

Solid wires for MAG-welding of high-strength steels for cold forming

ThyssenKrupp
high form

PAS



Steel grade	Manufacturer				
	BÖHLER	ESAB	LINCOLN	OERLIKON	THYSSEN
PAS 315	BÖHLER EMK 6	OK AristoRod 12.50	LNM 26	CARBOFIL 1	Union K 52
PAS 355	BÖHLER EMK 6	OK AristoRod 12.63	LNM 27	CARBOFIL 1 a	Union K 56
PAS 420	BÖHLER EMK 8				
PAS 460	BÖHLER DMO-IG	OK AristoRod 13.09	LNM Ni 1	CARBOFIL 2,5 Ni	Union K 5 Ni
PAS 500	BÖHLER NiMo 1-IG	(OK AristoRod 13.29)			
PAS 550					
PAS 600					
PAS 650	X 70-IG / NiMoCr-IG	OK AristoRod 13.29	LNM MoNiVa	CARBOFIL NiMoCr	Union NiMoCr
PAS 700					



Flux-cored wires for MAG-welding of high-strength steels for cold forming

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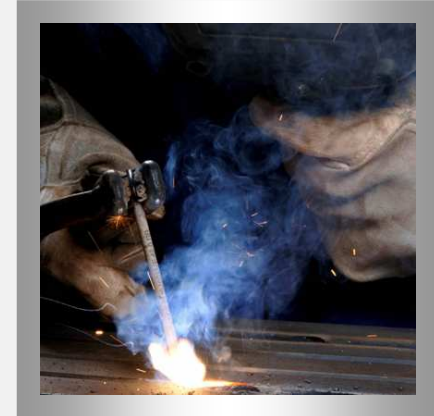


Steel grade	Manufacturer				
	Drahtzug Stein	ESAB	LINCOLN	OERLIKON	THYSSEN
PAS 315	Megafil 710 M	OK Tubrod 14.10	Outershield MC 715-H	Fluxofil 31	Union MV 70
PAS 355	Megafil 710 M Megafil 713 R				
PAS 420					
PAS 460					
PAS 500	Megafil 240 M, 821 R	(OK Tubrod 14.06)	Outershield 81Ni1-H(SR)	Fluxofil 40	Union TG 50 Ni
PAS 550	Megafil 940 M		Outershield 81K2-H(SR)	Fluxofil 41	
PAS 600	Megafil 742 M	OK Tubrod 14.03	Outershield 690-H(SR)	Fluxofil 42 Fluxofil M42	(Union MV NiMoCr)
PAS 650					Union MV NiMoCr
PAS 700					

Stabelektroden für das Lichtbogenhandschweißen von hochfesten Stählen zum Kaltumformen

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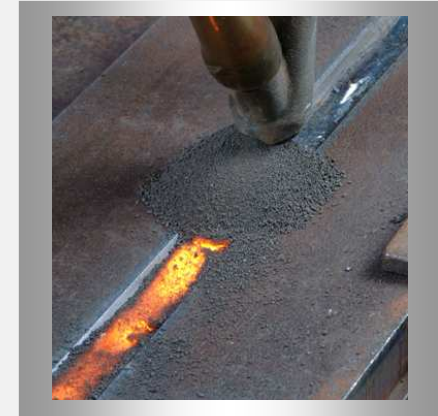


Steel grade	Manufacturer					
	BÖHLER	ESAB	LINCOLN	OERLIKON	THYSSEN	
PAS 315	FOX EV 47 / EV 50	SUPERCITO 7018 S	Conarc 49C	EXTRA	Phoenix 120 K	
PAS 355	FOX EV 50					Kryo 1
PAS 420				OK 55.00		
PAS 460	FOX DMO Kb / EV 60	(OK 75.75)	Conarc 85(-150)		TENACITO 65 R	Phoenix SH V 1
PAS 500	FOX EV 65			OK 75.75		
PAS 550	FOX EV 65 / EV 75	OK 75.75	Conarc 85(-150)		TENACITO 75	Phoenix SH Ni 2 K 90
PAS 600	FOX NiMo 100 / EV75			Phoenix SH Ni 2 K 100		
PAS 650	FOX EV 85					
PAS 700						

Wires / fluxes for submerged arc welding of high-strength steels for cold forming

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high form

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Steel grade	Manufacturer				
	BÖHLER	ESAB	LINCOLN	OERLIKON	THYSSEN
PAS 315	EMS 2 / BB 24	OK Autrod 12.20 / OK Flux 10.72	LNS 135 / P230 LNS 133U / P230	OE-SD3 / OP 121TT	Union S 2 / UV 421 TT
PAS 355	EMS 2 / BB 24				
PAS 420	EMS 3 / BB 24				
PAS 460	EMS 2 Mo / BB 24	OK Autrod 12.24 / 10.72	LNS 165 / Lincolnweld 8500	OE-S3NiMo1 / OP 121TT	Union S 3 NiMo / UV 421 TT
PAS 500	3 NiMo 1-UP / BÖHLER BB 24	OK Autrod 13.40 / 10.62			
PAS 550		(OK Autrod 13.43) / OK Flux 10.62	LNS 164 / Lincolnweld 8500	Fluxocord 41 / OP 121TT	
PAS 600			Fluxocord 42 / OP 121TT		
PAS 650	3 NiCrMo 2,5-UP / BÖHLER BB 24	OK Autrod 13.43 / OK Flux 10.62	LNS 168 / Lincolnweld 8500	OE-SD3 2,5NiCrMo / OP 121TT/W	Union S 3 NiMoCr / UV 421 TT
PAS 700					

Remarks

- **Other welding filler metals** which have not been listed here can also be used. The selection is not exclusive and should not be taken as any deprecation of the suitability of other filler metals.
- To avoid cold-cracking the welding filler metals have to be protected against any **absorption of moisture**. The basic covered electrodes and welding flux have to be post-dried in accordance with the manufacturer's instructions immediately before use.