Smaw	A5.5 - No AWS
	Daiko FCW 10CrMoW	FCAW	A5.29 - No AWS
9CrWV	Daiko 9CrWV	Tig	A5.28 - ER90S-G
	Daiko Saw 9CrWV	Saw	A5.23 - EG
	G-Tech 9CrWV	Smaw	A5.5 - E9015-G
	Daiko FCW 9CrWV	FCAW	A5.29 - E91T1-G
12CrMoV	Daiko 12CrMoV	Tig	A5.28 - No AWS
	G-Tech 12CrMoV	Smaw	A5.5 - No AWS

## HIGH TEMPERATURE ALLOYS

ALLOY	NAME	PROCESS	AWS
253MA	Daiko 22.12.HT	Mig - Tig - Saw	NO AWS
	G-Tech 253MA	Smaw	NO AWS
254 SMO®	G-Tech 20.18.6CuR	Smaw	NO AWS
800 / 800H	Daiko 21.33MnNb	Mig - Tig - Saw	NO AWS
	G-Tech 800Nb	Smaw	NO AWS
18-37 (HT-HU)	G-Tech 330H	Smaw	AWS A5.4 - (E330-15)
4830	G-Tech 25.24Nb	Smaw	NO AWS
HP10Cb	Daiko 25.35Nb	Mig - Tig - Saw	NO AWS
	G-Tech 25.35Nb	Smaw	NO AWS
HP40Nb	Daiko 25.35.4CNb	Mig - Tig - Saw	NO AWS
	G-Tech 25.35.4CNb	Smaw	NO AWS
35.45	Daiko 35.45Nb	Tig	NO AWS
	G-Tech 35.45Nb	Smaw	NO AWS
22H	G-Tech 50WCo	Smaw	NO AWS
	G-Tech 26.50.4W	Smaw	NO AWS



## CRYOGENIC STEELS

ALLOY	NAME	PROCESS	AWS
1Ni	Daiko 1Ni	Mig - Tig	AWS A5.28 - ER80S-Ni1
	Daiko 1Ni	Saw	AWS A5.23 - ENi1
	G-Tech 1Ni	Smaw	AWS A5.5 - E8018-C3
	Daiko FCW 1NiB	FCAW	AWS A5.29 - E81T5-Ni1
	Daiko FCW 1Ni	FCAW	AWS A5.36 - AWS A5.36 E81T1-M21A8-Ni1-H4
	Daiko MCW 1Ni	FCAW	AWS A5.36 - E80T15-M21A8-Ni1-H4
2Ni	Daiko 2Ni	Mig - Tig	AWS A5.28 - ER80S-Ni2
	Daiko 2Ni	Saw	AWS A5.23 - ENi2
	G-Tech 2Ni	Smaw	AWS A5.5 - E8018-C1
	Daiko FCW 2NiB	FCAW	AWS A5.29 - E81T5-Ni2
	Daiko FCW 2Ni	FCAW	AWS A5.29 - E81T5-Ni2
3Ni	Daiko 3Ni	Mig - Tig	AWS A5.28 - ER80S-Ni3
	Daiko 3Ni	Saw	AWS A5.23 - ENi3
	G-Tech 3Ni	Smaw	AWS A5.5 - E8018-C2

## HIGH STRENGTH STEELS

ALLOY	NAME	PROCESS	AWS
80-90ksi	Daiko D2	Mig - Tig	A5.28 - ER80S-D2
	Daiko SAW MnMo	Saw	A5.23 - EA3
	G-Tech 90G	Smaw	A5.5 - E9018-G
100ksi	Daiko NiMo	Mig - Tig	A5.28 - ER100S-G
	Daiko Saw S3NiMo	Saw	A5.23 - EF3
	G-Tech 109	Smaw	E10018-G
110ksi	Daiko 96	Mig - Tig	A5.28 - ER110S-G
	Daiko 700	SAW	A5.23 - EG
	G-Tech 96	SMAW	A5.5 - E11018-M
	Daiko FCW 115R	FCAW	A5.36 - E111T1
	Daiko FCW 115B	FCAW	A5.36 - E110T5
	Daiko MCW 115	FCAW	A5.36 - E110T15
	Daiko FCW 97	FCAW	A5.29 - E111T1-K3MJ
120ksi	Daiko 120	Mig - Tig	A5.28 - ER120S-G
	Daiko 900	SAW	A5.23 - EG
	G-Tech 120	SMAW	A5.5 - E12018-G
	Daiko FCW 120B	FCAW	A5.36 - E120T5
	Daiko MCW 120	FCAW	A5.36 - E120T15
130ksi	Daiko 4130	Mig - Tig - Saw	NO AWS

## ALLUMINIUM ALLOYS

ALLOY	NAME	PROCESS	AWS
Al	Daiko Al 99,5Ti	Mig - Tig	En18273 - S Al 1450
	Daiko Al 99,7	Mig - Tig	A5.10 - ER1070
	Daiko Al 99,8	Mig - Tig	A5.10 - ER1080
	G-Tech 99,8	SMAW	DIN 1732 - EL-Al 99,8
	Daiko Al 99Cu	Mig - Tig	A5.10 - ER1100
AlSi	Daiko AlSi5	Mig - Tig	A5.10 - ER4043
	G-Tech 605	SMAW	A5.3 - E4043
	Daiko AlSi12	Mig - Tig	A5.10 - ER4047
	G-Tech 601	SMAW	DIN 1732 - EL-AlSi 12
AlMg	Daiko AlMg3	Mig - Tig	A5.10 - ER5754
	Daiko AlMg5	Mig - Tig	A5.10 - ER5356
AlMgMn	Daiko AlMg4,5Mn	Mig - Tig	A5.10 - ER5183
AlMn	G-Tech AlMn	Smaw	DIN 1732 - EL-AlMn 1

## CARBON STEEL

ALLOY	NAME	PROCESS	AWS
Wire	Daiko SG1	Mig-Tig	A5.18 - ER70S-3
	Daiko SG2	Mig-Tig	A5.18 - ER70S-6
	Daiko SG3	Mig-Tig	A5.18 - ER70S-6
	Daiko 107Ti	Mig	A5.18 - ER70S-G
FCW	Daiko FCW 107Ti	FCAW	--
	Daiko FCW 102R	FCAW	A5.36 - E71T1
	Daiko FCW 107B	FCAW	A5.36 - E70T5
	Daiko MCW 107	FCAW	A5.36 - E70C6M
	Daiko FCW 107OP	FCAW	A5.36 - E71TGS
SMAW	G-Tech 101C	SMAW	A5.1 - E6010
	G-Tech 102C	SMAW	A5.1 - E7010-G
	G-Tech 101	SMAW	A5.1 - E6013
	G-Tech 102	SMAW	A5.1 - E6013
	G-Tech 103	SMAW	A5.1 - E6013
	G-Tech 102HR	SMAW	A5.1 - E7024
	G-Tech 107	SMAW	A5.1 - E7016
	G-Tech 107B	SMAW	A5.1 - E7018.1
	G-Tech 108	SMAW	A5.1 - E7018
	G-Tech 107HR	SMAW	A5.1 - E7028
SAW	Daiko S2	SAW	A5.23 - EM12k
	Daiko S2Si	SAW	A5.23 - EM12k
	Daiko S3Si	SAW	A5.23 - EH12k
	Daiko S4	SAW	A5.23 - EH14
CORTEN	Daiko 66	Mig Tig	A5.28 - ER80S-G
	G-Tech 57B	SMAW	A5.5 - E8018-W2
	Daiko FCW 66R	FCAW	A5.36 - E81T1
	Daiko FCW 66B	FCAW	A5.36 - E80T5
	Daiko MCW 66	FCAW	A5.36 - E80T15
	Daiko SAW 66	SAW	A5.23 - EG

## CAST IRON

ALLOY	NAME	PROCESS	AWS
Ni CI	Daiko 99	Mig - Tig	AWS A5.15 - ERNi-CI
	G-Tech 99	Smaw	AWS A5.15 - ENi-CI
	Daiko 324	Mig - Tig	AWS A5.14 - ERNI-1
	G-Tech 324	Smaw	AWS A5.15 - ENi-CI
NiFe-CI	Daiko 55	Mig - Tig	AWS A5.15 - ERNiFe-CI
	G-Tech 55	Smaw	AWS A5.15 - ENiFe-CI
	G-Tech 323	Smaw	AWS A5.15 - ENiFe-CI
	G-Tech 323S	Smaw	AWS A5.15 - ENiFe-CI
	Daiko FCW 55	FCAW	AWS A5.15 - NO AWS
	Daiko FCW 321	FCAW	AWS A5.15 - NO AWS
	Daiko FCW 345	FCAW	AWS A5.15 - NO AWS
	Daiko FCW 323S	FCAW	AWS A5.15 - NO AWS
NiFe-Cu	G-Tech 330Cu	Smaw	AWS A5.15 - (E NiCu - B)
	G-tech 306Cu	Smaw	AWS A5.15 - (E NiFe - CI)
Bimetal	G-Tech 305	Smaw	AWS A5.15 - ENiFe-CI
Fe-V	G-tech 301V	Smaw	AWS A5.15 - E S t



## COPPER ALLOYS

ALLOY	NAME	PROCESS	AWS
Cu	Daiko CuSn	Mig - Tig	A5.7 - ERCu
	G-Tech CuSn	Smaw	A5.6 - ECu
CuSi	Daiko CuSi3	Mig - Tig	A5.7 - ERCuSi-A
CuAg	Daiko CuAg	Mig - Tig	DIN 1733 - SG-CuAg
CuSn	Daiko CuSn6	Mig - Tig	A5.7 - ERCuSn-A
	G-Tech CuSn7	Smaw	A5.6 - ECuSn-C
	Daiko CuSn8	Mig - Tig	A5.7 - ERCuSn-C
	Daiko CuSn10	Mig - Tig	A5.7 - NO AWS
	Daiko CuSn12	Mig - Tig	A5.7 - NO AWS
CuAl	Daiko CuAl8	Mig - Tig - Saw	A5.7 - ERCuAl-A1
	G-Tech 401	Smaw	A5.6 - ECuAl-8
	Daiko CuAl9Fe	Mig - Tig - Saw	A5.7 - ERCuAl-A2
	G-Tech 405	Smaw	A5.6 - ECuAl-A2
CuAlNi	Daiko CuAl8Ni2	Mig - Tig	DIN 1733 - SG-CuAl8Ni2
	Daiko CuAl8Ni6	Mig - Tig	A5.7 - ERCuNiAl
CuMnAl	Daiko CuMn13Al	Mig - Tig	A5.7 - ERCuMnNiAl
	G-Tech 403	Smaw	A5.6 - ECuMnNiAl
CuNi 70-30	Daiko 413	Mig - Tig - Saw	A5.7 - ERCuNi
	Daiko 187	Smaw	A5.6 - ECuNi
	Daiko Strip 413	Strip	A5.7 - EQCuNi
CuNi 90-10	Daiko 412	Mig - Tig - Saw	DIN 1733 - SG-CuNi10Fe

## COBALT ALLOYS

ALLOY	NAME	PROCESS	AWS
Gr. 6	Daiko 1006LC	FCAW	A5.21 - ERCCoCr-A
	Daiko 1006	FCAW	A5.21 - ERCCoCr-A
	Daiko 1006	Tig	A5.21 - ERCoCr-A
	G-Tech 1006	Smaw	A5.13 - ECoCr-A
Gr. 12	Daiko 1008	FCAW	A5.21 - ERCCoCr-B
	Daiko 1008	Tig	A5.21 - ERCoCr-B
	G-Tech 1008	Smaw	A5.13 - ECoCr-B
Gr. 1	Daiko 1010	FCAW	A5.21 - ERCCoCr-C
	Daiko 1010	Tig	A5.21 - ERCoCr-C
	G-Tech 1010	Smaw	A5.13 - ECoCr-C
Gr. 21	Daiko 1021	FCAW	A5.21 - ERCCoCr-E
	Daiko 1021	Tig	A5.21 - ERCoCr-E
	G-Tech 1021	Smaw	A5.13 - ECoCr-E
Gr. 25	Daiko 1025	Tig	EN14700 - T Z Co (L 605)
	G-Tech 1025	Smaw	EN14700 - E Z Co1 (L 605)
Gr. 50	Daiko 1050	FCAW	A5.21 - ERNiCr-B (UMCO 50)

Other grades upon request

## TITANIUM ALLOYS

ALLOY	NAME	PROCESS	AWS
Gr. 1	Daiko Ti Gr. 1	Mig - Tig	A5.16 - ERTi-1
Gr. 2	Daiko Ti Gr. 2	Mig - Tig	A5.16 - ERTi-2
Gr. 5	Daiko Ti Gr. 5	Mig - Tig	A5.16 - ERTi-5
Gr. 7	Daiko Ti Gr. 7	Mig - Tig	A5.16 - ERTi-7
Gr. 12	Daiko Ti Gr. 12	Mig - Tig	A5.16 - ERTi-12



# FLUX

## A COMPLETE ASSORTMENT OF SAW/ESW FLUXES SUITABLE FOR EVERY KIND OF ALLOYS

	NAME	PROCESS	BASICITY	DESCRIPTION
C Steel	DAIKOFLUX 470-W	SAW	0,5	RUTILE FLUX FOR CARBON STEEL AND LOW ALLOY STEELS
	DAIKOFLUX 480-W	SAW	1,5	SEMI-BASIC FLUX FOR CARBON STEEL AND LOW ALLOY STEELS FOR GENERAL APPLICATION WITH EXCELLENT WELDING PERFORMANCE
	DAIKOFLUX 481-WP	SAW	1,4	SEMI-BASIC FLUX SPECIFIC FOR WELDING HIGH QUALITY STEEL PIPES FOR OIL&GAS INDUSTRIES
	DAIKOFLUX 490-W	SAW	3,1	BASIC FLUX FOR CARBON STEEL AND LOW ALLOY STEELS SUITABLE TO JOIN STRUCTURAL STEELS WITH HIGH RESISTANCE
	DAIKOFLUX 491-W	SAW	3	BASIC FLUX FOR CARBON STEEL AND LOW ALLOY STEELS FOR CRITICAL APPLICATIONS OF THICK SECTION MATERIALS WHEN THERE IS DEMAND ON HIGH IMPACT TOUGHNESS VALUES AT VERY LOW TEMP (-60° C)
	DAIKOFLUX 491MW	SAW	3	MODIFIED VERSION OF 491-W SUITABLE FOR MULTI WIRE APPLICATIONS
Low alloy and Martensitic steels	DAIKOFLUX 493-W	SAW	3,1	HIGH BASIC FLUX FOR LOW ALLOYS AND MARTENSITIC CrMo(Ni) STEELS
Stainless Steels	DAIKOFLUX 303	SAW	1.6	SEMI-BASIC FLUX FOR WELD/CLAD STAINLESS AND HEAT RESISTANT STEELS
	DAIKOFLUX 693	SAW	1,8	SEMI-BASIC FLUX FOR WELD/CLAD STAINLESS STEELS
	DAIKOFLUX 900-W	SAW	1,9	SEMI-BASIC FLUX FOR WELD/CLAD AUSTENITIC AND DUPLEX/SUPERDUPLEX STEELS
Ni Alloy	DAIKOFLUX 982	SAW	1,3	SEMI-BASIC PREFUSED FLUX FOR Cr-Mo STEELS, STAINLESS STEELS AND NICKEL BASE ALLOYS
	DAIKOFLUX 626-W	SAW	2,7	FLUORIDE-BASIC FLUX FOR WELD/CLAD STAINLESS STEELS AND NICKEL ALLOYS
	DAIKOFLUX 960-W	SAW	3,5	BASIC FLUX FOR HEAVY THICKNESS WELDING/CLADDING NICKEL ALLOYS
	DAIKOFLUX 961-W	SAW	2	BASIC FLUX FOR WELDING/CLADDING NICKEL BASE ALLOYS
Strip cladding	DAIKOFLUX 930	ESW	4,6	HIGH BASIC FLUX FOR STAINLESS STEEL STRIP CLADDING
	DAIKOFLUX 937AS	SAW	1,2	FLUX FOR STAINLESS STEEL STRIP CLADDING WITH SAW PROCESS
	DAIKOFLUX 940	ESW	4	BASIC FLUX FOR HIGH SPEED CLADDING WITH NICKEL BASE STRIPS
	DAIKOFLUX 942AS	SAW	2,3	BASIC FLUX FOR SUBARC STRIP CLADDING WITH NICKEL BASE STRIPS
	DAIKOFLUX 944	ESW	4,6	HIGH BASIC FLUX FOR NICKEL BASE STRIP CLADDING
	DAIKOFLUX 944-SL	ESW	4,6	HIGH BASIC FLUX FOR SINGLE LAYER NICKEL BASE STRIP CLADDING



## Certifications and Technical assistance

- UNI EN ISO 9001 quality system ICIM certificate nr.1245/3
- TuV certificate (nr. 0035-CPR-C908) for Factory Production Control system
- TuV approval of a qualified manufacturer of Welding Consumables pursuant to VdTUV 1153
- Technical assistance provided by qualified Welding Engineers I.W.E. nr.120085A





# TÜV APPROVALS

PRODUCT	TÜV APPROVAL No.
MIG Daiko SF 308LSi	11857
TIG Daiko SF 308L	11865
MIG Daiko SF 307Si	11858
MIG Daiko SF 309LSi	11864
TIG Daiko SF 309LSi	11869
MIG Daiko SF 316LSi	11859
TIG Daiko SF 316L	11866
MIG Daiko SF 318Si	11860
MIG Daiko SF 347Si	11863
MIG Daiko SF 2209	11861
TIG Daiko SF 2209	11867
MIG Daiko SF 82	11862
TIG Daiko 82	06004
MIG Daiko SF 625	10735
TIG Daiko SF 625	11868





# NOTES

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