

**Weldability**®

**sif**



[www.weldability-sif.com](http://www.weldability-sif.com)

Peters House  
The Orbital Centre  
Icknield Way  
Letchworth Garden City  
Hertfordshire  
SG6 1ET  
Tel. +44 (0) 1462 482200  
UK Sales 0345 130 7757



# The Welder's One -Stop Shop

Product Catalogue  
V9 2019

## Welding Products Catalogue



OXY/FUEL

MIG WELDING

STICK WELDING

TIG WELDING

SPOT WELDING

PLASMA CUTTING

TOOLS & MARKING

PIPE TOOLS

ABRASIVES

HANDLING EQUIP

DRYING OVENS

CHEMICALS

WELDING SAFETY

IND SAFETY

FUME EXTRACTION

SERVICES

SIF PRODUCTS

*For details of your nearest distributor, please contact*

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# A WELD OF OPPORTUNITY

Since 1925, Sif welding and brazing products have been relied upon by welders for their performance and consistency, in applications on cast iron, steel, stainless, aluminium, copper, brass and bronze.

Combined with the comprehensive range of equipment, accessories and safety products and services provided by Weldability Sif, the group delivers :

- Fast Shipping and Next-Day Delivery from our stock
- Product Support from our knowledgeable specialists
- Worldwide Availability online and via our resellers

So if you're looking for welding machines, torches, electrodes, wires, fluxes, regulators, helmets, fume extractors, or training courses, you can trust Weldability Sif.

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## SERVICES

LEARN to WELD



### Training

- Vocational Level 1-2 Welding Processes
- Professional Level 3-4 RWC



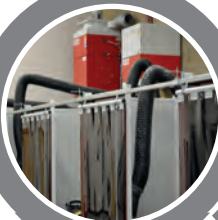
### Inspection

- Welders, Procedures - ISO 9606/15614
- Arc & Fume Equipment - Validation Service



### Certification

- Reminder Service



## FUME EXTRACTION



### Mobile

- Filtering
- On Torch



### Fixed

- Vent-to-Atmosphere
- Filtering



### Environment Monitoring

- ProtectoScan EDI

Extractability

## Weldability **sif** WELDING PRODUCTS



### Equipment

- Welding Machines
- Plasma Cutters
- Gas Control



### Consumables

- Wires & Rods
- Electrodes
- Fluxes



### Accessories

- Torches & Parts
- Connectors
- Tools
- Safety



**LX Series Plugged Regulators**

No gauges. Pressure shown on markings around the adjustment knob. Oxygen has 300 bar service, Acetylene & Propane have 20 bar.



Art #	Product
AE6001LX	Oxygen
AE6002LX	Acetylene
AE6001LXEXT	Oxygen - Extended Stem
AE6002LXEXT	Acetylene - Extended Stem
AE6004LXEXT	Propane - Extended Stem

**LX Series I-Gauge Regulators**

Gauge shows bottle contents. Knob shows output pressure. Oxygen has 300 bar service, Acetylene 20 bar.



Art #	Product
AE2001LX	1S 1G Oxygen
AE2002LX	1S 1G Acetylene
AE2004LX	1S 1G Propane 3.5 bar

**LX Series Multi Stage Regulators**

More accurate than single-stage regulators. Two gauges display pressure and contents. Oxygen 300bar. Acetylene 20 bar.



Art #	Product
AE7001LX	2S 2G Oxygen
AE7002LX	2S 2G Acetylene

**LX Series Nitrogen Regulators**

Nitrogen is used in many applications, including refrigeration and chamber purging. All have two gauges, showing bottle contents and output pressure and have 3/8" BSP right-hand outlet fittings. 200 bar.



Art #	Product
AE3003LX	1S 2G Nitrogen
AE7003LX	2S 2G Nitrogen
AE7003LX10	2S 2G Nitrogen - 10 Bar

**Argon To CO<sub>2</sub> Adaptor**

For connection of an Argon regulator to a CO<sub>2</sub> gas cylinder.



Art #	Product
AEARGBN	Argon To CO <sub>2</sub> Adaptor

**LX Series Indicator Regulators**

Bottle contents status shown by indicator on top. Ideal on-site. Pressure is determined via markings around knob. Oxygen has 300 bar service. Acetylene 20 bar.



Art #	Product
AE5001LX	Oxygen
AE5002LX	Acetylene

**LX Series 2-Gauge Regulators**

Gauges show output pressure & bottle contents. Oxygen has 300 bar service, Acetylene 20 bar.



Art #	Product
AE3004LX	1S 2G Oxygen
AE3002LX	1S 2G Acetylene

**LX Series Side Entry Regulators**

An alternative to bottom-entry regulators with 90° adaptor. The range includes single-stage one and two gauge, for Oxygen and Acetylene and higher-accuracy multi-stage two-gauge models for Propane.



Art #	Product
AE3004LXSEEXT	1S 2G Oxygen
AE3002LXSEEXT	1S 2G Acetylene
AE7004LXSEEXT	2S 2G Propane

**Heating Propane Regulator**

Single-stage plugged Propane regulator with 5/8" BSP bull-nose (inlet) and 3/8" BSP outlet.



Art #	Product
BG5143	Propane Heating Regulator

**CO<sub>2</sub> To Argon Adaptor**

For connection of a CO<sub>2</sub> regulator to an Argon gas cylinder.



Art #	Product
AECO2BN	CO <sub>2</sub> To Argon Adaptor

## 3-Way Adaptors

Available in LH or RH models to allow two or three regulator connections to one gas bottle. Connections are orientated at 90°, 180° and 270°. 5/8" BSP



Art #	Product
DA360RH	3-Way Adaptor RH
DA360LH	3-Way Adaptor LH

## Extensions

Adds additional distance between the regulator and the gas cylinder.



Art #	Product
DAEXTRH	Cylinder Extension RH
DAEXTLH	Cylinder Extension LH

## 90° Cylinder Valve Adaptors



Allows bottom entry regulators to be connected to cylinders designed for side entry regulators. 5/8" BSP

Art #	Product
DA90RH	Oxygen RH
DA90LH	Acetylene LH

## Straight Hose Adaptors

Straight adaptors are used to convert the thread size of 1/4"BSP hose fittings in order to enable them to be connected to 3/8"BSP HD shank fittings.



Art #	Product
DA6003814SRH	Straight Adaptor RH
DA6003814SLH	Straight Adaptor LH

## Bent Hose Adaptors

Bent adaptors are used to convert the thread size of 3/8"BSP hose fittings in order to enable them to be connected to 1/4"BSP LW shank fittings.



Art #	Product
DA6003814BRH	Bent Adaptor RH
DA6003814BLH	Bent Adaptor LH

## Balloon Inflator

Our popular balloon gas inflator is durable, easy to install and simple to use. Hand-tight cylinder connection requires no wrench for installation.



Art #	Product
AEBR125	Balloon Inflator

## Tank Wrench

"T-Bar" style cylinder key alternative.



Art #	Product
DZ0005	Cylinder key

## Regulator Nuts

Replacement regulator nuts for our LX series regulators.



Art #	Product
DANUTLHLX	5/8" BSP Reg Nut LH
DANUTRHLX	5/8" BSP Reg Nut RH

## Bullnose Stems

Replacement Bullnose stems are available in several regulator thread sizes to suit different regulator manufacturers.



Art #	Product
DASTEM12	Reg Stem 1/2x27TPI UK
DASTEM14	Reg Stem 1/4NPT UK
DASTEM26	Reg Stem 1/2x26TPI UK
DASTEMCO2	Reg Stem CO <sub>2</sub> UK
DASTEMLX	Reg Stem for Weldability LX

## CO<sub>2</sub> Regulator Nut & Washer

Replacement CO<sub>2</sub> regulator nut and washer.



Art #	Product
DACO2NUT	CO <sub>2</sub> Regulator Nut
DACO2WSHR	CO <sub>2</sub> Regulator Washer



Replacement of regulator parts should only be undertaken by a trained professional.

### Cylinder Key

Strong, drop-forged or nylon, black cylinder keys. Fits valves on British-type gas cylinders.

Art #	Product
DZ0002	Drop Forged Cylinder Key
DZ0002NYL	Nylon Cylinder Key

### Cup Type Sparklighter

A single flint bar. Single strike action. Made from quality spring steel. Sold complete with fitted flint. Replacement flints are available, packs of 10pcs.

Art #	Product
DZ105001	UK Cup Lighter
DZ105002B	UK Cup Lighter Flints pk 10
DZ105001A	US Cup Lighter
DZ105002BA	US Cup Lighter Flints pk 10

### Tri-Flint Sparklighter

Popular design of quality spring steel sparklighter, features a triple-flint strike action. Flints included, Spare flints sold as pack of 10 triangles.

Art #	Product
DZ205001	Tri-Flint Lighter
DZ205002	Spare Flints (10)

### Twin-Outlet Hose Valves

Twin-outlet valves let you connect two sets of hoses and torch equipment to a single gas inlet to use with one set of bottles, regulators and an FBA. With independent adjustment knobs, you can control the flow of gas from each outlet individually.

Art #	Product
DA8003838YRH	3/8" BSP RH
DA8003838YLH	3/8" BSP LH

### Fine Adjustment Valves

Designed to allow the isolation and flow control of gas travelling through a hose.

Art #	Product
DA800RH	3/8" BSP RH
DA800LH	3/8" BSP LH

### Combination Spanner

Strong, black, drop-forged spanners with integrated cylinder key, 3/8" BSP and jaw for 3/8" BSP (UK) & EN 560 (EU) hose nuts.

Art #	Product
DZ0001	Combi Spanner (UK Type)
DZ0001EN	Combi Spanner (EU Type)

### Nickel Pistol Sparklighter

Makes use of a single flint and a trigger strike action. Popular design. Fitted with flint. Spare flints in pk 10.

Art #	Product
DZ305001	Nickel Pistol
DZ305002	Spare Flints (10)

### Red Pistol Sparklighter

Similar to the nickel pistol sparklighter, but in a more economical red painted style.

Art #	Product
DZ405001	Red Pistol
DZ305002	Spare Flints (10)

### Twin-Outlet Valves FBA Version

These heavier-duty twin-outlet valves let you connect two sets of hoses, two FBA's and torch equipment to a single gas inlet, to use one set of bottles and regulators. With independent adjustment knobs, you can control the flow of gas from each outlet individually.

Art #	Product
DA8003838YRH	FBA 3/8" BSP RH
DA8003838YLH	FBA 3/8" BSP LH

### Nozzle Cleaner Sets

Sets of reamers and a file for cleaning the holes in an Oxy/Fuel gas cutting or welding nozzle. Flip-out cases.

Art #	Product
DZ0003	Nozzle Cleaners Large
DZ0004	Nozzle Cleaners Small (Blue)
DZ0004WBTY	Nozzle Cleaners Small (Red)

## Barrel Type Flashback Arrestors

Non-resettable FBA for high flow oxy/fuel cutting & welding. Will withstand a series of minor flashbacks but will not react as a consequence of external heat. Fuel gas model suitable for Acetylene or Propane. To ISO 5175-1



Product	
Art #	
AU111002	Oxygen FBA
AU111007	Fuel Gas FBA

## Air Products Integra® Arrestors

Air Products Integra® cylinders have bespoke quick-connector fittings. These connectors allow connection of your regular MIG/TIG equipment to the Integra® fitting.



Product	
Art #	
AU124523	AP Integra® Oxygen FBA
AU124524	AP Integra® Fuel Gas FBA

## Fitted Hose Lengths - ISO 3821

Separate fitted Oxygen, Acetylene and Propane hose. High-compression crimp fittings and non-return flame-traps. Available in a range of lengths and bore sizes with 3/8" or 1/4" BSP fittings **B**=Oxy, **R**=Acet, **P**=Propane.



Product	
Art #	
BW600514 <b>B</b> /RFT	6mm 5m 1/4" <b>B/R</b>
BW600514 <b>P</b> FT	6mm 5m 1/4" <b>P</b>
BW600538 <b>B</b> /RFT	6mm 5m 3/8" <b>B/R</b>
BW600538 <b>P</b> FT	6mm 5m 3/8" <b>P</b>
BW6001014 <b>B</b> /RFT	6mm 10m 1/4" <b>B/R</b>
BW6001014 <b>P</b> FT	6mm 10m 1/4" <b>P</b>
BW6001038 <b>B</b> /RFT	6mm 10m 3/8" <b>B/R</b>
BW6001038 <b>P</b> FT	6mm 10m 3/8" <b>P</b>
BW6002014 <b>B</b> /RFT	6mm 20m 1/4" <b>B/R</b>
BW6002038 <b>B</b> /RFT	6mm 20m 3/8" <b>B/R</b>
BW800538 <b>B</b> /RFT	8mm 5m 3/8" <b>B/R</b>
BW800538 <b>P</b> FT	8mm 5m 3/8" <b>P</b>
BW8001038 <b>B</b> /RFT	8mm 10m 3/8" <b>B/R</b>
BW8001038 <b>P</b> FT	8mm 10m 3/8" <b>P</b>
BW8002038 <b>B</b> /RFT	8mm 20m 3/8" <b>B/R</b>
BW8002038 <b>P</b> FT	8mm 20m 3/8" <b>P</b>
BW8003038 <b>B</b> /RFT	8mm 30m 3/8" <b>B/R</b>
BW8003038 <b>P</b> FT	8mm 30m 3/8" <b>P</b>
BW1000538 <b>B</b> /RFT	10mm 5m 3/8" <b>B/R</b>
BW1000538 <b>P</b> FT	10mm 5m 3/8" <b>P</b>
BW10001038 <b>B</b> /RFT	10mm 10m 3/8" <b>B/R</b>
BW10001038 <b>P</b> FT	10mm 10m 3/8" <b>P</b>
BW10002038 <b>B</b> /RFT	10mm 20m 3/8" <b>B/R</b>
BW10002038 <b>P</b> FT	10mm 20m 3/8" <b>P</b>
BW10003038 <b>B</b> /RFT	10mm 30m 3/8" <b>B/R</b>
BW10003038 <b>P</b> FT	10mm 30m 3/8" <b>P</b>

## Resettable Flashback Arrestors

Clearly indicate the occurrence of a flashback and can be manually reset afterwards via their collar. Will withstand a series of flashbacks but will not react as a consequence of external heat. To ISO 5175-1



Product	
Art #	
AU2001	Oxygen FBA
AU2002	Fuel Gas FBA

## Hi-Flow Fitted Hose Lengths

10mm x 3/8" hose pre fitted with high compression crimp fittings and FBA's. Conform to ISO 3821:2010



Product	
Art #	
BW10001038BFBA	10m Oxygen Hi-Flow
BW10001038PFBA	10m Propane Hi-Flow
BW10001038RFBA	10m Acetylene Hi-Flow
BW10002038BFBA	20m Oxygen Hi-Flow
BW10002038PFBA	20m Propane Hi-Flow
BW10002038RFBA	20m Acetylene Hi-Flow

## Fitted Siamese Hose Sets

Joined twin hose sets, fitted with flame traps. Conform to ISO 3821:2010



Product	
Art #	
BZ60514SETFTSY	6mm 5m 1/4" Oxy/Acet Set
BZ61038SETFTSY	6mm 10m 3/8" Oxy/Acet Set
BZ62038SETFTSY	6mm 20m 3/8" Oxy/Acet Set
BZ80538SETFTSY	8mm 5m 3/8" Oxy/Acet Set
BZ80538SETPFTSY	8mm 5m 3/8" Oxy/Prop Set
BZ81038SETFTSY	8mm 10m 3/8" Oxy/Acet Set
BZ81038SETPFTSY	8mm 10m 3/8" Oxy/Prop Set
BZ82038SETFTSY	8mm 20m 3/8" Oxy/Acet Set
BZ82038SETPFTSY	8mm 20m 3/8" Oxy/Prop Set
BZ100538SETFTSY	10mm 5m 3/8" Oxy/Acet Set
BZ101038SETFTSY	10mm 10m 3/8" Oxy/Acet Set
BZ101038SETPFTSY	10mm 10m 3/8" Oxy/Prop Set
BZ102038SETFTSY	10mm 20m 3/8" Oxy/Acet Set
BZ102038SETPFTSY	10mm 20m 3/8" Oxy/Prop Set

## Double Hose Clamp

Durable metal clamp, tightened via screw, to secure 2 lengths of a separate hose set.



Product	
Art #	
DA084124310	Double Hose Clamp



**Single-Line Bulk Unfitted Hose**

Unfitted hose supplied on 50m coils.  
Conforms to ISO 3821:2010

B = Oxy, R = Acet, P = Propane



Art #	Product
BW600B/R	6mm Oxy (B) Acet (R)
BW600PRP	6mm Propane (P)
BW800B/R	8mm Oxy (B) Acet (R)
BW800PRP	8mm Propane (P)
BW1000B/R	10mm Oxy (B) Acet (R)
BW1000PRP	10mm Propane (P)

**Hose Nuts**

Hose nuts available in either LH or RH with 3/8" or 1/4" BSP thread size.

Conform to EN 560.



Art #	Product
DA10014LH	1/4" BSP LH
DA10014RH	1/4" BSP RH
DA10038LH	3/8" BSP LH
DA10038RH	3/8" BSP RH

**Hose Tails**

Inserted into hose, to attach hose nuts. Available for a variety of hose bore sizes. Use with hose nuts and suitable hose clips to secure in place and seal. Conform to EN 1256.



Art #	Product
DA2001414	1/4" Tail - 1/4" BSP Nut
DA2003814	1/4" Tail - 3/8" BSP Nut
DA2003836	3/16" Tail - 3/8" BSP Nut
DA2003856	5/16" Tail - 3/8" BSP Nut
DA2003838	3/8" Tail - 3/8" BSP Nut

**Hose Splicers**

Use with suitable hose clips to join two lengths of hose together without using threaded nuts and couplers.

Splicers are available to suit a range of hose sizes.



Art #	Product
DA30014	1/4" BSP Hose Splicer
DA30038	3/8" BSP Hose Splicer
DA30036	3/16" BSP Hose Splicer
DA30056	5/16" BSP Hose Splicer



Inspect hoses regularly for cuts, abrasions, perishing, flashback incidents and replace as necessary

**Twin Bulk Unfitted Hose - ISO 3821**

Siamese Oxy/Fuel hoses (Acet or Propane). Priced per mtr.



Art #	Product
BW600RBT	6mm Twinflex Oxy/Acetylene
BW800RBT	8mm Twinflex Oxy/Acetylene
BW800PBT	8mm Twinflex Oxy/Propane
BW1000RBT	10mm Twinflex Oxy/Acetylene
BW1000PBT	10mm Twinflex Oxy/Propane

**Hose Clips**

Also called 'O' Clips, they are used to crimp over the ends of hoses to secure hose tails and create a gas-tight seal. A wide range of hose sizes is catered for. Priced each, supplied in packs of 10. Use with Hose Clip Pliers (page 64)



Art #	Product (Each)
DA70532	5/32" (3-4mm)
DA70036	3/16" (4-5mm)
DA70014	1/4" (5-7mm)
DA70056	5/16" (7-9mm)
DA70038	3/8" (8-11mm)
DA70076	7/16" (9-11mm)
DA70012	1/2" 5mm Hose (11-13mm)
DA70096	9/16" 6mm Hose (13-15mm)
DA70058	5/8" 8mm Hose (15-18mm)
DA70034	3/4" 10mm Hose (17-20mm)
DA70078	7/8" 10mm Hose (20-23mm)
DA70100	1" (23-27mm)

**Hose Couplers**

A threaded connector used with hose nuts and tails to join two lengths of hose together.

Available in a LH or RH version with a range to suit a number of different thread combinations.



Art #	Product
DA4001414LH	1/4"-1/4" BSP LH
DA4001414RH	1/4"-1/4" BSP RH
DA4003814LH	3/8"-1/4" BSP LH
DA4003814RH	3/8"-1/4" BSP RH
DA4003838LH	3/8"-3/8" BSP LH
DA4003838RH	3/8"-3/8" BSP RH

## Flame Trap Check Valves

A vital item of gas safety equipment. This product is used at the torch end of a hose to help prevent dangerous back-feeding of gases. A preferred design to traditional hose check valves, the flame trap valve is fastened inside the hose using hose clips. (page 7)



Art #	Product
DA5001414LHFT	1/4" Nut - 1/4" Tail LH
DA5001414RHFT	1/4" Nut - 1/4" Tail RH
DA5003814LHFT	3/8" Nut - 1/4" Tail LH
DA5003814RHFT	3/8" Nut - 1/4" Tail RH
DA5003838LHFT	3/8" Nut - 3/8" Tail LH
DA5003838RHFT	3/8" Nut - 3/8" Tail RH
DA5003856LHFT	3/8" Nut - 5/16" Tail LH
DA5003856RHFT	3/8" Nut - 5/16" Tail RH

## Model 'O' Lead Burning Kit

For very fine welding and brazing applications, including the fusion welding of thin gauge sheet metal up to 1.5mm (1/16") and delicate lead welding. The torch is very easy to handle and generates a small, focused flame ideal for precise, heat-sensitive situations, where it is important that the heat-affected zone is kept to a minimum.



### Product

Art #	Product
CCMOKIT	Model 'O' Kit (Torch & Tips)
CCMONECK	Model 'O' Neck
CCMO01	#1 Model 'O' Tip (2-3mm)
CCMO02	#2 Model 'O' Tip (4-5mm)
CCMO03	#3 Model 'O' Tip (6-8mm)
CCMO04	#4 Model 'O' Tip (10-20mm)
CCMO05	#5 Model 'O' Tip (18-30mm)

## Shank & Mixer - LW & HD

A shank carries Oxygen and Fuel Gas and controls gas flow to the nozzle. A mixer combines these gases and holds the welding nozzle. Both available in two types; the more portable 'Lightweight' and 'Heavy Duty'.



### Product

Art #	Product
BB5001	HD Shank
BB5003	HD Mixer
BB6001	LW Shank
BB6003	LW Mixer

## On-Torch Flashback Arrestors

Ideally suited for configurations with long hose sets. Helps prevent hose fires and bursting which can result from serious flashback events. To ISO 517s-1



Art #	Product
AU121002	On-Torch FBA Oxygen
AU121007	On-Torch FBA Fuel Gas

## Quick Coupling Fittings

Quick connect fittings to allow rapid change between different gas welding/cutting torches from a single hose assembly.

Comply with BS EN 561:2002



Art #	Product
AU125001	Regulator Quick Coupling 3/8" RH
AU125002	Regulator Quick Coupling 3/8" LH
AU126001	Male Pin 38 RH (to Hose - Regulator End)
AU126002	Male Pin 38 LH (to Hose - Regulator End)

## Welding & Cutting Boxed Sets

Complete welding or welding and cutting torch kits. Supplied in a durable, plastic, foam-insulated case, the kits include a shank, mixer and cutting attachment (if required) a range of nozzles, cleaner and bottle spanner.



Art #	Product
BBHDKIT	HD Kit Welding & Cutting
BBLWKIT	LW Kit Welding & Cutting
BBLWKITWLD	LW Kit Welding Only

## Cutting Attachments - LW & HD

The cutting attachment fits to an Oxy/Fuel shank and is available in Heavy Duty and Lightweight versions.

The HD model is used with ANM, PNM, ASN and AGNM nozzles and the LW model uses AFN and ASFN.



Art #	Product
BB5002	HD Cutting Attachment
BB6002	LW Cutting Attachment

### Portable Gas Packages

These units are complete equipment packages for Oxy/Fuel welding & cutting. They contain regulators, FBA's, a shank, mixer, cutting attachment, hoses, a selection of nozzles, tools, goggles and a trolley (excluding gas bottles).



Art #	Product
BB1007	HD Style Portable Package
BB2007	LW Style Portable Package

### LW Welding Nozzles

Smaller swaged style nozzles for use with the LW mixer.



Art #	Product No.	Thickness
CCLW01	# 1	0.9mm
CCLW02	# 2	1.2mm
CCLW03	# 3	2.0mm
CCLW05	# 5	2.6mm
CCLW07	# 7	3.2mm
CCLW10	#10	4.0mm
CCLW13	#13	5.0mm
CCLW18	#18	6.5mm
CCLW25	#25	8.2mm

### On-Site Oxy/Fuel Packages

Complete packages consisting of plugged regulators, FBAs, a hose set (20m for cutting, 5m for weld+cut) and a torch (NM universal for cutting, or 3-part for cut+weld) with a selection of nozzles and accessories. Ideal for use on-site.



Art #	Product
PKGSITEACHD	On-Site Oxy/Acet HD Cutting Set
PKGSITEPCHD	On-Site Oxy/Prop HD Cutting Set
PKGSITEAWCHD	On-Site Oxy/Acet HD Cut+Weld Set
PKGSITEAWCLW	On-Site Oxy/Acet LW Cut+Weld Set

### Oxy/Fuel Gas Economiser

Allows for quick repeated stop-start of the flame. Additional extension available for use with natural gas.



Art #	Product
AE2000	Oxy/Fuel Economiser ①
AE2000/NG	Natural Gas Burner ②
TAE 2000PR	Propane Burner

### HD Welding Nozzles

Welding nozzles for use with a HD style mixer. Swaged type.



Art #	Product No.	Thickness
CCSW01	# 1	0.9mm
CCSW02	# 2	1.2mm
CCSW03	# 3	2.0mm
CCSW05	# 5	2.6mm
CCSW07	# 7	3.2mm
CCSW10	#10	4.0mm
CCSW13	#13	5.0mm
CCSW18	#18	6.5mm
CCSW25	#25	8.2mm
CCSW35	#35	10.0mm
CCSW45	#45	13.0mm
CCSW70	#70	18.5mm

### Blanking Nozzles

A selection of blanking nozzles for use in testing gas hand equipment for leaks. These nozzles have no outlet holes so they do not allow gases to pass through them, thus forcing them to exit via leaks in hoses etc.



Art #	Product
CCANMB	HD Cutting Blanking Nozzle
CCLWB	LW Welding Blanking Nozzle
CCSWB	HD Welding Blanking Nozzle
CCAFNB	LW Cutting Blanking Nozzle

### Workshop Cutting & Welding Kits

Full workshop welding and cutting packages, with 1S 2G regulators, FBAs, a 5m hose set and Heavy Duty 3-part torch with a selection of nozzles and accessories.



Art #	Product
PKGSHOAWCHD	Workshop Oxy/Acet HD Weld+Cut Set
PKGSHOAWCLW	Workshop Oxy/Acet LW Weld+Cut Set

### AFN Cutting Nozzles

For use with a lightweight cutting attachment. Available in 3 sizes to cut 3-6mm (1/8"-1/4"), 6-20mm (1/4"-3/4") & 20-50mm (3/4"-2").



Art #	Product No.	Thickness
CCAFN01	#1	3-6mm 1/32"
CCAFN02	#2	6-20mm 3/64"
CCAFN03	#3	20-50mm 1/6"

## NM Universal Cutting Torches

A popular design of oxy/ fuel gas cutting torch which is used with NM type nozzles.

It features 3/8" BSP inlets, pressure control knobs and cutting oxygen lever. 18", 27", 36", 48" & 60" lengths with 90°, 75° or 180° head models.

Robust, all brass body



Art #	Product
BU100B	NM Torch 18/90 (457mm)
BU100B75	NM Torch 18/75
BU100B180	NM Torch 18/180
BU200B	NM Torch 27/90 (685mm)
BU200B75	NM Torch 27/75
BU200B180	NM Torch 27/180
BU300B	NM Torch 36/90 (914mm)
BU300B75	NM Torch 36/75
BU300B180	NM Torch 36/180
BU400B	NM Torch 48/90 (1219mm)
BU400B75	NM Torch 48/75
BU400B180	NM Torch 48/180
BU600B	NM Torch 60/90 (1524mm)

## NM Pivot & Circle Cutting Guide

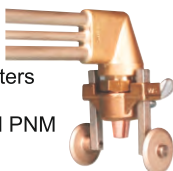
Easy circle cutting tools for use with NM style universal cutters. Available in two models, one for smaller circles, based on a pivot or our circle cutting kit for larger diameters.



Art #	Product
TJ111535	Pivot Guide
TJ1082	Circle Cutting Kit
TJ5085	Linear Cutting Guide c/w 1.2m Track

## NM Roller Cutting Guide

Made from machined brass and stainless steel, the roller guide keeps an optimum distance and makes the cutting of lines and shapes quick and easy. It can be used with NM style universal cutters and the HD type cutting attachment using ANM and PNM style cutting nozzles.



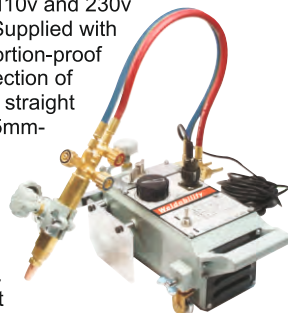
Art #	Product
TJ1602	Roller Cutting Guide

## Straight Line Cutting Machine

Portable, automatic straight-line cutting machines, available in either single or double torch models to suit 110v and 230v input power supply. Supplied with 2x1.2 lengths of distortion-proof steel track and a selection of cutting nozzles. Cuts straight

lines and bevels on 5mm-50mm thick steel. Constant adjustable travel speed - in forward or reverse - to provide good machine-quality cuts.

Robust, and compact manufactured with brass and stainless steel machined components.

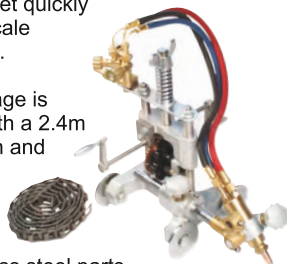


Art #	Product
BCG31I110	Straight Line Cutting M/C 110V
BCG31I230	Straight Line Cutting M/C 230V
BCG30ITRK	Straight Line Cutting Track 2x 1.2m
BCGCIRCLE	Optional Circle Guide (20cm - 2m r)
BCG30I110	Double Torch Model M/C 110v
BCG30I230	Double Torch Model M/C 230v
BCG30I1KIT	Double Torch Kit
BCG30ITCH	Replacement Torch
BCG30HOSE	Replacement Hose Set

## Pipe Cutting Machine

A manual chain-driven pipe cutting machine that provides smooth, accurate cutting action by incorporating a low gear ratio and worm wheel drive. Cuts 5-50mm thick wall on pipe with 102-600mm (4"-24") diameter. Beveling head angle can be set quickly and accurately by scale on a rack and pinion.

This complete package is supplied together with a 2.4m length of guide chain and a selection of ANM cutting nozzles. solidly constructed using brass, chromed and stainless steel parts.



Art #	Product
BCG30PCM	Pipe Cutting Machine
BCG30CHN	Guide Chain 2.4m
BCG30PCM25	Torch Holder Kit
BCG30PCM49	Torch
BCG30PBAND	Guide Band - >400mm dia



**ANM/E Nozzles**

ANM & ANME Oxy/Acetylene cutting nozzles for use with NM cutter or HD cutting attachments. (E) shows ANME's extended length nozzle types.



Art #	Product No.	Thickness
CCANM01W	1/32	6mm
CCANM02W	3/64	12mm
CCANM03W	1/16	75mm
CCANM04W	5/64	100mm
CCANM05W	3/32	150mm
CCANM06W	1/8	300mm
CCANME01W	1/32 (E)	6mm
CCANME02W	3/64 (E)	12mm
CCANME03W	1/16 (E)	75mm
CCANME04W	5/64 (E)	100mm
CCANME05W	3/32 (E)	150mm
CCANME06W	1/8 (E)	300mm
CCPNME07W	7/64 (E)	200mm

**PNM/E Nozzles**

PNM & PNME Oxy/Propane cutting nozzles. For use with NM cutters or HD cutting attachments (E) shows PNME's extended length nozzle types.



Art #	Product No.	Thickness
CCPNM01W	1/32	6mm
CCPNM02W	3/64	12mm
CCPNM03W	1/16	75mm
CCPNM04W	5/64	100mm
CCPNM05W	3/32	150mm
CCPNM09W	7/64	200mm
CCPNM06W	1/8	300mm
CCPNME01W	1/32 (E)	6mm
CCPNME02W	3/64 (E)	12mm
CCPNME03W	1/16 (E)	75mm
CCPNME04W	5/64 (E)	100mm
CCPNME05W	3/32 (E)	150mm
CCPNME06W	1/8 (E)	300mm

**Sheet Cutting Nozzles**


The ASNM and ASFN sheet metal cutting nozzles are made to cut sheet mild steel to a 3mm maximum thickness. ASNM is designed to be used with the HD style cutting attachment. ASFN is used with the small, LW style cutting attachment.

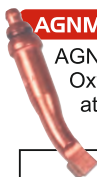
Art #	Product
CCASFN	LW ASFN Nozzle ①
CCASNM	HD ASNM Nozzle ②

**ARCNM Rivet Cutting Nozzle**

ARCNM nozzles are used with the NM type cutters and HD cutting attachments for cutting rivet heads.



Art #	Product
CCARCNM	ARCNM Nozzle

**AGNM Gouging Nozzles**


AGNM nozzles gouge welds and plate using Oxy/Acetylene with the Heavy Duty cutting attachment or NM type cutter. Three sizes are sold with a range of gouge widths.

Art #	Product No.	Gouge Width
CCAGNM13	#13	6-8mm
CCAGNM19	#19	8-11mm
CCAGNM25	#25	10-13mm

**PGNM Gouging Nozzles**


Like the AGNM's, PGNM nozzles are used with NM and HD cutters, but use Oxy/Propane to gouge.

Art #	Product No.	Gouge
CCPGNM01	#1	3-6mm
CCPGNM02	#2	5-9mm
CCPGNM03	#3	6-12mm
CCPGNM04	#4	10-16mm

**Apachi Type Nozzles**

Two-piece NM type cutting nozzles for use with 'Apachi' (MAPP) gas in an NM style cutting torch or HD cutting attachment.



Art #	Product No.	Thickness
CC113594	1/32	3-6mm
CC113589	3/64	5-12mm
CC113584	1/16	10-75mm
CC113593	3/32	25-90mm
CC113591	5/64	70-100mm
CC113595	1/8	200-300mm

**Leak Detection Spray**

Non-toxic milky spray formula, for use on hoses, regulator nuts, valves, etc.



Art #	Product
EG3001	Leak-Tek Aerosol Spray 400ml
EG3002	1ltr Leak-Tek-T Trigger Spray

## Toolbox Cutting and Welding Kits

Our workshop welding and cutting packages supplied in a durable metal toolbox for safe storage and transport.

See page 09 for contents.



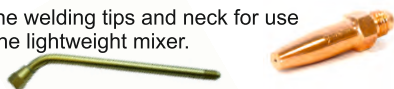
### Product

Art #

PKGCASEAWCHD Toolbox Oxy/Acet HD Weld+Cut Set  
PKGCASEAWCLW Toolbox Oxy/Acet LW Weld+Cut Set

## DH Type Neck and Nozzles

DH fine welding tips and neck for use with the lightwelder mixer.



### Product

Art #	No.	Thickness
BB2005	DH Style Neck	
CCDH01	# 1	0.9mm
CCDH02	# 2	1.2mm
CCDH03	# 3	2.0mm
CCDH05	# 5	2.6mm
CCDH07	# 7	3.2mm
CCDH10	#10	4.0mm
CCDH13	#13	5.0mm
CCDH18	#18	6.5mm

## Cutter Headnuts

Replacement headnuts for NM style universal cutters, HD and LW style cutting attachments. Used to hold the cutting nozzle in place. Sold individually.



### Product

Art #

DZ0000	Headnut - NM
DZ001T3	Chromed Headnut - HD
DZ001LW	Chromed Headnut - LW
BCG30INUT	Headnut for cutting machines

## H625 Type One-Piece Cutting Torch

A heavy duty cutting torch for use with NFF type nozzles in the Harris® style on oxy/propane or natural gas. (See page 14)



### Product

Art #

BUH625	Harris® Type Cutting Torch
--------	----------------------------

## Toolbox On-site Cutting Kits

Our on-site cutting packages supplied in a durable metal toolbox for safe storage and transport.

See page 08 for contents.



### Product

Art #

PKGCASEACHD10	Toolbox Site Oxy/Acet HD Cutting Set
PKGCASEPCHD10	Toolbox Site Oxy/Prop HD Cutting Set

## VVC (Cr) M/C Nozzles

VVC are used with machine cutters using propane to cut quickly and efficiently, with repeated accuracy. The popular 'Chromed' type is available in 16 sizes.



### Product

Art #	No.	Thickness
CCVVC0	0	25mm
CCVVC00	00	12mm
CCVVC000	000	9mm
CCVVC01/2	0 1/2	38mm
CCVVC1	1	50mm
CCVVC11/2	1 1/2	76mm
CCVVC2	2	100mm
CCVVC21/2	2 1/2	127mm
CCVVC3	3	150mm
CCVVC31/2	3 1/2	178mm
CCVVC4	4	180mm
CCVVC4/0	4/0	6mm
CCVVC5	5	203mm
CCVVC5/0	5/0	5mm
CCVVC51/2	5 1/2	228mm
CCVVC7NH	7	300mm

## Toolbox Case

A durable red-painted metal toolbox case measuring 66 x 27 x 25cm and weighing 3kgs. Can be sealed shut with metal latches and has a pull-out tool tray. Ideal for tool and accessory kits.



### Product

Art #

OP1000W	Weldability Sif Toolbox Case
---------	------------------------------

**V315 Type Shank 3/8"**

A model shank made in the Victor style, to fit our BUV152 cutting attachment. Uses Victor® type welding nozzles. Built in flashback arrestors and reverse-flow check valves so no need for separate on-torch FBA's. Works with all fuel gases.



Art #	Product
BUV211	Victor® Style Shank 3/8" Fitting

**One Piece Welding Nozzles**

General purpose welding nozzles, excellent for welding and pre-heating using oxygen and acetylene or hydrogen fuel gas. Nozzles are swaged with one-piece copper elbow. Produce a long cone flame. Compatible with V315 type shank.

Art #	Product Thickness
CCVW000	0.9mm
CCVW00	1.2mm
CCVW0	2.0mm
CCVW1	2.6mm
CCVW2	3.2mm
CCVW3	4.0mm
CCVW4	5.0mm
CCVW5	6.5mm
CCVW6	8.2mm
CCVW7	10.0mm
CCVW8	13.0mm
CCVW10	18.5mm

**Series One Cutting Nozzles**

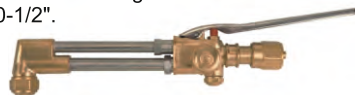
Single-piece 2-seat Oxygen/Acetylene cutting nozzles for use with Victor® style cutting torches.



Art #	Product No.	Thickness
CCV01101	0-1-101	13mm
CCV11101	1-1-101	19mm
CCV21101	2-1-101	25mm
CCV31101	3-1-101	51mm
CCV41101	4-1-101	76mm
CCV51101	5-1-101	102mm
CCV71101	7-1-101	220mm

**V2460 Type Cutting Attachment**

This model is designed to fit our V315 Victor®-style shank/handle and accommodate series one cutting nozzles and GPN nozzles. Features a die-forged brass head, stainless steel tube and a head angle of 90°. The length is 10-1/2".



Art #	Product
BUV152	Victor® Style Cutting Attachment

**VST-900 One Piece Cutting Torch**

Heavy duty cutting torch for use with any fuel gas single piece. Includes built in flashback arrestors and reverse flow check valves for added safety. Uses Victor®. Type series one nozzles with a cutting capacity of 1/8"/3.2mm to 8"/200mm and GPN cutting nozzles. Head angle 90°.



Art #	Product
BUV900F	Victor® Style One Piece Cutting Torch

**GPN Series Propane Cutting Nozzles**

General purpose natural gas/propane two-piece cutting nozzles. For use with the VST-900 and V2460 type cutting torches above.



Art #	Product Thickness
CCV0333-03000	1-3mm
CCV0333-0300	3-6mm
CCV0333-0301	6-10mm
CCV0333-0302	10-20mm
CCV0333-0303	20-40mm
CCV0333-0304	40-60mm
CCV0333-0305	60-80mm
CCV0333-0306	80-125mm
CCV0333-0307	125-200mm



Weldability-Sif provide a Compressed Gas System Inspection training service which offers EAL certification for the inspection of gas equipment in accordance with the Provision & Use of Working Equipment Regulations 1998 and the British Compressed Gas Associations Code of Practice 7. **See page 103** for more details on our comprehensive training services.

## NFF Cutting Nozzles

NFF are 2-piece cutting nozzles that are used with propane or natural gas, in flat seat torches.



Art #	Product No.	Thickness
CCNFF0	#0	10-15mm
CCNFF1	#1	15-25mm
CCNFF2	#2	25-50mm
CCNFF3	#3	50-75mm
CCNFF4	#4	75-150mm
CCNFF5	#5	150-200mm
CCNFF6	#6	200-300mm

## AHT Equipment

AHT equipment is used with the AHT neck and HD mixer, which connect only to the HD shank. BFAHT100 can use the BFAHTNECK & option BB5005 high-flow mixer combination.



Art #	Product
BFAHT025	# 25 Nozzle 52k Btu/h
BFAHT050	# 50 Nozzle 91k Btu/h
BFAHT100	#100 Nozzle 139k Btu/h
BFAHTNECK	AHT Heating Neck
BB5003	HD Style Mixer
BB5005	Hi-Flow Mixer

## NM Heating Nozzle



Designed to be used with the NM type cutter or HD cutting attachment for oxy/propane heating. 102K-188K Btu/h

Art #	Product
BFPHNM	NM Heating Nozzle
BFNMI	NM Heating Insert

## Propane Superheating Equipment

'H' Type propane heating nozzles, available in a range of sizes



Art #	Product
BF1H	② 1H Nozzle - 72k-163k Btu/h
BF2H	② 2H Nozzle - 102k-188k Btu/h
BF3H	② 3H Nozzle - 183k-361k Btu/h
BF4H	② 4H Nozzle - 236k-406k Btu/h
BF5H	② 5H Nozzle - 281k-618k Btu/h
BFSN11	① Superheating Neck 11" Long
BFSN27	① Superheating Neck 27" Long
BB5004	Superheating HD MixerNM
BFNMSHA	① Adaptor

## Heating Torch - Multi Head

Used with propane gas in metal pre-heating, flame-cleaning, warming and the welding and brazing of copper pipe, with valve for fine adjustment of fuel gas flow.



Connects via 3/8" BSP fitting at the base. 330mm length, with a burner diameter of 17mm. Weighs 650g.

Includes a standard nozzle (fitted), float nozzle, pipe nozzle. Provides 9kbtu with standard nozzle, 26kbtu with float & pipe nozzle.

Art #	Product
BG109-SF	Heating Torch (Multi Head)

## Heating Torch - 45mm

A standard propane heating torch, measuring 380mm in length with a 45mm diameter burner. Incorporates a valve and a lever to introduce a jet of heat as required. Provides 181kbtu heat.



Connects to a propane gas supply via a 3/8" BSP inlet fitting. Suitable for a diverse range of applications from pre-heating, to flame cleaning and paint removal.

Weighs 650g.

Art #	Product
BG105-45L	Heating Torch 45mm

## Heating Torch - 60mm

A more industrial Propane heating torch, measuring 560mm in length with a 60mm diameter burner. Incorporates a valve and a lever to introduce a jet of heat as required. Provides 218kbtu heat.



Connects to a Propane gas supply via a 3/8" BSP inlet fitting. Suitable for white line removal and pitch-heating etc.

Weighs 750g. Available with or without a piezo lighter, which ignites the torch without the need for a sparklighter.

Art #	Product
BG111	Heating Torch 60mm
BG312	Above, With Piezo Lighter



**Bare Silicon Bronze Brazing Rods**

Original, multi-purpose Sifbronze No 1 low-temperature rod for brazing of steels, cast iron, copper and its alloys. Use with Sifbronze Flux.



See our Sif section for other pack sizes.



Art #	Product
RO011625	Sifbronze No 1 1.6mm 2.5kg
RO012425	Sifbronze No 1 2.4mm 2.5kg
RO013225	Sifbronze No 1 3.2mm 2.5kg

**Fluxed Silicon Bronze Brazing Rods**

Sifautobronze is our Sifbronze No1 impregnated with Sifbronze Flux, allowing faster brazing of clean mild steel. See our Sif section for other pack sizes.



Art #	Product
RS412425	Sifautobronze 2.4mm 2.5kg

**Coated Silicon Bronze Brazing Rods**

Sifredicote is our Sifbronze No1 pre-coated with Sifbronze Flux, allowing faster continuous brazing. Ideal for general mild steel work and dissimilar applications. See our Sif section for other pack sizes.



Art #	Product
RR011625	Sifredicote No 1 1.6mm 2.5kg
RR012425	Sifredicote No 1 2.4mm 2.5kg
RR013225	Sifredicote No 1 3.2mm 2.5kg

**Plain Ni Bronze Brazing Rods**

Our 9% Nickel Sifbronze No2, for use on copper alloys, alloy steel and stainless steel, with excellent wear properties and high strength. Ideal for brazing tubes, cutting tips and use as a general maintenance alloy. When brazing stainless, use with our Sif Tool Tip / Braze Stainless Flux.



Art #	Product
RO021625	Sifbronze No 2 1.6mm 2.5kg
RO022425	Sifbronze No 2 2.4mm 2.5kg
RO023225	Sifbronze No 2 3.2mm 2.5kg

**Sifbronze Brazing Flux**

Sif's flux for general brazing work. Available in 225g and 500g jars. For a range of compatible filler rods, see page 116



Art #	Product
FO010022	Sifbronze Flux 225g
FO010050	Sifbronze Flux 500g
FO100050	Sif 101 Brazing Flux 500g

**Sif ECO Flux**

A pre-mixed paste at optimal liquidity free of boric acid and suitable for brazing of mild steel and copper alloys.

This non-toxic flux complies to EN 1045 - FH10.



Art #	Product
FO050035	Sifbronze 350G Eco Paste

**Steel Gas Welding Rods**

Sifsteel No 11 is a low-carbon gas welding rod for mild steel and wrought iron applications. Free-flowing and ideal for panels, plates and fittings. Copper-coated for longer shelf life.

See our Sif section for pack sizes.



Art #	Product
RO111625	Sifsteel No 11 1.6mm 2.5kg
RO112425	Sifsteel No 11 2.4mm 2.5kg
RO113225	Sifsteel No 11 3.2mm 2.5kg

**Sif Tool Tip / Braze Stainless Flux**

A powder flux used for tool tipping or brazing stainless with Sifbronze No1 or No2 filler rods, which are detailed on page 116.

Has a higher melting point range than standard Sifbronze Brazing Flux



Art #	Product
FO200050	Tool Tip/Braze Stainless 500G Jar

# MIG WELDING



110v  
1ph



230v  
1ph  
16A/32A



415v  
3ph

## MIG 130T Gas/No Gas

140A, 230v 1ph MIG welder package. Takes 0.6mm and 0.8mm wire up to 5kg reels and 0.8mm flux-cored gasless wire. Supplied complete with torch, clamp and accessories.



Art #	Product
TWX1M130T	MIG 130T Package 230v 1ph
TWN742402	Replacement Torch

## MIG 160T Gas/No Gas

160A, 230v 1ph MIG welder package. Takes 0.6mm and 0.8mm wire up to 5kg reels and 0.8mm flux-cored gasless wire.



Supplied complete with torch, clamp and accessories and caters for a small industrial gas bottle at the rear. Sold separately

Art #	Product
TWX1M160T	MIG 160T Package 230v 1ph
TWN742400	Replacement Torch

## MIG 200 Euro

200A, 230v 1ph MIG welder package. Takes 0.6mm and 1.0mm wire up to 15kg reels. Supplied complete with regulator, torch, clamp, accessories and caters for a small industrial gas bottle at the rear. Sold separately



Art #	Product
TWX1M200E	MIG 200E Package 230v 1ph
QH180300LX	Replacement Torch

## Leasing

Power your business with flexible lease offers. Whether you are looking to buy equipment for your own business, or seeking an affordable finance solution for your customers, Weldability Sif Leasing makes it easier to access the welding power you need, now.

You choose the equipment, you choose the term. With no deposit, fixed rentals, fully managed service.

- Available to Limited Companies, LLPs and PLCs.
- All Quotes are 'Subject to Status'.
- Apply online today

## Learn to Weld MIG Welding Training

Our comprehensive work book and DVD are the ideal resources to help you learn to weld in your own time and workspace. Or book to attend a one week intensive MIG welding qualification, developed to provide an introduction to the theory and practical skills required with the focus and support of our experienced instructors.

**LEARN to WELD**



Art #	Product
WBLEARN11	Welding and Fab Workbook
WBLEARN01	Learning DVD Level 1 / 2
WBQ1MIG	EAL Level 1 MIG Welding Course

## Upright Water Coolers

115v/230v 1ph water cooler/ recirculator which operates at 270W power, with a 2kW cooling capacity. Fitted with a 5ltr rust free plastic water tank, the pump provides 2ltrs per minute in this forced air cooling system. Fitted with male quick-connectors.



Art #	Product
TWX1COOL110	115v 1ph Water Cooler
TWX1COOL230	230v 1ph Water Cooler

**MTS200**

A professional, microprocessor-controlled inverter welding power-source for MIG, MMA and Lift-TIG applications, featuring IGBT technology and providing a lightweight,


**MTS250**

The SifWeld MTS 250 multi-purpose power source with integral wire feed system. It is an electronically controlled MIG/MAG/MMA industrial welding power source featuring IGBT inverter technology.



Product	
Art #	
TSX1D200MTS	MTS 200 Power Source
FXMT2003	SifGun MIG Torch 200 amp 3m

Product	
Art #	
TSX1D250MTPKG	MTS 250 Package 1PH +
FXMT2003	FXMT2003 SIFGUN 200A 3M
TSX1D250SOG	MTS 200 Spool-On-Gun 4M

**MTS300**

The SifWeld MTS 300 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and 5m standard interconnecting cables, along with an external 4-roll wire feed system which accommodates up to 15kg D300 wire spools.


**MTS400**

The SifWeld MTS 400 is an electronically controlled MIG/MAG/MMA industrial welding power source featuring IGBT inverter technology.



Product	
Art #	
TSX1D300MTSPKG5	MTS 300 P-Source 1PH
FXMT3003	SifGun MIG Torch 3m

Product	
Art #	
TSX3D400MTPKG	MTS 300 Package 1PH
TSX30400MTSPKGWC	MTS Wire Feed Unit
TSX30400MTSPKGWC	Water Cooled Package
FXMT4003	SifGun MIG Torch 400 3m

**SifVac**
**INNOVATION**

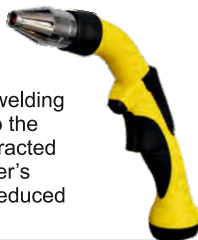
SifVac is an ideal modular unit that can be modified or purpose-built for specific applications to support the extraction of fumes and dust directly at the source

Can be used with SiGun FE MIG torch for highly efficient on-source extraction.

230V and 110V models available.


**SifGun Fume Extraction Torch**

The SifGun Fume Extraction Torch is an innovative MIG welding torch with integrated extraction at the nozzle of the welding torch. The extraction is close to the weldpool, so the fumes are extracted immediately. As a result the user's exposure to welding fumes is reduced by up to 95%.



Product	
Art #	
EXTMT3004	SifGun FE Air-Cooled 300A 4M torch
EXTMT5004	SifGun FE Water-Cooled 500A 4M torch

Product	
Art #	
EXTSVAC230S15	PKG 1 - Single motor head with 15ltr body
EXTSVAC230T15	Package 2 - Twin motor head with 15ltr body
EXTSVAC230C15	Package 3 - Brushless turbinehead

## Mini Gas Regulator

The mini gas regulator features a 1/8" BSP inlet bottle fitting and a quick connector outlet. It is used with disposable gas cylinders on small MIG and TIG machines, but can also be used with the Conversion Kit to adapt the quick-connector for use with 3/8" BSP fitting typically found on industrial welding machines.



## Conversion Kit

A kit for converting the quick-connector fitting typically found on our range of mini MIG welders to an industrial bottle regulator. Can be used with our mini gas regulator.



Art #	Product
TWN722120	Mini Gas Regulator

Art #	Product
TWN001COMP	Conversion Kit

## Shielding Gas Regulators

Regulators for use with Argon or CO<sub>2</sub> shielding gas in MIG and TIG welding applications. They feature 3/8"RH BSP outlet and 5/8" BSP RH inlet fittings. Available in plugged, 1S 1G, 1S 2G and 2S 2G models with 3.5 or 10 Bar maximum outlets.



Bottom Entry

## Flowmeter

Designed to be fitted to the outlet of an Argon or CO<sub>2</sub> regulator to provide greater control of the flow of your shielding gas through the gas line. 2 models are available, with either 0-15lpm or 0-40lpm flow rate.



Art #	Product
AU200	Flowmeter 0 - 15lpm
AU300	Flowmeter 0 - 40lpm

Art #	Product
AE2005LXPS	1S 1G Argon Pre-Set
AE2005LX	1S 1G Argon
AE3005LX	1S 2G Argon
AE3005LX10	1S 2G Argon 10 Bar
AE7005LX	2S 2G Argon
AE7008LX	2S 2G CO <sub>2</sub>

## Shielding Gas Economiser

Reduces unnecessary loss of Argon or CO<sub>2</sub> shielding gas by up to 50%. Shipped calibrated at 8lpm but can be adjusted via an allen key fitting in the base.



Supplied complete with flowmeter.

Art #	Product
MW15210	Gas Economiser
MW15220	Gas Flow Tube 0 - 15lpm
MW15230	Gas Flow Tube 0 - 40lpm

## Side Entry Shielding Regulators

A range of economy regulators for use with Argon or CO<sub>2</sub> shielding gas in MIG and TIG applications. They feature 3/8" BSP outlet and 5/8" BSP inlet fittings. Models are available in 1S 1G and 1S 2G designs, with standard length or extended length.



## 240v CO<sub>2</sub> heater (25W)

This IP44 rated CO<sub>2</sub> heater allows flow of up to 20lpm without risk of freezing or noticeable changes in flow/pressure. Fits onto a CO<sub>2</sub> cylinder and heats the CO<sub>2</sub> gas prior to entering the regulator. Supplied complete with 2m mains cable.



Art #	Product
AE2005LXSE	1S 1G Argon
AE2008LXSE	1S 1G CO <sub>2</sub>
AE3005LXSEEXT	1S 2G Argon Extended Stem
AE3008LXSEEXT	1S 2G CO <sub>2</sub> Ext
AE3005LXBEXT	1S 2G Argon Ext

Art #	Product
AE1000	CO <sub>2</sub> Heater 230V



**Replacement Mini MIG Torches**

Replacement MIG torch for our MIG 130T and 160T Weldability portable welding machines.



Art #	Product
TWN742402	MIG 130T TORCH
TWN742400	MIG 106T TORCH

**Mini-To-Euro Converter**

This euro converter allows the connection of a euro torch to MIG machines that are supplied with hard wire torches.

Unfortunately these are not compatible with all machines. Check your model before ordering. (Requires a gas solenoid valve).



Art #	Product
TWN723051	Euro Adaptor

**Mini MIG Tips and Shrouds**

A range of copper contact tips and chromed nozzles for use with our MIG 130T and 160T.

Also available in bulk packs of 50.



Art #	Product
TWN722661W	0.6mm Tip pk 10 M5 Thread
TWN722661WBLK	0.6mm Tip pk 50 M5 Thread
TWN722667W	0.8mm Tip pk 10 M5 Thread
TWN722667WBLK	0.8mm Tip pk 50 M5 Thread

TWN722054W	Shroud each
TWN722054WBLK	Shroud pk 25

**Spool Hub Adaptor**

Allows a small 1/2kg spool of wire to be used on a wire-feed system with a 15kg hub. Ideal for small jobs, demonstrations, etc, where use of a large reel would not be practical or economical.



Art #	Product
SHW1001	Spool Hub Adaptor

**Mini Torch Liners**

For use with our MIG 130T and 160T machines, these liners carry wire from the feeder to the contact tip.

Two diameters are available, 0.6-0.8mm and 0.8-1.0mm both in 2m lengths. Also available in 0.6-0.8mm by the meter.



Art #	Product
TWN742412	0.6-0.8mm 3m
TWN722077	0.8-1.0mm 3m
TWNLINER	0.6-0.8mm / mtr

**Mini Swan Necks**

These swan necks are for use with our MIG 130T and MIG 160T, they connect the tip and the shroud to the main torch body and carry the wire, gas and current to the end of the torch. One model available for each machine.



Art #	Product
TWN722810	For MIG 130T
TWN722078	For MIG 160T

**Wire Basket Adaptor**

This re-useable, durable and strong hub adaptor allows european-style wire baskets to be used on a standard wire-feeder hub.

Suitable for either 15kg or 18kg B300 wire baskets.



Art #	Product
XO001	K-300 Coil Hub Adaptor

**Magnetic Support Bracket**

Our magnetic support bracket holds the work pieces at a variety of angles while you weld. Strong magnet and rugged, durable body. Ideal for all welding processes to free both your hands.



Art #	Product
ET001002	Magnetic Support

# sifGUN®

## BND

*Bernard® - compatible*

A range of ergonomically designed heavy duty air-cooled MIG welding torches using the popular BND spares. Featuring a highly flexible cable assembly with knuckle joints fitted at torch and machine end for extended cable life.

### SifGun® Heavy Duty MIG Torches

Art #	Product
FXMT2003	SifGun 200A 3m
FXMT2004	SifGun 200A 4m
FXMT2005	SifGun 200A 5m
FXMT3003	SifGun 300A 3m
FXMT3004	SifGun 300A 4m
FXMT3005	SifGun 300A 5m
FXMT4003	SifGun 400A 3m
FXMT4004	SifGun 400A 4m
FXMT4005	SifGun 400A 5m

### SifGun® - Head Assemblies

#	Art #	Product
3	SW4235	Head Assembly (200/300A)
	SW4335	Head Assembly (200/300A)
	SW4435	Head Assembly (400A)
	SW4635	Head Assembly (400A)

### SifGun® - Nozzles

#	Art #	Product
4	SW4391	Brass Nozzle (200/300A)
	SW4392	Brass Nozzle (200/300A)
	SW4491	Brass Nozzle (400A)
	SW4492	Brass Nozzle (400A)
4	SW4393	Copper Nozzle (200/300A)
	SW4394	Copper Nozzle (200/300A)
	SW4591	Copper Nozzle (400A)
	SW4592	Copper Nozzle (400A)

### SifGun® - Cu Contact Tips (Each)

#	Art #	Product
5	SW1588	Contact Tip 0.8mm Long
	SW1589	Contact Tip 0.9mm Long
	SW1596	Contact Tip 1.0mm Long
	SW1590	Contact Tip 1.2mm Long
	SW1598	Contact Tip 1.3mm Long
	SW1591	Contact Tip 1.6mm Long
	SW1592	Contact Tip 2.0mm Long
	SW7488	Contact Tip 0.8mm Short
5	SW7489	Contact Tip 0.9mm Short
	SW7496	Contact Tip 1.0mm Short
	SW7490	Contact Tip 1.2mm Short
	SW7498	Contact Tip 1.3mm Short
	SW7491	Contact Tip 1.6mm Short
	SW7492	Contact Tip 2.0mm Short



Complies with EN 60974-7  
60% Duty Cycle (mixed gases)

### SifGun® - Binzel® Style Liners

Art #	Product
QH180320W	Liner 3m 0.6mm - 0.8mm
QH180420W	Liner 4m 0.6mm - 0.8mm
QH180520W	Liner 5m 0.6mm - 0.8mm
QH180322W	Liner 3m 1.0mm - 1.2mm
QH180422W	Liner 4m 1.0mm - 1.2mm
QH250522W	Liner 5m 1.0mm - 1.2mm
QH290426	Liner 4m 1.6mm

### SifGun® - Bernard® Style Liners

Art #	Product
SW43010	Liner 3m 2/300A 0.6-0.8mm
SW43015	Liner 4m 2/300A 0.6-0.8mm
SW43110	Liner 3m 2/300A 0.9-1.2mm
SW43115	Liner 4m 2/300A 0.9-1.2mm
SW44110	Liner 3m 400A 0.9-1.2mm
SW44115	Liner 4m 400A 0.9-1.2mm
SW44210	Liner 3m 400A 1.2-1.6mm
SW44215	Liner 4m 400A 1.2-1.6mm

**Weldability**®

*The Welder's One-Stop Shop*

**BZL**
*Binzel®-compatible*

Popular BZL style replacement MIG torch with Euro connector plug and comfortable handle design. Features sprung plug pins and spring cable supports, this torch offers durability and affordability.

Can be fitted with liners for welding with mild steel, stainless steel, aluminium and copper alloy wires. Using the popular BZL established "industry standard" design of front end spare parts.

Economic styles, in 3m or 4m lengths, under the following model designations:

WB15 - 180A@60% (CO2) Air-Cooled  
 WB25 - 250A@60% (CO2) Air-Cooled  
 WB36 - 360A@60% (CO2) Air-Cooled

**BZL - Economic MIG Torches c/w Euro Plug**

Fig #	Art #	Product	
1	QH180300LX	180A Air Cooled MIG Torch 3mtr	WB15
	QH180400LX	180A Air Cooled MIG Torch 4mtr	WB15
	QH180500LX	180A Air Cooled MIG Torch 5mtr	WB15
	QH250300LX	250A Air Cooled MIG Torch 3mtr	WB25
	QH250400LX	250A Air Cooled MIG Torch 4mtr	WB25
	QH250500LX	250A Air Cooled MIG Torch 5mtr	WB25
	QH290300LX	360A Air Cooled MIG Torch 3mtr	WB36
	QH290400LX	360A Air Cooled MIG Torch 4mtr	WB36
	QH290500LX	360A Air Cooled MIG Torch 5mtr	WB36


**BZL - Swan Necks**

Art #	Product	
QH180341W	Swan Neck Assembly 180A	WB15
QH250441W	Swan Neck Assembly 250A	WB25
QH290441W	Swan Neck Assembly 360A	WB36
QH400441W	Swan Neck Assembly 500A	WB40

**BZL - Eco Cu Contact Tips - Bulk Bags (50)**


Art #	Product	
QH180306WBLK	Contact Tip 0.6mm 180A M6 (Pk 50)	WB15
QH180308WBLK	Contact Tip 0.8mm 180A M6 (Pk 50)	WB15
QH180310WBLK	Contact Tip 1.0mm 180A M6 (Pk 50)	WB15
QH250406WBLK	Contact Tip 0.6mm 250A M6 (Pk 50)	WB25
QH250408WBLK	Contact Tip 0.8mm 250A M6 (Pk 50)	WB25
QH250408WALK	Contact Tip Alu 0.8mm 250A M6 (Pk 50)	WB25
QH250410WALK	Contact Tip Alu 1.0mm 250A M6 (Pk 50)	WB25
QH250410WBLK	Contact Tip 1.0mm 250A M6 (Pk 50)	WB25
QH250412WBLK	Contact Tip 1.2mm 250A M6 (Pk 50)	WB25
QH400408WBLK	Contact Tip 0.8mm 500A M8 (Pk 50)	WB40
QH400410WBLK	Contact Tip 1.0mm 500A M8 (Pk 50)	WB40
QH400412WBLK	Contact Tip 1.2mm 500A M8 (Pk 50)	WB40
QH400416WBLK	Contact Tip 1.6mm 500A M8 (Pk 50)	WB40

## BZL - Eco Cu Contact Tips - Blister Packs (10)




Art #	Product	
QH180306W	Contact Tip 0.6mm 180A M6 Pack 10	WB15
QH180308W	Contact Tip 0.8mm 180A M6 Pack 10	WB15
QH180310W	Contact Tip 1.0mm 180A M6 Pack 10	WB15
QH180312W	Contact Tip 1.2mm 180A M6 Pack 10	WB15
QH250406W	Contact Tip 0.6mm 250A M6 Pack 10	WB25
QH250408W	Contact Tip 0.8mm 250A M6 Pack 10	WB25
QH250410W	Contact Tip 1.0mm 250A M6 Pack 10	WB25
QH250412W	Contact Tip 1.2mm 250A M6 Pack 10	WB25
QH400408W	Contact Tip 0.8mm 500A M8 Pack 10	WB40
QH400410W	Contact Tip 1.0mm 500A M8 Pack 10	WB40
QH400412W	Contact Tip 1.2mm 500A M8 Pack 10	WB40
QH400416W	Contact Tip 1.6mm 500A M8 Pack 10	WB40

## BZL - Tip Adaptors - Blister Packs (5)




Art #	Product	
QH250405W	Tip Adaptor 250A M6 Pack 5	WB25
QH290405W	Tip Adaptor 360A M6 Pack 5	WB36
QH290418W	Tip Adaptor 360A M8 Pack 5	WB36
QH400405W	Tip Adaptor 400A M8 Pack 5	WB40

## BZL - Nozzles - Bulk Bags (25)



Art #	Product	
QH180301WBLK	Conical Nozzle (Pk 25)	WB15
QH180302WBLK	Tapered Nozzle 180A (Pk 25)	WB15
QH180303WBLK	Cylindrical Nozzle 180A (Pk 25)	WB15
QH180304WBLK	Spot Welding Nozzle 180A (Pk 25)	WB15
QH180305WBLK	Bottle Neck Nozzle 180A (Pk 25)	WB15
QH250401WBLK	Conical Nozzle 250A (Pk 25)	WB25
QH250402WBLK	Tapered Nozzle 250A (Pk 25)	WB25
QH250403WBLK	Cylindrical Nozzle 250A (Pk 25)	WB25
QH250404WBLK	Spot Welding Nozzle 250A (Pk 25)	WB25
QH250409WBLK	Bottle Neck Nozzle 250A (Pk 25)	WB25
QH290401WBLK	Conical Nozzle 360A (Pk 25)	WB36
QH290402WBLK	Tapered Nozzle 360A (Pk 25)	WB36
QH290403WBLK	Cylindrical Nozzle 360A (Pk 25)	WB36
QH400401WBLK	Conical Nozzle 500A (Pk 25)	WB40
QH400402WBLK	Tapered Nozzle 500A (Pk 25)	WB40
QH400403WBLK	Cylindrical Nozzle 500A (Pk 25)	WB10

## BZL - Nozzles - Blister Packs (Each)



Art #	Product	
QH180301W	Conical Nozzle 180A	WB15
QH180302W	Tapered Nozzle 180A	WB15
QH180303W	Cylindrical Nozzle 180A	WB15
QH180304W	Spot Welding Nozzle 180A	WB15
QH180305W	Bottle Neck Nozzle 180A	WB15

**BZL - Nozzles - Blister Packs (each)**


Art #	Product	
QH250401W	Conical Nozzle 250A	WB25
QH250402W	Tapered Nozzle 250A	WB25
QH250403W	Cylindrical Nozzle 250A	WB25
QH250404W	Spot Welding Nozzle 250A	WB25
QH250409W	Bottle Neck Nozzle 250A	WB25
QH290401W	Conical Nozzle 360A	WB36
QH290402W	Tapered Nozzle 360A	WB36
QH290403W	Cylindrical Nozzle 360A	WB36
QH400401W	Conical Nozzle 500A	WB40
QH400402W	Tapered Nozzle 500A	WB40
QH400403W	Cylindrical Nozzle 500A	WB40

**BZL - Liners**


Art #	Product
QH180320W	Liner 3m 0.6mm - 0.8mm
QH180420W	Liner 4m 0.6mm - 0.8mm
QH180520W	Liner 5m 0.6mm - 0.8mm
QH180322W	Liner 3m 1.0mm - 1.2mm
QH180422W	Liner 4m 1.0mm - 1.2mm
QH250522W	Liner 5m 1.0mm - 1.2mm
QH290426	Liner 4m 1.6mm
QH180326	Teflon Liner 0.6mm - 0.8mm - 3 mtr
QH250424	Teflon Liner 0.6mm - 0.8mm - 4 mtr
QH250425	Teflon Liner 0.6mm - 0.8mm - 5 mtr
QH180327	Teflon Liner 1.0mm - 1.2mm - 3 mtr
QH250426	Teflon Liner 1.0mm - 1.2mm - 4 mtr
QH250427	Teflon Liner 1.0mm - 1.2mm - 5 mtr
QH290436	Teflon Liner 1.6mm - 4mtr

**BZL - Insulator / Diffusors**


Art #	Product	
QH290407W	Insulator White 360A (Pack 2)	WB36
QH290407WBLK	Insulator White 360A (Pack 25)	WB36
QH400440	Insulator White 500A (Each)	WB40

**BZL - Nozzle Springs**


Art #	Product
QH180340	Nozzle Spring WB15
QH250440	Nozzle Spring WB25

**BZL - Euro Plug O-Ring**


Art #	Product
4CE305630	O Ring 4X1mm

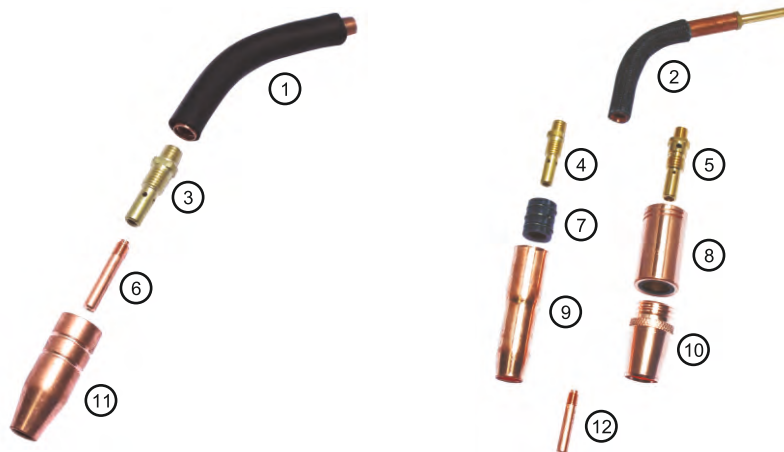


## Weldability®

The Welder's One-Stop Shop

## TWC

Tweco®-compatible



### TWC - Tweco Style Torches

Fig #	Art #	Product
	SWB2-10E	Tweco Style No.2 10ft Torch
	SWB2-15E	Tweco Style No.2 15ft Torch
	SWB3-10E	Tweco Style No.3 10ft Torch
	SWB3-15E	Tweco Style No.3 15ft Torch
	SWB4-10E	Tweco Style No.4 10ft Torch
	SWB4-15E	Tweco Style No.4 15ft Torch

### TWC #1 / #2 - Conductor Tubes (Swan Necks)

Fig #	Art #	Product
1	SW61-45	45° Conductor Tube
	SW61-60	60° Conductor Tube
2	SW62A45	45° Conductor Tube
	SW62A60	60° Conductor Tube

### TWC - Contact Tips (Each)

Fig #	Art #	Product
6	SW14-30	Contact Tip 0.8mm Ecu
	SW14-40	Contact Tip 1.0mm Ecu
	SW14-45	Contact Tip 1.2mm Ecu
	SW14H-30	Contact Tip 0.8mm Ecu Hd
	SW14H-40	Contact Tip 1.0mm Ecu Hd
	SW14H-45	Contact Tip 1.2mm Ecu Hd
	SW14H-52	Contact Tip 1.3mm Ecu Hd
	SW14H-116	Contact Tip 1.6mm Ecu

**TWC #1 / #2 - Gas Diffusers (Tip Adaptors)**

Fig #	Art #	Product
3	SW51	Gas Diffuser
4	SW52	Gas Diffuser

**TWC #1 / #2 - Nozzles**

Fig #	Art #	Product
11	SW21-37	Nozzle Self Insulated 9mm
	SW21-50	Nozzle Self Insulated 12mm
	SW21-62	Nozzle Self Insulated 16mm
7	SW32	Adjustable Nozzle Insulator
9	SW22-50	Nozzle Adjustable 12mm
	SW22-62	Nozzle Adjustable 16mm
8	SW34CT	Nozzle Insulator Coarse Thread
10	SW24CT-50S	Nozzle Fixed Coarse Thread 12mm
	SW24CT-62S	Nozzle Fixed Coarse Thread 16mm

**TWC #3 / #4 - MIG Torch Spares**

Fig #	Art #	Product
9	SW23-50	Nozzle Self Insulated 12mm
	SW23-62	Nozzle Self Insulated 16mm
	SW23-75	Nozzle Self Insulated 19mm
7	SW34A	Adjustable Nozzle Insulator
9	SW24A-50	Nozzle Adjustable 12mm
	SW24A-62	Nozzle Adjustable 16mm
	SW24A-75	Nozzle Adjustable 19mm
7	SW34CT	Nozzle Insulator Coarse Thread
9	SW24CT-50S	Nozzle Fixed Coarse Thread 12mm
	SW24CT-62S	Nozzle Fixed Coarse Thread 16mm
	SW24CT-75S	Nozzle Fixed Coarse Thread 19mm
7	SW35CT	Nozzle Insulator Coarse Thread
9	SW25CT-50	Nozzle Fixed Coarse Thread 12mm
	SW25CT-62	Nozzle Fixed Coarse Thread 16mm
	SW25CT-75	Nozzle Fixed Coarse Thread 19mm
2	SW64A45	45° Conductor Tube
	SW64A60	60° Conductor Tube
4	SW65-45	45° Conductor Tube
	SW65-60	60° Conductor Tube
4	SW54A	Gas Diffuser
	SW55	Gas Diffuser

**TWC - Liners**

Fig #	Art #	Product
	SW42-3035-15	Liner Conduit 0.8-0.9mm X 15ft
	SW42-4045-15	Liner Conduit 1.0-1.2mm X 15ft
	SW44-3545-15	Liner Conduit 0.9-1.2mm X 15ft
	SW44-116-15	Liner Conduit 1.6mm X 15ft
	SW44-564-15	Liner Conduit 2.0mm X 15ft

## Tip-Dip Gel

Tip-dip gel is used in MIG welding to help prevent the build-up of welding spatter on your contact tips and shrouds. Non-toxic, non-flammable, and silicone free. Available in a 225g or 500g tin.



Art #	Product
FXTIPDIP22	SIF Tip-Dip - 225g
FXTIPDIP50	SIF Tip-Dip - 500g

## Solvent-Based Anti-Spatter

Low-odour formula anti-spatter spray which prolongs tip and shroud life and prevents the adhesion of the weld spatter to the area surrounding the weld zone. Supplied in a 450g aerosol can.



Art #	Product
EG261005	Solvent-Based Anti-Spatter 450g

## CeraMIGuard Dry-Film Spray

A protective ceramic spray specifically designed to prolong tip and shroud life in industrial MIG fabrication. It can also be applied to jigs, fixtures & cables to protect them from spatter adhesion.



Art #	Product
EG5001	CeraMIGuard Dry-Film Spray

## Disposable Gas Cylinders

A range of Argon, CO<sub>2</sub> and Argon/CO<sub>2</sub> mix mini shielding gas cylinders which are typically used with portable MIG and TIG welding machines. Two sizes are available; a 390g and a 600g version with a 1/8" BSP fitting.



Art #	Product
TWN802038	CO <sub>2</sub> 390g
TWN802038L	CO <sub>2</sub> 600g
TWN802048	Argon/CO <sub>2</sub> 390g
TWN802048L	Argon/CO <sub>2</sub> 600g
TWN802050	Argon 390g

## Water-Based Anti-Spatter

A water-based, silicone-free, non-toxic, non-flammable anti-spatter solution, used to prolong tip & shroud life and to prevent adhesion of weld spatter to the area surrounding the weld zone. It is available in a full range of container types and sizes.



Art #	Product
EG1001W	400ml Spray
EG1001100W	1ltr Trigger Spray
EG1001100BW	1ltr Empty Bottle
EG10015000	5ltr Bulk Bottle
EG1001BLK	25ltr Bulk Drum

## Flaw & Crack Detector

3 part system to highlight cracks and flaws in a finished weld. Red dye shows cracks after developer is applied.



Available separately in spray cans.

Art #	Product
EG2001	Cleaner 400ml e
EG2002	Penetrant 400ml e
EG2003	Developer 370ml e

## MIG Wire Cleaning Pads

Engineered to clean & lubricate the MIG wire as it passes through the wire-feeder. The red pad removes mill dust, dirt and oxides to allow the wire to feed more easily. It is suitable for all wire types. The black pad cleans and lubricates mild steels only.



Art #	Product
EWA007060	Clean & Lube Pad (Black) Pk6
EWA007061	All Wire Clean Pad (Red) Pk6

## Toolbox Case

A durable, red-painted metal toolbox case which measures at 66x27x25cm and weighs just 3kgs.



Art #	Product
OP1000W	Weldability Sif Toolbox

# sif CeramiBac®



Our **ceramic backing** material strips enable welding to be carried out from one side with full penetration, and provide the following advantages:

- Removes the need for welding from the reverse side
- Helps reduce oxidation
- Does not create hydrogen inclusion
- Quick execution improves operation economy
- Can be used with every weldable metal
- Supplied in box qtls, cut to 60cm strips

Available in various sizes to meet the most demanding requirements.

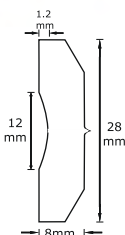
## SIFCeramiBac® Rounded Groove



Rounded groove ceramic backing on self-adhesive aluminium tape.

Groove measures 12mm wide x 1.2mm deep.

60cm strips, 20 strips per box  
Total welding length 12m



Art #	Product
PV290806100SF	Rounded Groove

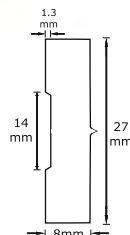
## SIFCeramiBac® Square Groove



Square groove ceramic backing on self-adhesive aluminium tape.

Groove measures 14mm wide x 1.3mm deep.

60cm strips, 20 strips per box  
Total welding length 12m



Art #	Product
PV290806152SF	Square Groove

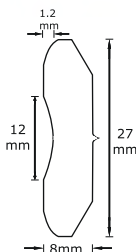
## SIFCeramiBac® 1/8<sup>th</sup> Segmented Circle



Circular ceramic backing on self-adhesive aluminium tape.

Groove measures 12mm wide x 1.2mm deep. Supplied in 1/8th segments

8 strips per circle,  
10 circles per box



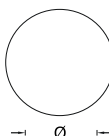
Art #	Product
PV290806715SF	1/8 <sup>th</sup> Segmented Circle

## SIFCeramiBac® Round



Round ceramic backing on self-adhesive aluminium tape. Available in a range of diameters.

60cm strips, 20 strips per box  
Total welding length 12m



Art #	Product
PV290806307SF	Round 6mm Diameter
PV290806310SF	Round 9mm Diameter
PV290806312SF	Round 12mm Diameter

## Mild Steel Wire

SG2/SG3 grades of layer wound, copper coated mild steel wire in a range of reel sizes and diameters.



Art #	Product
VZ180607L	SG2 0.6mm 0.7kg
VZ180650L	SG2 0.6mm 5kg
VZ180615LW	SG2 0.6mm 15kg
VZ180807L	SG2 0.8mm 0.7kg
VZ180850L	SG2 0.8mm 5kg
VZ180815LW	SG2 0.8mm 15kg
VZ181050L	SG2 1.0mm 5kg
VZ181015LW	SG2 1.0mm 15kg
VZ181215LW	SG2 1.2mm 15kg
VZ180815LSG3	SG3 0.8mm 15kg
VZ181015LSG3	SG3 1.0mm 15kg
VZ181215LSG3	SG3 1.2mm 15kg

## SifMIG® Copper Free Wires

Fe

SifMIG® Zero SG2 & SG3 copper free welding wires providing a smooth arc with low spatter and low fume. SG3 has increased silicon and manganese for improved tensile strength



Art #	Product
WA201018	SifMIG Zero SG2 1.0mm 18kg
WA201218	SifMIG Zero SG2 1.2mm 18kg
WA191018	SifMIG Zero SG3 1.0mm 18kg
WA191218	SifMIG Zero SG3 1.2mm 18kg

## SifMIG® Non-Ferrous Wires

AL SS

SifMIG® 4043 is our general-purpose 5% silicon aluminium alloy. SifMIG® 5356 has 5% magnesium for greater UTS. SifMIG® 308LSi is our commonly used stainless alloy, compatible with a range of stainless grades.

Art #	Product
WO150865	SifMIG 4043 0.8mm 6.5kg
WO151065	SifMIG 4043 1.0mm 6.5kg
WO151265	SifMIG 4043 1.2mm 6.5kg
WO151665	SifMIG 4043 1.6mm 6.5kg
WO270865	SifMIG 5356 0.8mm 6.5kg
WO271065	SifMIG 5356 1.0mm 6.5kg
WO271265	SifMIG 5356 1.2mm 6.5kg
WO271665	SifMIG 5356 1.6mm 6.5kg
WO330840	SifMIG 308LSi 0.8mm 3.75kg
WO331040	SifMIG 308LSi 1.0mm 3.75kg
WO331240	SifMIG 308LSi 1.2mm 3.75kg

## Gasless Flux Cored Wire

E71-TGS is a carbon steel MIG wire that eliminates the need for shielding gas. Suited to welding thin gauge mild and galvanised steel.



Art #	Product
VZFC08045	Gasless 0.8mm 0.45kg
VZFC08090	Gasless 0.8mm 0.9kg
VZFC08450	Gasless 0.8mm 4.55kg

## SifMIG® Copper Coated Wires

Fe

SifMIG® SG2 wire is used in general purpose steel fabrication applications for mild and medium tensile steels, for impact toughness down to -20° C. SifMIG® SG3 is used in general purpose steel fabrication applications and has increased silicon and manganese for improved UTS



Art #	Product
WA180607	SifMIG SG2 0.6mm 0.7kg
WA180807	SifMIG SG2 0.8mm 0.7kg
WA180650	SifMIG SG2 0.6mm 5.0kg
WA180850	SifMIG SG2 0.8mm 5.0kg
WA181050	SifMIG SG2 1.0mm 5.0kg
WA180615	SifMIG SG2 0.6mm 15kg
WA180815	SifMIG SG2 0.8mm 15kg
WA181015	SifMIG SG2 1.0mm 15kg
WA181215	SifMIG SG2 1.2mm 15kg
WA1808250	SifMIG SG2 0.8mm 250kg Drum
WA1810250	SifMIG SG2 1.0mm 250kg Drum
WA1812250	SifMIG SG2 1.2mm 250kg Drum

WG030815	SifMIG SG3 0.8mm 15kg
WG031015	SifMIG SG3 1.0mm 15kg
WG031215	SifMIG SG3 1.2mm 15kg
WG0308250	SifMIG SG3 0.8mm 250kg Drum
WG0310250	SifMIG SG3 1.0mm 250kg Drum
WG0312250	SifMIG SG3 1.2mm 250kg Drum

## SifMIG® Brazing Wires

CU

SifMIG® 968 is a popular copper-silicon brazing alloy for dissimilar materials. SifMIG® No8 is a lower-melting-point alternative alloy commonly used in autobody applications.

Art #	Product
WO960812	SifMIG 968 0.8mm 12.5kg
WO961012	SifMIG 968 1.0mm 12.5kg
WO961212	SifMIG 968 1.2mm 12.5kg
WO080812	SifMIG 8 0.8mm 12.5kg
WO081012	SifMIG 8 1.0mm 12.5kg
WO081212	SifMIG 8 1.2mm 12.5kg



## MIG "Helper" Pliers

Performs many tasks to aid smooth MIG welding, including removal of spatter from in & around the shroud, drawing out and cutting off wire, fitting and removing contact tips and shrouds. These pliers are both comfortable to handle and durable in use.



Art #	Product
ET001W	MIG "Helper" Pliers

## MIG Shroud Reamer

Insert the reamer into a MIG torch shroud and expand the teeth to grip the shroud from the inside. By rotating with teeth expanded, spatter is removed from the inside of the shroud and from around the tip to allow the shielding gas to flow more easily.



Art #	Product
ET002W	MIG Shroud Reamer

## Magnetic Torch Stand

When your MIG torch is not in use, you will look to store it somewhere close to your MIG welder or close to your workbench. This stand is magnetic and will attach to a range of surfaces to support your torch where you need it. A strong, reliable design suitable for use with all our MIG and TIG torches.



Art #	Product
ETMTS	Magnetic Torch Stand

## Air Products Integra® Connectors

Air Products Integra® cylinders have bespoke quick-connector fittings.

These connectors allow connection of your regular MIG/TIG equipment to the Integra® fitting.



Art #	Product
AU181870	AP Integra® Argon/CO <sub>2</sub> 12lpm
AU181950	AP Integra® Argon/CO <sub>2</sub> 15lpm
AU181960	AP Integra® Argon/CO <sub>2</sub> 18lpm

## MIG Side Cutters

Suitable for a variety of applications, side cutters are essential for any welders' toolbox. With rubber handle covers and strong jaws, the side cutters can trim filler wire and clear contact tip jams. They are drop-forged for greater reliability.



Art #	Product
ET000	MIG Side Cutters

## Skintex Blue Gloves

Fully-lined & padded Skintex offer good protection to the wearer in MIG, Stick or Oxy/Fuel welding and in plasma or oxy/fuel cutting.



Art #	Product
EAD007	Skintex Blue Gloves

## Phantom Active Auto-Darkening Helmet

A stylish auto-darkening welding helmet, suitable for all welding and cutting applications at >10Amp min current. Externally adjustable from 9-13. Fully automatic on/off. Comfortable and lightweight with 'tribal' decal design. Point of sale packaged for retail display. CE Approved



Art #	Product
FXADF600S	Phantom Active 9-13 Variable
ES9547SP	Replacement Inner Lens
ES11291SP	Replacement Outer Lens

## MIG Torch Tester

The Weldability MIG Torch Tester allows you to test any euro fitting MIG Torch quickly and effectively. Diagnose potential problems and save time and money. Ready to go straight out of the box.

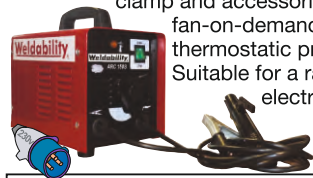


Art #	Product
ET329658	MIG Torch Tester

# STICK WELDING

## Arc 150S

A basic, portable, entry-level 150A AC Stick Welder, supplied with stick welding leads, clamp and accessories. Features fan-on-demand cooling and thermostatic protection. Suitable for a range of electrodes, from 1.6mm to 2.5mm dia.



### Product

#### Art #

TWX1A150S Arc 150S AC MMA Package

## Arc 250S

An affordable 250A AC Stick Welding machine, designed to work from a 230v or 415v power supply and supplied with stick welding leads, clamp and accessories. Features fan-on demand cooling and thermostatic protection.



Suitable for a range of electrodes, from 1.6mm to 4.0mm diameter.



### Product

#### Art #

TWX1A250S Arc 250S AC MMA Package

## Arc 200S

A portable, affordable 200A AC Stick Welding machine, designed for simple operation and supplied with stick welding leads, clamp and accessories. features fan-on demand cooling and thermostatic protection.



Suitable for a range of electrodes, from 1.6mm to 3.2mm diameter.



### Product

#### Art #

TWX1A200S Arc 200S AC MMA Package

## Arc 140i Inverter DC Package

DUAL VOLTAGE

A portable, user-friendly 140A inverter, weighing only 5kg and incorporating IGBT technology. Featuring arc-force, hot start MMA function and a smooth DC output.



### Product

#### Art #

TWX1D140i	Arc 140i Inverter 140A 230A
TWNTIG140	Tig Welding Kit

## SifDry Rod Quiver



The SifDry electrode quiver has a 200 watt (approx) heater which is thermostatically controlled to warm the rods between 80°C and 130°C and optimise their welding performance. An indicator light will show when heating is in operation. Capable of comfortably holding a full pack of 5kg electrodes. The carry handle can also serve as a stand for the quiver to rest on. Versions are available which use a 230v or 110v input power supply.

### Product

#### Art #

ZAB30011	SifDry Electrode Quiver 110v
ZAB30023	SifDry Electrode Quiver 230v

## Digital Thermometer 850°C

INNOVATION

A digital thermometer with laser targeting and temperature detection via infrared, operated via trigger control. Ideal for pre-heating, interpass-temperature measurement and controlled-cooling tasks. Can be used on practically all solid surfaces and is battery-operated, with an LCD screen. Includes K-type probe.



### Product

#### Art #

TTFX850C Sif Temp IR Thermometer

**200A/400A Earth Clamp & Cable Sets**


Complete set contains DIN type plug, 5m of single-insulated welding cable and 200A or 400A earth clamp.

**Product**
**Art #**

C250502	Earth Cable Set 25mm x 5m
C350502	Earth Cable Set 35mm x 5m
C500502	Earth Cable Set 50mm x 5m

**Cable Plug**

Popular 'DIN' type design with a locking brass male connector and insulating rubber wall. A full range is available to suit many cable sizes.


**Product**
**Art #**

EW1625PW	10-25mm <sup>2</sup> Cable Plug
EW3550PW	35-50mm <sup>2</sup> Cable Plug
EW5070PW	50-70mm <sup>2</sup> Cable Plug
EW7095PW	70-95mm <sup>2</sup> Cable Plug
EW95120PW	95-120mm <sup>2</sup> Cable Plug

**200A/400A Welding Cable Set**


Complete set european-made electrode holder, 3m or 5m of welding cable and DIN type plug.

**Product**
**Art #**

C250301	Work Cable Set 25mm x 3m
C250501	Work Cable Set 25mm x 5m
C350501	Work Cable Set 35mm x 5m
C500301	Work Cable Set 50mm x 3m
C500501	Work Cable Set 50mm x 5m

**Cable Socket**

Popular 'DIN' type design with a brass female connector and insulating rubber wall. A full range is available to suit many different cable sizes.


**Product**
**Art #**

EW1625SW	10-25mm <sup>2</sup> Cable Socket
EW3550SW	35-50mm <sup>2</sup> Cable Socket
EW5070SW	50-70mm <sup>2</sup> Cable Socket
EW7095SW	70-95mm <sup>2</sup> Cable Socket
EW95120SW	95-120mm <sup>2</sup> Cable Socket

**Panel Plug**


Popular "DIN" type design with a locking brass male connector, insulating bakelite wall and a point for internal connection to the power source. Designed to be panel mounted.

**Product**
**Art #**

EW1625PPW	10-25mm <sup>2</sup> Panel Plug
EW3550PPW	35-50mm <sup>2</sup> Panel Plug
EW7095PPW	70-95mm <sup>2</sup> Panel Plug

**Panel Socket**


Popular "DIN" type design with a locking brass female connector, insulating bakelite wall and a point for internal connection to the power source. Designed to be panel mounted.

**Product**
**Art #**

EW1625PSW	10-25mm <sup>2</sup> Panel Socket
EW3550PSW	35-50mm <sup>2</sup> Panel Socket
EW5070PSW	50-70mm <sup>2</sup> Panel Socket
EW7095PSW	70-95mm <sup>2</sup> Panel Socket
EW3550PSWST	35-50mm <sup>2</sup> - Straight

**BB Type Plug & Socket**

400A legacy BB or WSL type, fully-insulated industrial plug & socket combination for 50mm to 70mm diameter cable.


**Product**
**Art #**

EW15BB	BB Type Plug
EW16BB	BB Type Socket

**CC17 / CC18 Type Plug & Socket**

450A legacy MRX design, fully-insulated industrial cable plug & socket combination for 50mm to 70mm diameter cable.


**Product**
**Art #**

EW450/17P	CC17 Type Plug
EW450/18S	CC18 Type Socket

## SifTrod® Spezial7016



Double coated rutile-basic universal electrode. Ideal for use in pipelines and steel construction. For joint penetrations and welding in difficult positions. Excellent welding properties, smooth and pure joints. 100% second ignition. Double coating results in stable, concentrated and direct arc.

Art #	Product
RE852501	Spezial 2.5mm 1.5kg
RE853201	Spezial 3.2mm 1.5kg
RE854001	Spezial 4.0mm 1.5kg

## SifTrod® Cast NiFe



Cast iron electrode with NiFe bimetal core wire. Dedicated for cold welding grey, nodular and malleable cast iron and for joining cast iron with steel.

Excellent welding properties, does not overheat, the speed of welding is high, almost no spatters, slag removes easily.

Art #	Product
RE4002501	Cast NiFe 2.5mm 1.0kg
RE4003201	Cast NiFe 3.2mm 1.0kg
RE4004001	Cast NiFe 4.0mm 1.0kg

## SifTrod Cast Ni



A nickel-cored electrode for welding grey cast iron and for joining cast irons to other ferrous or non-ferrous metals. Leaves an easily-machineable heat-affected zone

Art #	Product
TX50025010	NI99 CI 2.5MM 1.0KG
TX50032010	NI99 CI 3.2MM 1.0KG
TX50040010	NI99 CI 4.0MM 1.0KG

## SifTrod® Bronze

Basic coated tin bronze electrode for repairing copper and copper tin bronzes, brasses and phosphor bronzes. Suitable for surfacing on brasses, wrought bronzes (CuSn), mild steel and cast steel.



Art #	Product
RE3003201	Bronze CuSn 3.2mm 1.0kg

## SifTrod® Aluminium Si12

Electrode for rapidly joining cast aluminium alloys. Recommended for joining aluminium alloys such as broken gear parts or other casting parts. Ideal for classing or rebuilding parts. Very good weldability with good penetration and porosity free deposit. Unique self-lifting slag and improved coating to protect against moisture pick up.



Art #	Product
RE1003201	Alu Si12 3.2mm 1.0kg

## SifTrod® 7024

An iron-powder rutile-coated electrode with about 150% efficiency. For butt & fillet welds on medium to thick plates in shipbuilding and structural steel.

Art #	Product
RE723250	
RE724050	7024 4.0mm 5kg
RE725050	7024 5.0mm 5kg

## SifTrod® 6010

A vac-packed cellulosic electrode for pipe welding, performing well in all positions, especially vertical down.



Art #	Product
RE612550V	6010 2.5mm 5kg
RE613250V	6010 3.2mm 5kg
RE614050V	6010 4.0mm 5kg

SifWeld® TS 200 AC/DC Inverter Welder

NEW  
PRODUCT

A professional, microprocessor-controlled inverter welding power-source for AC TIG, DC TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich.

High Frequency ignition and a pulse function on both AC and DC mode make this machine ideal for sheet metal and fine precision work. The TS 200 AC incorporates a user-friendly LCD control panel for logical operation. It suitable for AC MMA, DC+ MMA, DC- MMA, DC TIG & AC TIG welding.

Suitable for:

- Aluminium
- Sheet Metal Work, Inc. Pipe/Tube
- Stainless Steel Fabrication
- Process Engineering
- Repair & Maintenance
- General Fabrication



Art #	Product
TSX1T200ACPKG	SifWeld TS200 AC/DC TIG Package
TWX1T200KIT	TIG Torch, Reg & Clamp Kit
AU200	Flowmeter 0-15 LPN
DZ10012	MIG/Inverter Trolley
TWX1COOL230	230v 1ph Water Cooler



SifWeld® TS 200 DC Inverter Welder

NEW  
PRODUCT

A professional, microprocessor-controlled inverter welding power-source for TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich.

High Frequency ignition and a pulse function make this machine ideal for sheet metal and fine precision work. The TS 200 DC incorporates a user-friendly control panel with logical layout for operation in MMA or TIG modes. It suitable for DC+ MMA, DC- MMA & DC TIG welding.

Suitable for:

- Sheet Metal Work
- Stainless Steel Fabrication
- Process Engineering
- Repair & Maintenance
- General Fabrication



Art #	Product
TSX1T200DC	SifWeld TS200 DC Power Source
TWX1T200KIT	TIG Torch, Reg & Clamp Kit
AU200	Flowmeter 0-15 LPN
DZ10012	MIG/Inverter Trolley





## Rubber Insulated Welding Cable

Single insulated rubber welding cable manufactured to European standard quality.  
Supplied on 100m coils.  
Available cut to desired length.



Compliant with EN60974 and EN60228.



Art #	Product
EZR25RIP	25mm Rubber Insulated Cable
EZR35RIP	35mm Rubber Insulated Cable
EZR50RIP	50mm Rubber Insulated Cable

## Double Insulated Welding Cable

Double insulated rubber cable for higher duty. Flexible & strong. Available on 50m/100 coils. Cut to desired length, per metre.  
Compliant with BS683 and EN 60228



Art #	Product
EZD16DIP	16mm Double Insulated Cable
EZD25DIP	25mm Double Insulated Cable
EZD35DIP	35mm Double Insulated Cable
EZD50DIP	50mm Double Insulated Cable
EZD70DIP	70mm Double Insulated Cable

## Tubular Cable Lugs

Tubular cable lugs are used to provide secure cable fixing in crimped applications. Available in 35mm & 50mm.



Art #	Product
EW35TL	35mm Tubular Lug
EW50TL	50mm Tubular Lug

## Hammer-On Cable Lugs

Placed over end of welding cable & secured by hammering notch.  
Available in a full range to suit larger cable sizes.



Art #	Product
EW50HO	50mm Hammer-On Lug
EW70HO	70mm Hammer-On Lug
EW95HO	95mm Hammer-On Lug

## 'HiFlex' Copper Cable

Single insulated PVC copper cable manufactured to meet IEEE requirements to IEC 60332-1.  
Available in 5 sizes priced per metre, cut to length. Also available on 50m/100m coils.  
Compliant with EN60228



Art #	Product
EZC16P	16mm Single Insulated Cable
EZC25P	25mm Single Insulated Cable
EZC35P	35mm Single Insulated Cable
EZC50P	50mm Single Insulated Cable
EZC70P	70mm Single Insulated Cable

## Quick Knock-On Cable Lugs

Placed over end of welding cable and fixed by knocking slotted piece down on to cable.



Two versions for popular cable sizes.

Art #	Product
EW35KO	35mm Knock-On Lug
EW50KO	50mm Knock-On Lug

## Re-usable Cable Lugs

Secured to cable via re-usable screws & nuts.



Available in a range to suit many popular cable sizes.

Art #	Product
EW16RL	16mm Re-useable Lug
EW25RL	25mm Re-useable Lug
EW35RL	35mm Re-useable Lug
EW50RL	50mm Re-useable Lug
EW70RL	70mm Re-useable Lug

## Solder-on Cable Lug

Solder-on lugs for up to 50mm cables.



Art #	Product
EW16S0	16mm Solder-on Lug
EW25S0	25mm Solder-on Lug
EW35S0	35mm Solder-on Lug
EW50S0	50mm Solder-on Lug



The latest version of EN60974 and IEC regulations specify that welding cable should be rubber insulated. EN60228 compliance ensures all wire cross-sectional areas have the proper copper content within the conductor.

### Crocodile Clamps

Solid, rugged, design. Strong spring jaws. A full range of current sizes is available in the standard crocodile and the popular Nevada style



Art #	Product
EW200C	200 Amp Clamp
EW400C	400 Amp Clamp
EW400CB	400 Amp Clamp (Brass)

EW200NEV	200 Amp 'Nevada' Style
EW350NEV	350 Amp 'Nevada' Style
EW500NEV	500 Amp 'Nevada' Style



### Myking Style Earth Clamp

Made in the popular Myking style, this earth clamp has an insulated rubber handle & strong jaws. 600A capacity.



Art #	Product
EW131560	G-600A Earth Clamp

### Twist-Grip Holders

Popular Twist-Grip style, handle twists to grip & release the rod. Available in red or yellow with a 5mm max jaw opening.



Art #	Product
EW405W	400A Red Holder
EW400T	400A Yellow Holder
EW605	600A Red Holder
EW600T	600A Yellow Holder

### Crocodile Holders

Simple, efficient rod holders with crocodile jaws. Models for 150A to 600A.



Art #	Product
EW150CR	150A Crocodile Holder
EW200CR	200A Eco Croc Holder
EW200CRQ	200A Crocodile Holder
EW250TW	250A Tweco Style Holder
EW400HC	400A 'Hi-Cool' Holder
EW500CR	500A Crocodile Holder
EW600HC	600A 'Hi-Cool' Holder

### Screw Type Clamp

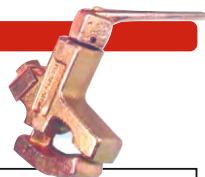
600A max current load. Operated by a screw-driven jaw. Rubber insulated handle, which cable connects through.



Art #	Product
EW600SC	600 Amp Clamp

### 'CC' - Type Earth Clamp

A strong, heavy-duty drop-forged earth clamp of solid construction. For 600A maximum current load.



Art #	Product
EW600CC	600 Amp Clamp

### 700A All Cast Earth Clamp

A strong, all-cast brass earth clamp capable of earthing up to 700A. Benefits from strong and robust screw-operated jaws.



Art #	Product
EW700SCB	700A Earth Clamp

### Myking Style Electrode Holder

A popular design electrode holder. 3 models are available for 200A, 400A & 600A maximum current



Art #	Product
EW131055	200A Holder
EW131060	400A Holder
EW131065	600A Holder

### 'Optimum' Style Holder

A versatile holder that can hold the rod at 180° or 90° angles.



Art #	Product
EW300OPT	300A Holder
EW400OPT	400A Holder

## Samson electrode holder



Samson is a high quality electrode holder with a strong crocodile type head that ensures good contact and reduces the chances of arcing-over. Samson is constructed to EN60974-11 and includes isolation between the head, spring and body - for extra safety and increased lifetime. All components are manufactured from robust materials to provide durability and drop resistance to approximately 2m. The handle includes cooling ribs which provide optimal cooling for intensive use.

Art #	Product
EV010215101	Samson 150-1 150A
EV010240201	Samson 400-2 400A

## Optimus electrode holder



Optimus is a high quality electrode holder ideal for overhead welding. Optimus is made to EN60974-11 from robust materials to provide drop resistance and includes isolation between the head, spring and body - for extra safety. Will hold electrodes in 3 positions.

Art #	Product
EV010140101	Optimus 400-1 400A
EV010160201	Optimus 600-2 600A

## Progress electrode holder



Progress is a super-quality twist-grip "stub" style electrode holder with class A electrical safety (400) and a precision-engineered jaw. Features a strong tool-steel jaw lever and a high-alloy brass body, with a reinforced handle and head for increased durability. Built to EN60974-11 and available in 400A and 600A versions.

Art #	Product
EV010341100	Progress 400-1 400A
EV010360100	Progress 600-1 600A

## Victory electrode holder



Victory is a quick-action, single-position electrode holder for welding in the most confined areas, with no exposed metal parts. With no exposed metal parts, Victory provides the highest level of isolation and electrical safety (class A for 400). The high-alloy brass head features a stainless ball-bearing tip to provide a reliable, contact. Built to EN60974-11 and available in 400A and 600A versions.

Art #	Product
EV010440100	Victory 400-1 400A
EV010460100	Victory 600-1 600A

### French Chalk

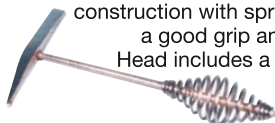
125mm x 12mm x 5mm soapstone pieces in an outer box of 144. Widely used in industry for marking. A flat holder is also available.



Art #	Product
EU10001	Flat French Chalk 144 pcs
EU10002	Flat French Chalk Holder
EU10003	Square Chalk 6 x 50 pcs

### Chipping Hammers

To remove welding slag. Strong, solid construction with spring handle to provide a good grip and reduce resonance. Head includes a chisel end and point.



A heavy-duty model is also available.

Art #	Product
EW0003	Spring Handle Hammer
EW0002	Heavy Duty Spring Handle Hammer

### Wooden Chipping Hammer

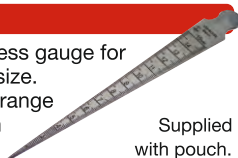
The original and most popular model chipping hammer. With solid wood handle and a double-ended chipping head.



Art #	Product
EW0001	Wooden Hammer

### Taper Gauge

A simple tapering stainless gauge for quickly measuring gap size. Range 0-15mm. Metric range on one side, imperial on the reverse.



Supplied with pouch.

Art #	Product
ET003315	Taper Gauge

### Fillet Gauge Set c/w Pouch

Stainless steel fillet gauge set for measuring a range of fillet weld dimensions in imperial and metric units. C/w pouch.



Art #	Product
ET0030	Fillet Gauge Set
ET0030METRIC	Metric Unit Fillet Gauge Set

### Pocket Fillet Gauge

A durable 2mm thick aluminium pocket fillet gauge set. Allows simple measurements of fillet leg length and troat thickness. An ideal everyday tool.



Art #	Product
EZ0029R	Pocket Fillet Gauge

### Tubular Chipping Hammer



A lightweight, reliable design with long handle & double-ended chipping head. Features a chisel end and a pointed tip to

efficiently remove slag created when welding.

Art #	Product
EW0004	Tubular Hammer

### Scratch Brushes

Alternative to wooden wire brushes. Durable plastic grip handle. Available in versions with mild steel or stainless bristles.



Art #	Product
EW133550	Mild Steel Brush (Red)
EW133550SS	Stainless Steel Brush (Green)

### HiLo Gauge

A popular design of cost-effective, easy-to-use welders gauge, for measuring root-weld space and internal misalignment. Frequently used in pipe-welding applications. Supplied with pouch.



Art #	Product
ET0032	HiLo Gauge

### Cam Type Welding Gauge

A stainless steel gauge for measuring weld preparations and completed butt & fillet welds, angle of preparation, excess weld metal, fillet leg length & throat size. C/w pouch.



Art #	Product
ET0031	Cam Type Gauge

# STICK WELDING



## SifTrove 6013-M

General purpose multi-positional rutile-coated mild steel electrode with stable arc and easy-lifting slag.



Art #	Product
RE652525	6013--M-1 2.5mm 2.5kg
RE653225	7018-1 3.2mm 2.5kg
RE654025	7018-1 4.0mm 2.5kg

RE652550	7018-1 2.5mm 5kg
RE653250	7018-1 3.2mm 5kg
RE654050	7018-1 4.0mm 5kg

## SifTrove 6013-R

SIFTrove 6013-R is a versatile and general purpose rutile-coated mild steel MMA electrode which runs smoothly and leaves an attractive weld bead.



Art #	Product
RE802050	6013-R 2.0MM 5.0KG
RE802550	6013-R 2.5MM 5.0KG
RE803250	6013-R 3.2MM 5.0KG
RE803250	6013-R 4.0MM 5.0KG

## SifChrome® Stainless Steel

SS

316L has excellent weld appearance and good corrosion resistance and is typically used on CrMo-alloyed steels. 308L is suitable for austenitic stainless steel (such as 304) and performs well in cold environments. Supplied in 4.0kg hermetically sealed cans. 3 cans per carton.



Art #	Product
RC3082540	308L 2.5mm 4.0kg
RC3083240	308L 3.2mm 4.0kg
RC3084040	308L 4.0mm 4.0kg

RC3092540	309L 2.5mm 4.0kg
RC3093240	309L 3.2mm 4.0kg
RC3094040	309L 4.0mm 4.0kg

RC3162540	316L 2.5mm 4.0kg
RC3163240	316L 3.2mm 4.0kg
RC3164040	316L 4.0mm 4.0kg

## SifTrove 7018-1



Basic coated low hydrogen electrode with high-efficiency and good mechanical properties. Supplied in 1.5kg vac pacs - to outer carton

Art #	Product
RE702550	7018-1 2.5mm 5kg
RE703250	7018-1 3.2mm 5kg
RE704050	7018-1 4.0mm 5kg

## SifTrove HF-600



Hardfacing general purpose electrode providing 57 – 62 HRC hardness. Recommended for elements exposed on heavy impact and medium abrasion.

Art #	Product
RE6003250	HF-600 3.2MM x 5.0KG
RE6004050	HF-600 4.0MM x 5.0KG
RE6005050	HF-600 5.0MM x 5.0KG

## SifChrome® Dissimilar MMA Rods

SS

When the exact grade of stainless is not known, or an application requires welding of stainless to mild steel, a dissimilar electrode can be used. 312 is a high CrNi content rod which is also suitable for difficult to weld steels and carbon steels. Supplied in 4.0kg hermetically sealed cans. 3 cans per carton.



Art #	Product
RC3122540	312 2.5mm 4.0kg
RC3123240	312 3.2mm 4.0kg
RC3124040	312 4.0mm 4.0kg



### Sifweld ST180PRO

A professional, microprocessor-controlled inverter welding power-source for MMA & TIG applications. The use of IGBT technology delivers a compact and lightweight professional welding machine for all types of welding electrode including cellulosic. The ST180 Pro incorporates a user-friendly control panel with logical layout for operation in MMA or TIG modes. It is suitable for DC+ MMA, DC-MMA & DC TIG welding. Target applications include general fabrication, sheet metal work, precision pipe work, stainless steel fabrication, process engineering and repair maintenance.



Art #	Product
TSX1ST180	SifWeld TS180 Pro package
DZ10012	Inverter trolley

### Sifweld MTS 300 IPH

The SifWeld MTS 300 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and 5m standard interconnecting cables, along with an external 4-roll wire feed system which accommodates up to 15kg D300 wire spools.

The SifWeld MTS 300 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyard tasks.

This unit can be used to weld mild low-alloy, stainless and aluminium solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG.



Art #	Product
TSX1D300MTSPS	MTS 300 Power Source
TSX1D300MTSPKG5	SifWeld MTS 300 Package
TSX3D400MTSWFU	SifWeld MTS Wire Feed Unit
TSX3D400MTSIC5	SifWeld MTS 5m IC Cable
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package

### SIFWELD MTS 250 IPH

The SifWeld MTS 250 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and integral 4-roll wire feed system which accommodates up to 15kg D300 wire spools. The SifWeld MTS 250 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyard tasks.

This unit can be used to weld mild steel, low-alloy, stainless and aluminium in solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG welding.

The SifWeld MTS 250 control system allows infinitely variable welding voltage and wire feed speed, burnback control & wire inching in MIG mode. The power source also benefits from 4T/2T torch-latching & spool gun selection.



Art #	Product
TSX1D250MTSPS	MTS 250 Power Source
TSX1D250MTSPKG	SifWeld MTS 250 Package
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package
TSX1D250SOG	SifGun Spool-On MIG Torch

### Sifweld MTS 400 3PH

The SifWeld MTS 400 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and 5m standard interconnecting cables, along with an external 4-roll wire feed system which accommodates up to 15kg D300 wire spools.

The SifWeld MTS 400 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyard tasks.

This unit can be used to weld mild steel, low-alloy, stainless and aluminium in solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG welding.



Art #	Product
TSX1D400MTSPS	MTS 400 Power Source
TSX3D400MTSPKG5	SifWeld MTS 400 Package
TSX3D400MTSWFU	SifWeld MTS Wire Feed Unit
TSX3D400MTSIC5	SifWeld MTS 5m IC Cable
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package

## Flair 2 Type Gouging Torch

The Flair 2 type gouging torch is a 600A carbon-arc torch, ideal for use in fabrication and boiler shops, shipyards, maintenance shops and foundries for applications up to 600A. It will accept round type arc gouging carbons from 4mm to 10mm diameter.

This rugged, hard-wearing torch is sold as standard without a 7ft monocable assembly, which is available separately to complete the package.



Art #	Product
ELC231055	Flair 2 Type Torch
ELC231060	Swivel Monocable Assembly

## K3 & K5 Type Gouging Torches

Our most popular and widely sold design torches. The K3 is a general-purpose, 600A carbon-arc torch, for use with 3.2 to 9.5mm gouging carbons. The K5 is a 1200A torch for use with 4.0mm to 15.9mm carbons. Supplied with monocable.



Art #	Product
ELCK3	K3 Type Gouging Torch
ELCK5	K5 Type Gouging Torch

## Cable Assembly

For connecting gouging torches to power sources and compressed air supply. Both ends of the monocables are fitted with crimps to secure the brass connectors in place. Available in 7ft lengths, replacement monocables are supplied for use with the K3, K5, K4000 and Flair 2 type carbon-arc gouging torch models.



Art #	Product
ELC231010	7ft Monocable For K3 Type Torch
ELC231050	7ft Monocable For K5 Type Torch
ELC231030	7ft For K4000 Type Torch
ELC231060	7ft For Flair 2 Type Torch

## Flair 1600 Gouging Torch



The genuine Flair 1600 is a high-quality 1600A gouging torch made of precision engineered components. This torch has an all copper body. The adjustable nozzle ensures optimal efficiency and maximum airflow - which can be controlled at the torch. The Flair 1600 is manufactured in Europe to EN60974 standards.

Torch and monocable each supplied separately.

Art #	Product
ELV060181600	Flair 1600 Torch
ELV060281601	Flair 1600 Rotating Monocable 2.5m

## K4000 Type Gouging Torch

The K4000 type gouging torch is a heavy-duty, 1000Amp carbon-arc gouging torch with a built-in 15° angled head and 360° 7ft swivel cable assembly. This torch is ideal for high-amp metal removal applications such as shipbuilding and pressure vessel manufacturing. It will accept a wide range of gouging carbons, flat and rounded, from 3.9mm to 15.7mm diameter. Light weight and reliable.



Art #	Product
ELCK4	K4000 Type Gouging Torch

## Gouging Torch Adaptor

Our K3, K4000 and K5 type gouging torches terminate in a US threaded fitting, for connection to the compressed air supply. This adaptor converts this US thread to a standard UK 3/8" BSP RH fitting.



Art #	Product
ELC38RH	Gouging Torch Adaptor

## Round Gouging Carbons

These carbons contain a precisely formulated blend of carbon and graphite that produces the most efficient metal removal performance. They offer excellent arc stability, superior metal removal rates, resistance to breakage, heat and oxidation, and provide uniform diameter and clean, slag-free grooves.



Art #	Product
ELC04305B	4.0mm x 305mm (x100)
ELC05305B	5.0mm x 305mm (x100)
ELC06305B	6.0mm x 305mm (x100)
ELC08305B	8.0mm x 305mm (x100)
ELC10305B	10.0mm x 305mm (x100)
ELC12305B	12.7mm x 305mm (x50)
ELC13430B	13.0mm x 430mm (x50)
ELC13430JC	13.0mm x 430mm Jointed (x50)
ELC16430B	16.0mm x 430mm (x25)
ELC16430JC	16.0mm x 430mm Jointed (x25)
ELC19430B	19.0mm x 430mm (x25)

## Brass Body

The lower jaw of the torch. Holds the head assembly and connects to the monocable.



Art #	Product
ELC231309	Brass Body - K3/K5
ELC234012	Brass Body - K4000
ELC232206	Brass Body - Flair 2

## Upper Arm

Connect to the pivot of the brass body part to complete the upper jaw and hold the carbon in place.



Art #	Product
ELC231307	Upper Arm - K3/K5
ELC231307	Upper Arm - K4000
ELC232204	Upper Arm - Flair 2

## Spring

Part of the lever assembly that controls the opening and closing motion of the upper arm jaw in a carbon-arc gouging torch.



Art #	Product
ELC231308	Spring - K3/K5/K4000
ELC232210	Spring - Flair 2

## Head Assembly Nozzle

Also known as 'Injector' nozzle. Fits the brass body. Holds carbon in place and carries current.



Art #	Product
ELC231305	Head Nozzle - K3/K5/K4000
ELC231306	Head Screw - K3/K5/K4000
ELC232205	Head Nozzle - Flair 2
ELC232207	Head Screw - Flair 2

## Spool & Bonnet

Operate as a valve for 'on/off' control of the compressed air. Bonnet is held in place by the spool.



Art #	Product
ELC231313	Dowel Pin- K3/K5/K4000
ELC231314	Spool Ass- K3/K5/K4000
ELC231315	Bonnet- K3/K5/K4000
ELC232215	Flair 2 P/ BTN Cap (Pair)

## Insulating Caps

Upper & lower insulators to prevent live jaw contact.



Art #	Product
ELC231301	Insulating Caps - K3/K5 (Set 2)
ELC231303	Insulating Cap Screw - K3/K5
ELC234001	Upper Insulating Cap - K4000
ELC234002	Lower Insulating Cap - K4000
ELC232203	Insulating Caps - Flair 2

## Lever Insulators

Help to raise and lower the upper arm jaw and to insulate live parts against contact. Sold each.



Art #	Product
ELC231311	Lever Insulator - K3/K5/K4000
ELC232209	Lever Insulator - Flair 2

## Handle

Shields connection between the cable and the brass body. Compressed-air control valve fits through its centre.



Art #	Product
ELC231310	Handle - K3/K5
ELC234015	Handle - K4000
ELC232217	Handle - Flair 2

## Sif Rod Cannister

A 14in yellow rod cannister for safe, airtight storage and transportation of your MMA rods.



Art #	Product
RG100SIF	Sif Rod Cannister

## Proban Balacava With Cape

The proban balacava provides protection to the head, forehead, ears, the side of the face and the neck. This version also has a cape which provides protection to shoulders. Worn under a headshield, the balacava incorporates strong velcro connectors. Proban is a durable, flame retardant material.



Art #	Product
ESF240035	Proban Balacava with Cape

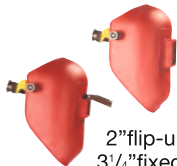
## Panther Shade 5 Specs

DIN5 shaded specs featuring a nylon nosepiece and soft PVC temple tips providing optimal comfort. Can be used in conjunction with a welding helmet as anti-flash specs. Packed 10pcs per display box.



Art #	Product
EP291000	Panther Specs SH5

## Flip-Up & Fixed Thermoplastic Helmets



A solid, hard-wearing welding helmet made from durable, lightweight thermoplastic. Complete with a comfortable headgear and a lens kit. 4 1/4" x 2" flip-up lens holder version or 4 1/4" x 3 3/4" fixed lens holder version available.

Replacement lens kits available separately.

Art #	Product
ES4434LW	4 1/4" x 3 3/4" Helmet
EFLNSG4310	Replacement Lenses
ES44X20LF	4 1/4" x 2" Flip Helmet
EFLNSG4210	Replacement Lenses

## Proban Balacava

The proban balacava provides protection to the head, forehead, ears, the side of the face and the neck. Designed to be worn beneath a headshield, the balacava incorporates strong velcro connectors which join the product around the neck & hold it in place. Proban is a durable, flame retardant material.



Art #	Product
ESF240030	Proban Balacava

## Flat-Front Handshield



A robust, plastic, hand-held protective welding shield with choice of apertures. Ideal for Stick & MIG welding. Easy to assemble. Replacement lens kits are available.

Art #	Product
ES4434FF	4 1/4" x 3 3/4" Handshield
ES4420FF	4 1/4" x 2" Handshield
ES11090FF	110mm x 90mm Handshield
EFLNSG4310	Replacement Lenses

## Red Superior Gauntlets

Our most popular red superior gauntlets are fully lined and provide a high level of comfort & protection.



Art #	Product
EAD009	Red Superior Gauntlets

## Vice Grip Clamps

A simple and cost-effective range of vice grip clamps used to hold metal work pieces in place while welding. 3 designs are available; Flat-Type, C-Type and 2 Prong-Type.



Art #	Product
ET2001	C11 C Clamp
ET2002	SM10 Flat Clamp
ET2003	W10 2 Prong Clamp



# TIG WELDING

## TIG Adaptor

An essential item for use with 'mono' style torches for connecting power and shielding gas supply to the machine. 'DIN' type power & 3/8" RH gas fittings. 2 versions available in 2 sizes. Standard model has 180° hose connection. 90° model features corner elbow to fit under machine panel louvres.



Art #	Product
RZ1625TA	16mm-25mm Type 180deg
RZ162590	16mm-25mm Type 90deg
RZ3595TA	35mm-95mm Type 180deg
RZ359590	35mm-95mm Type 90deg

## Amphenol Plugs

Amphenol type plugs are commonly used on TIG torch switch cables to interface with the welding machine, and on various peripheral cables to connect foot controls, hand controls, etc. 4 types of plug are available. The 3-pin plug is used to connect to our Weldability TIG power sources, the 4-pin plug is common on Kemppi® machines, the 14-pin is frequently used on Miller® equipment.



Art #	Product
TWN722999	3-Pin Plug (Torch Switch)
SSAMP4	4-Pin Plug
SSAMP5	5-Pin Plug
SSAMP14	14-Pin Plug

## Black Argon Hose

The correct and most popular method for the short distance transport of inert shielding gases from regulator to MIG or TIG welding machines. Durable PVC, 6mm or 10mm diameter that can be used with hose tails and appropriate nuts. It is recommended that the correct Hose Clips (page 6) are used, rather than jubilee clips.



Art #	Product
BW600BA	6mm Black Hose x 100m
BW1000BA	10mm Black Hose x 50m

## Clear Braided Hose

Clear braided hose is a very popular and versatile hose product. Often used in water recirculation attached to cooler inlet and outlet fittings, or as an alternative to using the proper black argon hose for the short transport of inert shielding gases from regulator to MIG or TIG machine.



Art #	Product
BY216000	Clear Braid Hose 6mm x 30m
BY216005	Clear Braid Hose 8mm x 30m
BY216010	Clear Braid Hose 10mm x 30m
BY216015	Clear Braid Hose 13mm x 30m

## "Ask Abe"

TIG welding has become a popular choice of process for many fabrication applications, especially on stainless steel and aluminium, because of the high weld integrity and finish quality which can be achieved. TIG is also used heavily in pipeline installation and repair work, and we now offer a complete range of pipe tools for use in such tasks - see our pipe section.



## Fitted Argon Gas Hose

A 2 metre length of black shielding gas hose complete with 3/8" BSP RH fittings and high-compression crimps at both ends. Used to connect industrial regulators to power sources or TIG adaptor plugs, to provide shielding gas to the weld zone. Manufactured to EN559.



Art #	Product
TWN004	2M Fitted Argon Gas Hose



## SifWeld TS200 AC/DC HF TIG Pulse

A professional, microprocessor-controlled inverter welding power source for AC TIG, DC TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich. High Frequency ignition and a pulse function on both AC and DC mode make this machine ideal for sheet metal and fine precision work.



Product	
Art #	
TSX1T200AC	SifWeld TS200AC Power Source
TSX1T200TIG	Replacement TIG Torch
AU200	Flowmeter 0-15 LPM
TWX1COOL230	230v 1ph Water Cooler
DZ10012	Inverter Trolley

## SifWeld TS200 DC Inverter Welder

A professional, microprocessor-controlled inverter welding power source for TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich. It is suitable for DC+ MMA, DC-MMA & DC TIG welding.



Product	
Art #	
TSX1T200DC	SifWeld TS200 DC Power Source
TWX1T200KIT	TIG Torch, Reg & Clamp Kit
AU200	Flowmeter 0-15 LPN
DZ10012	MIG/Inverter Trolley

## Turntable

300mm diameter turntable. Adjust to any angle from horizontal to right-angle. Supports 10kgs at 90° and 50kgs at 180°. Clockwise or anti-clockwise rotation, adjust to a maximum of 10 turns per minute. Supplied with a control console incorporating inch and latch start control, speed adjustment and port for connecting a remote foot or hand control. Requires a 230v 1ph mains supply and runs at 250watt power.



Product	
Art #	
TWN802331	TR Turntable Package
TWN802210	Remote Foot Control

## SifWeld TS320 AC/DC

**NEW PRODUCT**

A professional, 3ph, microprocessor-controlled inverter welding power source for AC TIG, DC TIG and MMA welding applications. The use of IGBT Technology providing a compact and lightweight machine that is feature rich. High Frequency ignition and a pulse function on both AC and DC mode make this machine ideal for sheet metal and fine precision work.



### Advanced TIG welding features include:

- Multi AC Waveform Output, including Square Wave, Sine Wave and Triangular Wave form.
- AC Balance 50% -85% Control monitors surface oxide and helps better cleaning during aluminium welding.
- High speed AC frequency up to 250HZ for a very precise and fine Arc Cone, producing a smaller HAZ when welding thin Aluminium
- High Speed Pulse from 0.5-250HZ for less distortion in AC and DC TIG welding.

Product	
Art #	
TSX3T320AC/DC	Sifweld HF TIG Pulse
TSX3T320AC	Sifweld foot pedal torch
DZ10012	Inverter Trolley

## SifVac

**INNOVATION**

SifVac is an ideal modular unit that can be modified or purpose-built for specific applications to support the extraction of fumes and dust directly at the source. A must for limited spaces that require a compact unit with a small footprint.

Can be used with SiGun FE MIG torch for highly efficient on-source



Product	
Art #	
EXTSVAC110S15	PKG 1 - Single motor head with 15ltr body
EXTSVAC110T15	Package 2 - Twin motor head with 15ltr body
EXTSVAC110C15	Package 3 - Brushless turbinehead

### Single-Stage I-Gauge Regulator

This simple regulator is designed to allow basic control of shielding gas flow and to indicate bottle contents. It has a 5/8" BSP inlet fitting and a 3/8" BSP outlet fitting, for use with either an Argon or mixed Ar/CO<sub>2</sub> gas cylinder. Pressure can be set via markings on knob. Bottle contents shown on gauge. An economical option, where accuracy isn't essential. A flowmeter can be attached.



Product	
Art #	
AE2005LX	1S 1G Argon Regulator

### Multi-Stage 2-Gauge Regulator

Designed to allow control of shielding gas flow and provide more accuracy and control over pressure. 5/8" BSP inlet fitting and a 3/8" BSP outlet. Model available to suit Argon (used in most TIG welding applications). One gauge shows pressure, the other shows bottle contents. 300 bar service. 7 bar output.



Product	
Art #	
AE7005LX	2S 2G Argon Regulator

### Shielding Gas Economiser

Proven to reduce the unnecessary loss of shielding gas by up to 50%. The shielding gas economiser works by quickly closing its valve when welding stops and reducing the amount of gas that is lost through the torch. The economiser is shipped calibrated with a flow rate of 8ltr/min but can be adjusted via an allen key fitting in the base.

Sold as a package, including a flow tube and a universal hose tail & nut combination that suits 3/8" BSP and 1/4" BSP fittings. The flow tube is also available separately.



Product	
Art #	
MW15210	Gas Economiser
MW15220	Gas Test Flowmeter 0-15lpm
MW15230	Gas Test Flowmeter 0-40lpm

### Pre-Set I-Gauge Regulator

Commonly used with a flowmeter to provide greater control over the shielding gas flow. Pre-set to 2 bar, with no pressure adjustment knob, this model displays bottle contents, on gauge. 3/8" BSP RH outlet. Owing to the single-stage nature of this regulator, output pressure can fluctuate as bottle contents drop. For greater accuracy use a multi-stage reg.



Product	
Art #	
AE2005LXPS	1S 1G Pre-Set Argon Regulator

### Flowmeter

Designed to be fitted to the outlet of an Argon or CO<sub>2</sub> regulator to provide greater control of the flow of your shielding gas through the gas line. 2 models are available, with either 0-15lpm or 0-40lpm flow rate.



Product	
Art #	
AU200	Flowmeter 0 - 15lpm
AU300	Flowmeter 0 - 40lpm

### Tungsten Sharpener Turbo-Sharp

Turbo-Sharp is a complete solution for the axial grinding of tungsten electrodes. Supplied complete in a suitcase with a mounting brace, standard adjustment knob and blue grinding head for electrodes with diameters 1.6mm, 2.0mm, 2.4mm and 3.2mm, dust extraction adapter, tungsten electrode holder and both EU and UK input power plugs. Turbo-Sharp collects and stores the resulting tungsten grinding dust for later safe disposal. To empty, simply undo the 3 retaining screws at the end of the unit. Turbo-Sharp features a 30,000 RPM motor which is powered by a 240v input supply.



Product	
Art #	
EV034591000	Turbo Sharp complete
EV034591010	Diamond grinding disc
EV034591015	Blue grinding head
EV034591020	Red grinding head
EV034591030	Lid for Turbo-Sharp
EV035001520	Tungsten Holder

## Thoriated - Tungsten ISOmm (●)

In 'red-tip' Thoriated (DC negative) for mild & stainless steel. Used to strike and maintain a TIG welding arc. ISO 6848 WTh20  
MOQ Pack of 10pcs

Art #	Product
HP16110	1.0mm Thoriated (Red Tip)
HP16112	1.2mm Thoriated (Red Tip)
HP16116	1.6mm Thoriated (Red Tip)
HP16124	2.4mm Thoriated (Red Tip)
HP16132	3.2mm Thoriated (Red Tip)
HP16140	4.0mm Thoriated (Red Tip)
HP16148	4.8mm Thoriated (Red Tip)

## Zirconiated - Tungsten ISOmm (○)

In 'white-tip' Zirconiated (AC) for aluminium etc. Used to strike and maintain a TIG welding arc. ISO 6848 WZr8. MOQ Pack of 10pcs

Art #	Product
HP16216	1.6mm Zirconiated (White Tip)
HP16224	2.4mm Zirconiated (White Tip)
HP16232	3.2mm Zirconiated (White Tip)
HP16240	4.0mm Zirconiated (White Tip)
HP16248	4.8mm Zirconiated (White Tip)
HP16255	5.5mm Zirconiated (White Tip)

## Ceriated - Tungsten ISOmm (●)

In 'grey-tip' Ceriated (AC/DC) for a range of ferrous and non-ferrous metals - with excellent ignition. (Thoria-free). ISO 6848 WCe20  
MOQ Pack of 10pcs

Art #	Product
HP16310	1.0mm Ceriated (Grey Tip)
HP16312	1.2mm Ceriated (Grey Tip)
HP16316	1.6mm Ceriated (Grey Tip)
HP16324	2.4mm Ceriated (Grey Tip)
HP16332	3.2mm Ceriated (Grey Tip)
HP16340	4.0mm Ceriated (Grey Tip)
HP16348	4.8mm Ceriated (Grey Tip)

## Pure - Tungsten ISOmm (●)

Pure tungsten 'green-tip' primarily used in AC on aluminium and magnesium. ISO 6848 WP  
MOQ Pack of 10pcs

Art #	Product
HP16410	1.0mm Pure (Green Tip)
HP16412	1.2mm Pure (Green Tip)
HP16416	1.6mm Pure (Green Tip)
HP16424	2.4mm Pure (Green Tip)
HP16432	3.2mm Pure (Green Tip)

## Lanthanated - Tungsten ISOmm (●)

In 'black-tip' (1%) Lanthanated (AC/DC) for ferrous & non-ferrous metals - with good re-ignition. ISO 6848 WL10. MOQ Pack of 10pcs

Art #	Product
HP16516	1.6mm Lanthanated (Black Tip)
HP16524	2.4mm Lanthanated (Black Tip)
HP16532	3.2mm Lanthanated (Black Tip)

## Lanthanated - Tungsten ISOmm (●)

In 'gold-tip' (1.5%) Lanthanated (AC/DC) for ferrous & non-ferrous metals - with superior re-ignition. ISO 6848 WL15. MOQ Pack of 10pcs

Art #	Product
HP16616	1.6mm Lanthanated (Gold Tip)
HP16624	2.4mm Lanthanated (Gold Tip)
HP16632	3.2mm Lanthanated (Gold Tip)

## SuperStrike - Tungsten ISOmm (●)

'Blue tip' special-formula SuperStrike tungstens for improved performance and safety over Thoriated in DC, and better arc stability in AC over a 0-300Amp current range. ISO 6848 WL20. MOQ Pack of 10pcs

Art #	Product
HP16716	1.6mm SuperStrike (Blue Tip)
HP16724	2.4mm SuperStrike (Blue Tip)
HP16732	3.2mm SuperStrike (Blue Tip)

- Thoriated
- Zirconiated
- Ceriated
- Pure
- Lanthanated (1%)
- Lanthanated (1.5%)
- SuperStrike



## WCF - Collets



Art #	Product
RWN13N21	0.040 Collets (Pk5) - to suit 9 & 20
RWN13N22	1/16 Collets (Pk5) - to suit 9 & 20
RWN13N23	3/32 Collets (Pk5) - to suit 9 & 20
RWN13N24	1/8 Collets (Pk5) - to suit 9 & 20
RWN10N23	1/16 Collets (Pk5) - to suit 17,18 & 26
RWN10N24	3/32 Collets (Pk5) - to suit 17,18 & 26
RWN10N25	1/8 Collets (Pk5) - to suit 17,18 & 26
RWN54N20	5/32 Collets (Pk5) - to suit 17,18 & 26

## WCF - Collet Bodies



Art #	Product
RWN13N26	0.040 Collet Body (Pk5) - to suit 9 & 20
RWN13N27	1/16 Collet Body (Pk5) - to suit 9 & 20
RWN13N28	3/32 Collet Body (Pk5) - to suit 9 & 20
RWN13N29	1/8 Collet Body (Pk5) - to suit 9 & 20
RWN10N31	1/16 Collet Body (Pk5) - to suit 17,18 & 26
RWN10N32	3/32 Collet Body (Pk5) - to suit 17,18 & 26
RWN10N28	1/8 Collet Body (Pk5) - to suit 17,18 & 26
RWN406488	5/32 Collet Body (Pk5) - to suit 17,18 & 26

## WCF - Gas Lens Collet Bodies



Art #	Product
RWN45V42	1.0mm Gas Lens Collet Body (Pk5) - to suit 9 & 20
RWN45V43	1.6mm Gas Lens Collet Body (Pk5) - to suit 9 & 20
RWN45V44	2.4mm Gas Lens Collet Body (Pk5) - to suit 9 & 20
RWN45V45	3.2mm Gas Lens Collet Body (Pk5) - to suit 9 & 20
RWN45V25	1.6mm Gas Lens Collet Body (Pk5) - to suit 17,18 & 26
RWN45V26	2.4mm Gas Lens Collet Body (Pk5) - to suit 17,18 & 26
RWN45V27	3.2mm Gas Lens Collet Body (Pk5) - to suit 17,18 & 26
RWN45V28	4.0mm Gas Lens Collet Body (Pk5) - to suit 17,18 & 26

## WCF - Back Caps



Art #	Product
RWN41V33	Short Back Cap - to suit torch types 9 & 20
RWN41V35	Medium Back Cap - to suit torch types 9 & 20
RWN41V24	Long Back Cap - to suit torch types 9 & 20
RWN57Y04	Short Back Cap - to suit torch types 17,18 & 26
RWN57Y02	Long Back Cap - to suit torch types 17,18 & 26

## WCF - Switches



Art #	Product
RWNSW1	Tig Torch Switch (On/Off)
RWNSW1-4	Switch And 4M Lead
RWNSW1-8	Switch And 8M Lead

## WCF - Zipper Covers



Art #	Product
RWNCC310	10ft Zipper Cover
RWNCC322	22ft Zipper Cover

# TIG Torches


**WCF**
*Weldcraft®-compatible*

A range of air and water-cooled TIG torches in Ergonomic and Classic styles. The ergonomic SifGUN® range features a handle that is designed to the grip of a welder's hand for ultimate comfort. The handle houses an integral control switch and has a knuckle joint at the base of the handle to reduce cable wear. All our TIG torches are supplied with switch and sheath and are available with 4m or 8m cable sets.




Single-piece torches terminate in 3/8<sup>th</sup> BSP right hand power corrections and bare 2-core switch cables.


## WCF - SifGun® TIG Torches

	Art #	4m Cable	8m Cable
	WP9 SifGUN® TIG Torch	FXTT0904M	FXTT0908M
	WP17 SifGUN® TIG Torch	FXTT1704M	FXTT1708M
	WP26 SifGUN® TIG Torch	FXTT2604M	FXTT2608M
	WP18 SifGUN® TIG Torch	FXTT1804M	FXTT1808M
	WP20 SifGUN® TIG Torch	FXTT2004M	FXTT2008M


## WCF - Classic TIG Torches. Switched & Sheathed

	Art #	4m Cable	8m Cable
	WP9 Torch	RWN9-12SS	RWN9-25SS
	WP9 Torch Flexi	RWN9F-12SS	RWN9F-25SS
	WP17 Torch	RWN17-12SS	RWN17-25SS
	WP17 Torch Flexi	RWN17F-12SS	RWN17F-25SS
	WP26 Torch	RWN26-12SS	RWN26-25SS
	WP26 Torch Flexi	RWN26F-12SS	RWN26F-25SS
	WP18 Torch	RWN18-12SS	RWN18-25SS
	WP18 Torch Flexi	RWN18F-12SS	RWN18F-25SS
	WP20 Torch	RWN20-12SS	RWN20-25SS
	WP20 Torch Flexi	RWN20F-12SS	RWN20F-25SS

## WCF - Ceramics

	Art #	Product	
	RWN13N08	1/4 Alumina Nozzle (Pk10)	- to suit 9 & 20
	RWN13N09	5/16 Alumina Nozzle (Pk10)	- to suit 9 & 20
	RWN13N10	3/8 Alumina Nozzle (Pk10)	- to suit 9 & 20
	RWN10N49	5/16 Alumina Nozzle (Pk10)	- to suit 17, 18 & 26
	RWN10N48	3/8 Alumina Nozzle (Pk10)	- to suit 17, 18 & 26
	RWN10N47	7/16 Alumina Nozzle (Pk10)	- to suit 17, 18 & 26

## WCF - Gas Lens Ceramics

	Art #	Product	
	RWN53N58	1/4 Gas Lens Nozzle (Pk10)	- to suit 9 & 20
	RWN53N59	5/16 Gas Lens Nozzle (Pk10)	- to suit 9 & 20
	RWN53N60	3/8 Gas Lens Nozzle (Pk10)	- to suit 9 & 20
	RWN54N17	5/16 Gas Lens Nozzle (Pk10)	- to suit 17, 18 & 26
	RWN54N16	3/8 Gas Lens Nozzle (Pk10)	- to suit 17, 18 & 26
	RWN54N15	7/16 Gas Lens Nozzle (Pk10)	- to suit 17, 18 & 26



**Sif Mild Steel TIG Rods**
**STL**

Sifsteel A15 is a popular copper-coated triple-deoxidised mild steel TIG welding rod, which enables sound porosity-free welds to be made on mild and low-alloy steels in applications including pipe and root runs on heavy vessels. Sifsteel A18 is a G4Si1-grade deoxidised mild steel TIG welding rod for a wide range of mild steel applications.


**sif**
**Product**
**Art #**

RA151650	Sif A15 1.6mm 5.0kg
RA152450	Sif A15 2.4mm 5.0kg
RA153250	Sif A15 3.2mm 5.0kg

RA181650	Sif A18 1.6mm 5.0kg
RA182450	Sif A18 2.4mm 5.0kg
RA183250	Sif A18 3.2mm 5.0kg

**Sif Aluminium TIG Rods**
**AL**

SIF aluminum TIG alloys have become widely specified for their clean, reliable surface finish and consistent welding characteristics. Sifalumin No15 is our general-purpose 4043 5% silicon aluminium alloy for use on a wide range of grades. Sifalumin No27 is a 5% magnesium 5356 aluminium alloy, used where greater UTS is required.


**sif**
**Product**
**Art #**

RO151625	Sif No15 4043A 1.6mm 2.5kg
RO152425	Sif No15 4043A 2.4mm 2.5kg
RO153225	Sif No15 4043A 3.2mm 2.5kg
RO271625	Sif No27 5356A 1.6mm 2.5kg
RO272425	Sif No27 5356A 2.4mm 2.5kg
RO273225	Sif No27 5356A 3.2mm 2.5kg

**Sif Purging FLUX**
**INNOVATION**

A flux used in TIG applications to shield the rear of a weld joint from oxygen contamination, dissipate heat and oxides during welding and prevent re-oxidation. Formulated to suit stainless steel and high nickel super alloys. Ideal for pipe and tube welding applications. Supplied in 500g jar.


**Product**
**Art #**

FO210050	Sif Purging Flux 500G Jar
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**Sif Stainless TIG Rods**
**SS**

The Sif range offers a full suite of stainless steel TIG rod grades to suit most common applications. 316L is a popular stainless grade, used in many industries including pipe, catering etc.


**sif**
**Product**
**Art #**

RO211650	Sif 316L 1.6mm 5.0kg
RO212450	Sif 316L 2.4mm 5.0kg
RO213250	Sif 316L 3.2mm 5.0kg

**Sif TIG Brazing Rods**
**CU**

Sif No8 is a phosphor-bronze TIG rod containing 7% tin and suitable for fusion welding of phosphor bronze castings and copper alloys (brass). It is also used for TIG brazing on ferrous and dissimilar metals. Sif No968 contains 3% silicon and 1% manganese and is frequently used for TIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications.


**sif**
**Product**
**Art #**

RO961250	Sif No968 1.2mm 5.0kg
RO961650	Sif No968 1.6mm 5.0kg
RO962450	Sif No968 2.4mm 5.0kg
RO963250	Sif No968 3.2mm 5.0kg

RO081250	Sif No8 1.2mm 5.0kg
RO081650	Sif No8 1.6mm 5.0kg
RO082450	Sif No8 2.4mm 5.0kg
RO083250	Sif No8 3.2mm 5.0kg

**SIF Pickling Paste**

A strong, colourless pickling paste for use on stainless steels to remove weld oxide, and burn marks and improve the final appearance of the welded stainless metal.

Supplied in 2kg jars and shipped in cartons of 6 jars.

Brush included.

A neutraliser is also available to remove the paste from unwanted areas.


**sif**

**A HazChem transport cost may be applied.**

**Product**
**Art #**

FXPICK20	SIF Pickling Paste Jar 2kg
FXPICKNP	SIF Neutralising Paste 2kg

### Inspection Brushes

Small inspection brushes, black handled with mild steel bristles and orange handled with stainless steel bristles. Used for accurate cleaning of weld areas during inspection.



Art #	Product
EBW192	Mild Steel Inspection Brush
EBW192SS	Stainless Steel Inspection Brush

### Inspection Mirror And Led Torch

**INNOVATION**

A versatile inspection mirror with bright LED illumination adjacent to the mirror. The mirror head is extendable, with a flexible neck, making it ideal for inspection of pipe root beads or in restricted access areas.



Handle/arm Length 177-558mm  
Mirror diameter 35mm.

Art #	Product
ETIMLED	LED Torch & Inspection Mirror

### Phantom XL Large-Lens ADF MKII

An attractive mid-market welding helmet with professional technology auto-darkening lens for precision TIG welding and production fabrication. Suitable for all applications. 2Amp min current. Internally adjustable from 9 - 13 with largest viewing area (97x62). Comfortable and lightweight with a 'pinstriped flame' decal design. Compliant to EN175B.



Features Grind Mode.

Art #	Product
FXADF800S	Phantom XL 9-13 Variable
ES9866SP	Replacement Inner Lens MKI
ES9766SP	Replacement Inner Lens MKII
ES133114SP	Replacement Outer Lens

### Aluminised Heat-Guard Pad

Small, aluminised, slip-on protective sleeves, worn over welding gloves to provide additional protection to the hands in close-up, high-heat applications. This heat guard pad is designed to be used on either hand or both.



Art #	Product
EAD010AMB	Heat Guard Ambidextrous

### Mordant Leather TIG Gloves

Designed to be lightweight and comfortable to wear and allow easy movement of a TIG rod across the palm. Soft leather palm and fingers.



Art #	Product	CAT II CE EN 388 EN 407
EAD005	Mordant TIG Gloves	

### Fine Hide TIG Gloves

Popular among TIG welders the fine hide design allows easy movement of a TIG rod across the palm and are comfortable to wear.



Art #	Product	CAT II CE EN 388 EN 407
EAD006	Fine Hide TIG Gloves	

### Flame Resistant Overalls

Weldability navy blue overalls are flame-retardant and feature breast pockets, back pocket and ruler pocket. They are fastened by snap buttons, which are concealed for extra safety, and have an elasticated waist for heightened comfort.



Art #	Product
PV500102	Proban Overall - M Chest 40" - 41"
PV500103	Proban Overall - L Chest 42" - 44"
PV500103	Proban Overall - XL Chest 46" - 48"
PV500103	Proban Overall - XXL Chest 50" - 52"
PV500103	Proban Overall - XXXL Chest 54" - 55"

### 250mm Straight Arms

Optional air-cooled 250mm straight arms for use with the Spot 20/TI and the Digital Spot 230. These arms have a 20mm diameter and allow longer reach spot welding. Supplied as a pair, complete with long top and short bottom straight style electrodes.

These electrodes have a diameter of 12mm.



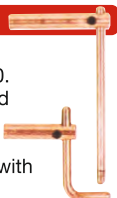
Art #	Product
TWN803152	250mm Arms

### External Profile Arms

Optional air-cooled arms for use with the Spot 20/TI and the Digital Spot 230. These arms have a 20mm diameter and allow spot welding to be carried out on the external edge of lips, sils, etc...

They are supplied as a pair, complete with long top and short, curved bottom electrodes.

These electrodes have a diameter of 12mm.



Art #	Product
TWN803158	External Profile Arms

### 120mm Narrow Arms

Optional air-cooled 120mm arms for use with the Spot 20/TI and the Digital Spot 230. These arms have a 20mm diameter.

They are supplied as a pair, complete with curved 'pincer' electrodes for precise spot welding when access to confined space is a problem.

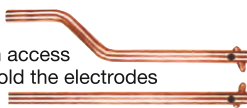
These electrodes have a diameter of 12mm.



Art #	Product
TWN803155	120mm Narrow Arm

### 350mm Narrow Arms

Optional air-cooled 350mm cranked arms for use with the Spot 20/TI and the Digital Spot 230, for precise spot welds when access is difficult. These arms hold the electrodes at an angle and have a 20mm diameter. Supplied as a pair, with short, equal length electrodes with a 12mm diameter.



Art #	Product
TWN803154	350mm Narrow Arm

### 350mm Angled Arms

Optional air-cooled 350mm arms with electrodes held at an angle.

For the Spot 20/TI and Digital Spot 230. These arms have a 20mm diameter and are provided as a pair, with equal length top & bottom 12mm diameter electrodes.



Art #	Product
TWN803153	350mm Angled Arm

### Internal Profile Arms

Optional air-cooled arms for use with the Spot 20/TI and the Digital Spot 230. These arms have a 20mm diameter and allow spot welding to be carried out on the internal edge of lips, sils, etc... They are supplied as a pair, complete with long bottom & short, curved top electrodes, which have a diameter of 12mm.



Art #	Product
TWN803159	Internal Profile Arms

### 120mm Arms

Replacements for the standard length, air-cooled arms that are shipped with the Spotter 9000, the Spot 20/TI, the Digital Spot 230 and the Digital Spot 400. These arms have a 20mm diameter and are provided as a pair, complete with a short bottom electrode and a long top electrode. These electrodes have a diameter of 12mm.



Art #	Product
TWN803151	120mm Arms

### 120mm Angled Arms

Optional air-cooled 120mm arms with electrodes held at a 45 angle. For use with the Spotter 9000, the Spot 20/TI, the Digital Spot 230 and the Digital Spot 400. These arms have a 20mm diameter and are provided as a pair, complete with a pair of equal length top and bottom electrodes. They have a 12mm diameter.



Art #	Product
TWN803150	120mm Angled Arm

# SPOT WELDING



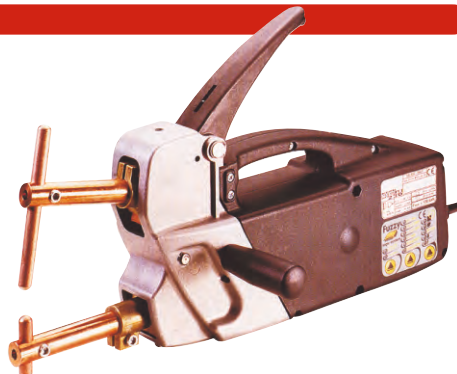
## Digital Spot 230

A 230v single phase, portable, micro-processor-controlled, manually operated spot welding machine. This unit features a new "fuzzy logic" control system that simplifies its use and increases the spot welding quality, by automatic adjustment of the welding time and current with respect to the thickness of the material. Suitable for spot welding sheets to a maximum thickness of 2mm to 2mm. Choose between continuous and pulsed operation (suitable for sheets with high yield points).

Arm pressure can be adjusted from 40kgs to 120kgs.

Fitted with standard 120mm arms.

18 kVA



## PCP 28 Pneumatic Pedestal Spot

400v 2ph column spot welder with pneumatic arm control. The PCP 28 is rated at 25kVA @50% (60kVA max). Welds a maximum of 5mm to 5mm mild steel. 350mm arms. Includes stepless electronic thyristor output control, electronic timer, fan-cooled cabinet, adjustable electrode force & water-cooled arms and electrodes, which require cooling by an additional cooler. A range of optional arms and electrodes are available.



## Pedestal Electrodes

Two types of 19mm diameter electrodes for use with the pedestal arms on the PCP 18 and PCP 28 spot welders. The straight electrode has a height of 45mm and the curved electrode has a height of 75mm. The curved electrode, which has a 6mm step, can be used in applications where access over a lip or edge is needed to spot weld.



### Product

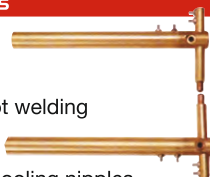
Art #	
TWN690035	Straight Electrode
TWN690036	Curved Electrode
TWN443020	Electrode Holder

### Product

TWN824023	PCP 28
TWX1COOL230	230v Cooler

## 500mm Pedestal Arms

Optional extended length 500mm arms that can be used with the PCP 18 and PCP 28 pedestal spot welding machines. Similar to the 350mm arms, these longer arms have water-cooling nipples and 190mm long electrode holders.

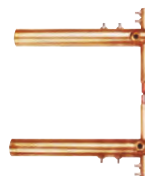


### Product

Art #	
TWN803101	500mm Arms

## 350mm Pedestal Arms

Replacements for the standard length arms that are shipped with the PCP 18 and PCP 28 pedestal spot welding machines. Include nipples for connection to water supply hoses and should be used with a water cooler. They have a 45mm diameter and include 25mm diameter, 190mm long holders for 19mm dia electrodes with a 13mm to 15mm tapered fixing.



### Product

Art #	
TWN803100	350mm Arms

**Weldability®**
*The Welder's One-Stop Shop*
**BZL**

Binzel®-compatible


**BZL - PSB30/PSB3I Plasma Torch Spares**

Fig #	Art #	Product	Manu Ref
1	SWPC306	Electrode ZR x 14.5mm	744.0014
	SWPC307	Electrode ZR x 15mm	744.0013
	SWPC308	Electrode ZR x 15.5mm	744.0012
	SWPC304	Insulator HF Style	744.0076
2	SWPC336	Spring	744.0024
4	SWPC302-10	Cutting Tip Stand 1.0mm	744.0010
4	SWPC302-12	Cutting Tip Stand 1.2mm	744.0061
5	SWPC303	Protective Nozzle	744.0011
1	SWPC310	Electrode ZR x 15.5mm	742.0016
	SWPC311	Electrode ZR x 16mm	742.0017
	SWPC312	Electrode ZR x 16.5mm	742.0018
	SWPC336	Spring	744.0024
3	SWPC320	Insulator Non HF	742.0025
4	SWPC313	Cutting Tip 1.0mm	742.0011
	SWPC314	Cutting Tip 1.2mm	742.0026

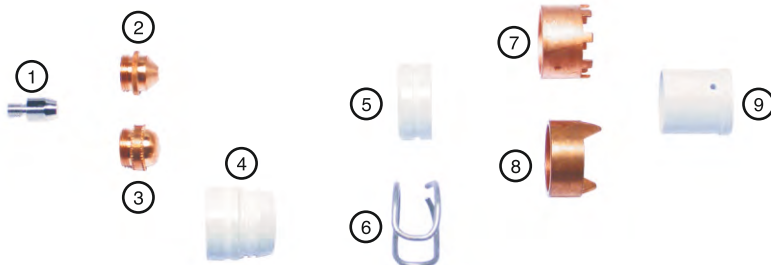

**BZL - PSB60 / 80 / I2I Plasma Torch Spares**

Fig #	Art #	Product	Manu Ref
1	SWPC801ZR	Electrode Zirconium	743.0077
	SWPC801	Electrode Hafnium	743.0067
2	SWPC802-10	Cutting Tip 1.0mm	743.0122
	SWPC802-13	Cutting Tip 1.3mm	743.0142
	SWPC802-15	Cutting Tip 1.5mm	743.0132
	SWPC802-18	Cutting Tip 1.8mm	743.0209
3	SWPC810-10	Cutting Tip 1.0mm 30°	743.0202
	SWPC810-13	Cutting Tip 1.3mm 30°	743.0261
	SWPC810-15	Cutting Tip 1.5mm 30°	743.0203
4	SWPC807	Stand Off Nozzle	743.0131
6	SWPC811	Stand Off Spring	743.0149
5	SWPC806	Distance Nozzle Collet	743.0125
7	SWPC804	Copper Nozzle Standard	743.0127
8	SWPC808	Copper Nozzle Double Point	743.0168
9	SWPC803	Distance Nozzle Holder	743.0126



# PLASMA CUTTING



## SifWeld® Cut 40

The SifWeld Cut40 Digital is a professional 40Amp plasma cutting system designed for hand-held efficient cutting, manufacturing, sheet metal, general maintenance industries and automotive.

Featuring IGBT inverter technology, the SifWeld Cut40 Digital plasma cutter is engineered to consistently deliver heavy-duty cutting performance. This is ideal to cut up to 12mm thick steel. The 4m cutting torch ensures exceptionally smooth, clean cuts, and comes with a quick-connect euro adapter to ensure effortless connection, and cost effective replacement of the torch. The SifWeld Cut40 Digital can be used to efficiently cut mild and low-alloy steels, stainless, aluminium, copper, titanium and nickel alloys.



Art #	Product
TSX1P40	Cut40 Digital Package
TSX1P4003	Cut40 Digital 4m torch
SWPD116-08	Tip
SWPR110	Electrode
SWPC116	Shield Cup
SWPE106	Air diffuser
TSX1P4004	Earth return
TSX1P4005	Hi-flow air connector



## SifWeld® Cut 100

The SifWeld Cut100 is a professional 100Amp 3ph plasma cutting system designed for hand-held efficient cutting in the heavy fabrication, manufacturing, demolition and general maintenance industries.

Featuring IGBT inverter technology, the SifWeld Cut100 plasma cutter is engineered to consistently deliver heavy-duty cutting performance. This is ideal to cut up to 30mm thick steel. The 6m high-frequency cutting torch ensures exceptionally smooth, clean cuts, and comes with a quick-connect central adapter to ensure effortless connection, and cost effective



Art #	Product
TSX3P100	Cut100 Package
TSX3PTA101	Cut40 Digital 4m torch
SWPD101-11	Cutting Tip 1.1mm
SWPD101-14	Cutting Tip 1.4mm
SWPD101-17	Cutting Tip 1.7mm
SWPR101	Electrode
SWPC109	Nozzle
SWPE101	Air Diffuser
SWCV11	Stand-off Spring
TSX3D400MTSTR	SifWeld MTS Trolley



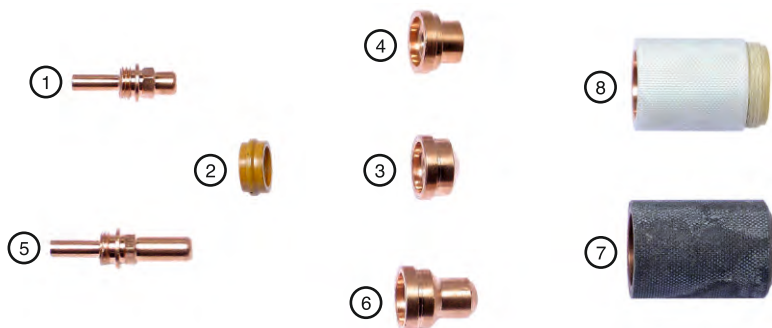

**HYP - MAX 80 / 100 Plasma Torch Spares**

Fig #	Art #	Product
1	SW020191	Electrode Air (#120433)
2	SW020194	Swirl Ring
	SW020203	Cutting Tip 1.0mm
3	SW020345	Cutting Tip 1.3mm
	SW020195	Cutting Tip 1.5mm
4	SW020397	Cutting Tip 1.3mm Shielded
	SW020337	Cutting Tip 1.5mm Shielded
5	SW020564	Long Electrode Air
6	SW020563	Cutting Tip Extended
7	SW020184	Nozzle Retaining Cap
	SW020336	Shield Cap
	SW020334	Machine Shield 100 Amp
8	SW020189	Torch Head Hand Max80/100
	SW020333	Deflector
	SW120282	Cutting Tip 50 A Shield (PM800)

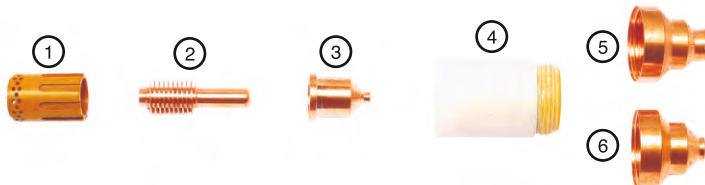

**HYP Max I250/I650 Plasma Torch Parts**

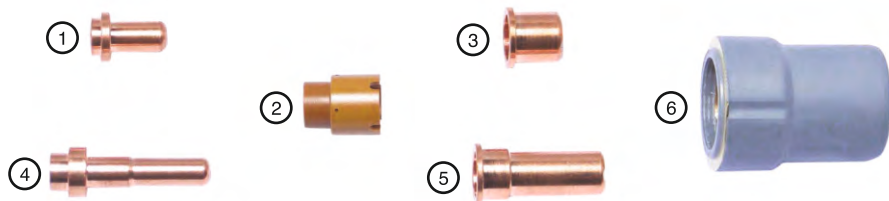
Fig #	Art #	Product
1	SW120925	Swirl Ring
2	SW120926	Electrode HF
	SW120932	Tip 40 A
3	SW120931	Tip 60 A
	SW120927	Tip 80 A
4	SW120928	Cap Retaining
5	SW120929	Shield Hand
	SW120930	Shield Machine
1	SW220051	Swirl Ring
2	SW220037	Electrode HF
3	SW220011	Tip 100 A
4	SW220048	Cap Retaining
5	SW220065	Shield Hand
6	SW220047	Shield Machine

**Weldability®**

*The Welder's One-Stop Shop*

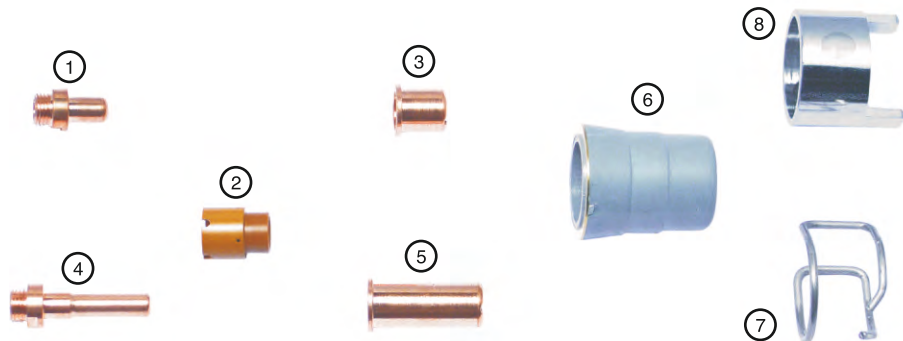
**CEB**

Cebora®-compatible



## CEB - PROF 35 / 50 Plasma Torch Spares

Fig #	Art #	Product
1	SWC1520	Electrode Hafnium Insert
	SWC1521	Electrode Hafnium Insert
2	SWC1510	Swirl Ring - Vespel
3	SWC1304	Cut/Tip Flat 1.0mm 35-50 A
	SWC1305	Cut/Tip Conical 1.0mm 35-50 A
4	SWC1518	Long Electrode Hafnium Insert
	SWC1519	Long Electrode Hafnium Insert
5	SWC1370	Cutting Tip Long 1.0mm
	SWC1306	Cut/Tip Long Conical 1.0mm 35-50 A
6	SW5.710.121	Nozzle Retaining Cap



## CEB - PROF 52 / 70 Plasma Torch Spares

Fig #	Art #	Product
1	SWC1402	Electrode Hafnium Insert
2	SWC1510	Swirl Ring - Vespel
3	SWC1396	Cutting Tip 1.0mm
	SWC1308	Cutting Tip 1.2mm
4	SWC1403	Long Electrode Hafnium Insert
5	SWC1395	Cutting Tip Long Life 1.0mm
6	SWC5710171	Nozzle Retaining Cap
7	SWC1394	Spacer Spring
8	SWC1405	Double Pointed Spacer

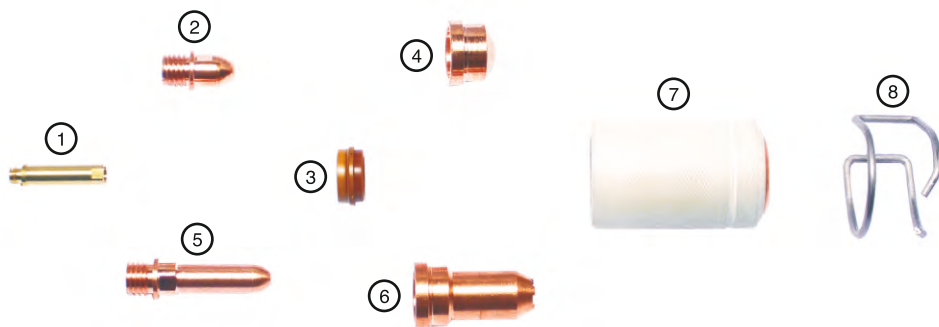

**CEB - PROF 90 / I20 / I50 / I60 Plasma Torch Spares**

Fig #	Art #	Product
1	SWC1378	Air Diffuser
2	SWC1376	Electrode Hafnium Insert
4	SWC1371	Cut/Tip Conical 1.1mm 40-60 A
	SWC1372	Cut/Tip Conical 1.35mm 50-80 A
	SWC1373	Cut/Tip Conical 1.6mm 70-90 A
	SWC1374	Cut/Tip Conical 1.8mm 100-150A
5	SWC1375	Cut/Tip Gouging 3.0mm 120-150A
	SWC1517	Long Electrode Hafnium Insert
6	SWC1369	Cut/Tip Long 1.1mm 40-60 A
	SWC1390	Cut/Tip Flat 1.35mm 50-80 A
	SWC1391	Cut/Tip Flat 1.6mm 70-90 A
	SWC1392	Cut/Tip Flat 1.8mm 120-150 A
7	SWC1389	Nozzle Retaining Cap
	SWC1408	Double Point Spacer
8	SWC1386	Spacer Spring

**Weldability®**
*The Welder's One Stop Shop*

Trafimet®-  
compatible

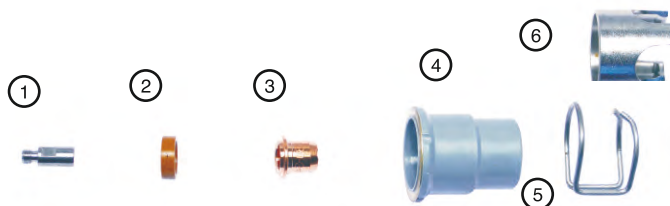
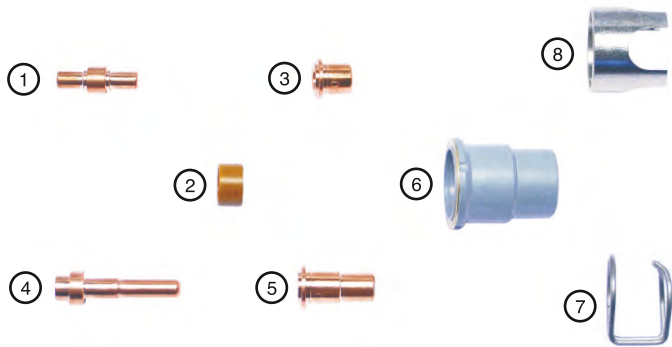
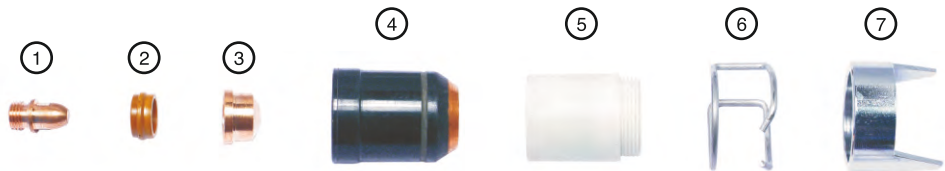
**TRF**

**TRF - S54 Plasma Torch Spares**

Fig #	Art #	Product
1	SWPR105	Electrode
	SWPR106	Long Electrode
2	SWPE106	Swirl Ring
3	SWPD102	Cutting Tip 1.0mm
	SWPD103	Cutting Tip Long 1.0mm
4	SWPC115	Protective Nozzle
5	SWCV28	Stand Off Spring
6	SWCV33	Crown Shield



TRF - ABO Plasma Torch Spares

Fig #	Art #	Product
1	SWPR107	Electrode
	SWPR109	Electrode Long Life
2	SWPE107	Swirl Ring
3	SWPD105	Cutting Tip 1.0mm
	SWPD105-12	Cutting Tip 1.2mm
4	SWPR108	Long Electrode Long Life
	SWPR115	Extended Electrode Long Life
5	SWPD106	Cutting Tip Long 1.2mm
6	SWPC115	Protective Nozzle
7	SWCV28	Stand Off Spring
8	SWCV33	Crown Shield



TRF - A90 Plasma Torch Spares

Fig #	Art #	Product
1	SWPR101	Electrode
2	SWPE101	Power Insulator
	SWPD101-11	Cutting Tip 1.1mm 40-60 A
3	SWPD101-14	Cutting Tip 1.4mm 50-80 A
	SWPD101-17	Cutting Tip 1.7mm 70-120 A
	SWPD101-19	Cutting Tip 1.9mm 110-140 A
4	SWPC109	Nozzle Assembly
5	SWPC113	Nozzle Insulator
6	SWCV11	Stand Off Spring
7	SWCV12	Crown Shield 2 Pin
	SWCV14	Crown Shield 4 Pin
	SWCV23	Spacer - Contact-Cut



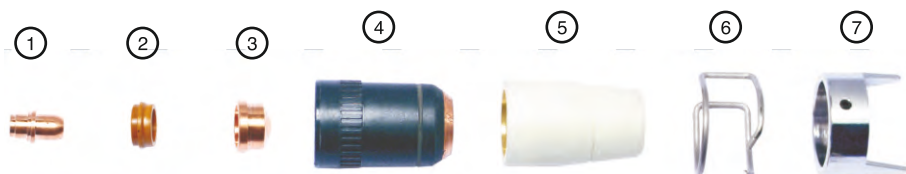

**TRF - Al40/RI45 Plasma Torch Spares**

Fig #	Art #	Product	
1	SWPR101	Electrode	A140
2	SWPE101	Power Insulator	A140
3	SWPD101-11	Cutting Tip 1.1mm 40-60 A	A140
	SWPD101-14	Cutting Tip 1.4mm 50-80 A	A140
	SWPD101-17	Cutting Tip 1.7mm 70-120 A	A140
	SWPD101-19	Cutting Tip 1.9mm 110-140 A	A140
4	SWPC101	Nozzle Assembly Stand Off	A140
	SWPC103	Contact Cutting Insulator	A140
	SWCV12	Crown Shield 2 Pin	A140
6	SWCV14	Crown Shield 4 Pin	A140
7	SWCV11	Stand Off Spring	A140
	SWCV13	Gouging Attachment	A140
1	SWPR111	Electrode	R145
2	SWPE103	Power Insulator	R145
3	SWPD109-14	Cutting Tip 1.4mm	R145
	SWPD109-16	Cutting Tip 1.6mm	R145
	SWPD109-18	Cutting Tip 1.8mm	R145
5	SWPC120	Nozzle Assembly	R145

**sif**

**Cut40 torch parts**

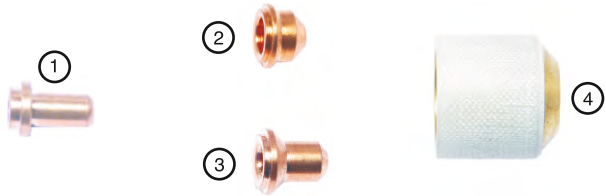
Fig #	Art #	Product
1	SWPR110	Electrode
2	SWPE106	Air diffusor
3	SWPD116-08	Tip
4	SWPC116	Shield cup
5	SWCV11	Stand off spring

**Cut100 torch parts**

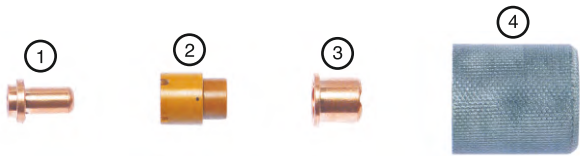
Fig #	Art #	Product
1	SWPR101	Electrode
2	SWPE101	Air diffusor
3	SWPD101-11	Tip
5	SWPC109	Nozzle
	SWCV11	Stand off spring

**Weldability®**  
The Welder's One-Stop Shop

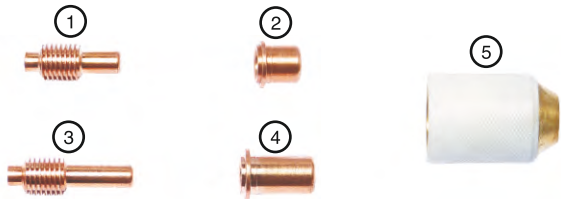
**HYP**  
Hypertherm®-compatible



HYP - MAX 20 Plasma Torch Spares			
Fig #	Art #	Product	
1	SW020382	Electrode	
2	SW020299	Cutting Tip	
3	SW020381	Long Cutting Tip	
4	SW020218	Retaining Cap	



HYP - MAX 40 Plasma Torch Spares			
Fig #	Art #	Product	
1	SW020103	Electrode Hafnium Air	
2	SW020101	Swirl Ring	
3	SW020115	Cutting Tip Flat	
4	SW020104	Nozzle Retaining Cap	



HYP - MAX 42 Plasma Torch Spares			
Fig #	Art #	Product	
1	SW120573	Electrode Hafnium	
2	SW020350	Cutting Tip 0.96mm	
2	SW020395	Cutting Tip 1.06mm	
3	SW120574	Long Electrode Hafnium	
3	SW020564	Long Electrode Air	
4	SW020546	Extended Tip 1.0mm	
5	SW020930	Retaining Cap	

# sifTEMP®

**SifTemp® InfraRed Digital Thermometer**
**INNOVATION**


The SifTemp® IR is a battery operated digital thermometer which can be used for contact and non-contact temperature measurement.

When using in IR mode it can be used for non-contact measurements up to 850°C. It can also be used with K-Type surface probes (see below), for contact measurements up to 1400°C.

The back-lit LCD display allows the operator to quickly read the measured temperature. The SifTemp® IR has a variety of functions including min recorded temp, max recorded temp, difference between the min and max and average recorded temperature.

The unit has an audible alarm, which can be set to trigger at a high or low temperature levels. Laser guidance allows accurate location of the target area and a simple trigger operation allows quick, easy repeated measurements.

**Probe Type:**

Infrared and K-Type

**Measurement Range:**

IR -50°C to +850°C (-64°C to + 1400°C - contact)

**Accuracy:**

±1.5°C or 1.5%

**Battery Type:**

9v block, 15h capacity

**Certificate of Conformity available upon request**

**Art #**

TTFX850C

**Product**

Sif Temp IR Thermometer

**"Ask Abe"**



When welding in critical applications, it can be important to control the pre, interpass and post weld temperatures.

Pre-heating is often required on cast materials to minimize the possibility of cracking.

Some materials may require the post weld cooling process to be controlled.

In these applications, it is important to monitor temperatures accurately.

Our range of temperature measuring products are your ideal solution.

## Optional K-Type Surface Probes

A range of external surface probes, with K-Type connectors. Includes a waterproof surface probe with widened 5mm diameter measurement tip for flat surfaces, a fast-action surface probe with sprung thermocouple strip for uneven surfaces [measurement range (limit contact time) to +500°C], and a high-temp. magnetic probe with an adhesive force of approximately 20N.



**Product**

**Art #**

TT06021993 Surface Probe 115mm, -60 to +400°C

TT06020393 Sprung Surface Probe -60 to +300°C

TT06024892 Magnetic Probe 75mm, -50 to +400°C

## Temperature Indicator Sticks

Used for marking the workpiece before welding, preheating, heat treatment or annealing. When the rated temperature has been reached a distinct melt (smear) will become evident. Silver and Lead free.

Available in popular **Fahrenheit** and **Celsius** rated sticks.

Priced each and packed in outer boxes of 10.

°F

Art #	Product
TS0100	100°F / 38°C Temp Stick
TS0150	150°F / 66°C Temp Stick
TS0163	163°F / 73°C Temp Stick
TS0169	169°F / 76°C Temp Stick
TS0182	182°F / 83°C Temp Stick
TS0200	200°F / 93°C Temp Stick
TS0206	206°F / 97°C Temp Stick
TS0213	213°F / 101°C Temp Stick
TS0225	225°F / 107°C Temp Stick
TS0250	250°F / 121°C Temp Stick
TS0256	256°F / 124°C Temp Stick
TS0263	263°F / 128°C Temp Stick
TS0288	288°F / 142°C Temp Stick
TS0294	294°F / 146°C Temp Stick
TS0300	300°F / 149°C Temp Stick
TS0306	306°F / 152°C Temp Stick
TS0344	344°F / 173°C Temp Stick
TS0350	350°F / 177°C Temp Stick
TS0363	363°F / 184°C Temp Stick
TS0375	375°F / 191°C Temp Stick
TS0400	400°F / 204°C Temp Stick
TS0413	413°F / 212°C Temp Stick
TS0450	450°F / 232°C Temp Stick
TS0463	463°F / 239°C Temp Stick
TS0488	488°F / 253°C Temp Stick
TS0550	550°F / 288°C Temp Stick
TS0600	600°F / 316°C Temp Stick
TS0650	650°F / 343°C Temp Stick
TS0700	700°F / 371°C Temp Stick
TS0750	750°F / 399°C Temp Stick
TS0800	800°F / 427°C Temp Stick
TS0900	900°F / 482°C Temp Stick
TS0932	932°F / 500°C Temp Stick
TS1150	1150°F / 621°C Temp Stick
TS1200	1200°F / 649°C Temp Stick
TS1300	1300°F / 704°C Temp Stick
TS1450	1450°F / 788°C Temp Stick
TS1500	1500°F / 816°C Temp Stick
TS1700	1700°F / 927°C Temp Stick
TS1750	1750°F / 954°C Temp Stick
TS1800	1800°F / 982°C Temp Stick

°C

Art #	Product
TSC0040	40°C / 104°F Temp Stick
TSC0050	50°C / 122°F Temp Stick
TSC0100	100°C / 212°F Temp Stick
TSC0125	125°C / 257°F Temp Stick
TSC0150	150°C / 302°F Temp Stick
TSC0175	175°C / 347°F Temp Stick
TSC0190	190°C / 374°F Temp Stick
TSC0200	200°C / 392°F Temp Stick
TSC0210	210°C / 410°F Temp Stick
TSC0215	215°C / 419°F Temp Stick
TSC0220	220°C / 428°F Temp Stick
TSC0225	225°C / 437°F Temp Stick
TSC0250	250°C / 482°F Temp Stick
TSC0260	260°C / 500°F Temp Stick
TSC0290	290°C / 554°F Temp Stick
TSC0300	300°C / 572°F Temp Stick
TSC0320	320°C / 608°F Temp Stick
TSC0350	350°C / 662°F Temp Stick
TSC0500	500°C / 932°F Temp Stick
TSC0677	677°C / 1250°F Temp Stick



**Welders Corner Clamp**

Secures metal work pieces for welding.  
Pivoting head and central screw column allows versatile clamping.  
100mm max jaw distance.



Holds by inside corner.

Art #	Product
ET0039	Corner Clamp

**Magnetic Support Bracket**

Hold the work pieces at a variety of angles while you weld. Strong magnet and rugged, durable body. Ideal for all welding processes to free both hands.

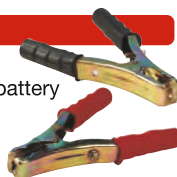


Art #	Product
ET001002	Magnetic Support

**Battery Clips**

Use as work return clamps in low-amp jobs (<120A) or with battery chargers.

Black=Neg, Red=Pos.



Art #	Product
EWBC120B	120A Black Battery Clip (-)
EWBC120R	120A Red Battery Clip (+)

**Cordless Drill**

18V cordless rechargeable drill with hammer action. Features include variable speed forward and reverse, 10mm keyless chuck, torque control and electric brake. Supplied in a durable plastic carry case complete with a 12 piece accessory kit, 1.3Ah battery, 1 hr quick charger and AC adaptor.



Art #	Product
HLDT071	18v Cordless Drill Driver Pkg

**Adjust-A-Magnet Square**

Unique magnet with ON/OFF switch design. Easy, safe setup. Ideal for round & square tube, angle and flat bar.  
Holds pieces at 45° or 90°. Available with a 25kg pull force and 34lb pull force



Art #	Product
EVSA47	Adjust-A-Magnet square 34kg
EVSA47A	Adjust-A-Magnet square 25kg

**Magnetic Earth Clamp**

350A and 800A circular earth clamps with a strong magnet and a central rotating lug point for reliable connection to the earthing cable. Ideal for using in areas that are difficult to clamp to and where use of a standard croc clamp is not suitable.



Art #	Product
ET004	350A Mag Clamp
ET004A	800A Mag Clamp

**Inspection Mirror And Led Torch**

A versatile inspection mirror with bright LED illumination adjacent to the mirror. The mirror head is extendable, with a flexible neck, making it ideal for inspection of pipe root beads or in restricted access areas. Handle/Arm length 177-558mm



Art #	Product
ETIMLED	LED Torch & Inspection Mirror

**Toolbox Case**

A durable red-painted metal toolbox case measuring 66x27x25cm and weighing 3kgs. Can be sealed shut with metal latches and has a pull-out tool tray. Ideal for tool and accessory kits, and for general tool storage.

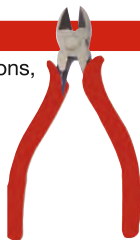


Art #	Product
OP1000W	Weldability Sif Toolbox



## MIG Side Cutters

Suitable for a variety of applications, side cutters are essential for any welders toolbox. With rubber handle covers and strong jaws, the side cutters can trim filler wire and clear contact tip jams. They are drop-forged for greater reliability.



Art #	Product
ET000	MIG Side Cutters

## Hose & Cable Cutters

This versatile cutting tool has many uses in all welding and cutting processes. These cutters are ideal for cutting and trimming welding cable and gas hose. They feature rubber covered handles and half moon jaws.



Art #	Product
DZ0021	Hose & Cable Cutters

## Adjustable Spanners

A satin finished, chrome plated steel adjustable spanner.

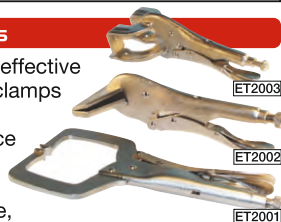
Available in 4 lengths.



Art #	Product
ET1006	6in Adjustable Spanner
ET1008	8in Adjustable Spanner
ET1010	10in Adjustable Spanner
ET1012	12in Adjustable Spanner

## Vice Grip Clamps

A simple and cost-effective range of vice grip clamps used to hold metal work pieces in place while welding. 3 designs are available; Flat-Type, C-Type and 2-Prong-Type.



Art #	Product
ET2001	C11 C Clamp
ET2002	SM10 Flat Clamp
ET2003	W10 2 Prong Clamp

## Lock Grip Pliers

Used frequently as a temporary clamping tool to hold work pieces in place during welding, cutting, burning or heating. The strong jaws can be secured in position by the screw and lever locking combination.



Art #	Product
EW0200	Lock Grip Pliers

## Hose Pliers

When fitting hose nuts, tails and hose check valves to lengths of oxy/fuel hose, hose clips should be used to secure them in place.

The flat head design of this tool makes it ideal for use in crimping the hose clips over the hose.



Art #	Product
DZ0020	Hose Clip Pliers

## Joggler Punch

A bending and punching tool which produces a 10mm lip on 18-20 gauge mild steel or aluminium sheet. All steel construction with non-slip grips and swivel head. Push and turn head to produce 5mm holes. 290mm approx overall length and ideal for spot/mig welding car panels.



Art #	Product
ET161202	Joggler and 5mm Punch Tool

## G-Clamps

G-Clamps are a quick & easy method for clamping the work in place for welding. Drop-forged and available in a range of 6 sizes.



Art #	Product
ET0053	G-Clamp 3" Jaw
ET0054	G-Clamp 4" Jaw
ET006	G-Clamp 6" Jaw
ET007	G-Clamp 8" Jaw
ET008	G-Clamp 10" Jaw
ET00812	G-Clamp 12" Jaw

### Pocket Fillet Gauge

A durable 2mm thick aluminium pocket fillet gauge set. Allows simple measurements of fillet leg length and throat thickness. All increments are clearly engraved. Secured together with a stainless steel chain. An ideal everyday tool for the Responsible Welding Co-ordinator.



Art #	Product
EZ0029R	Pocket Fillet Gauge

### Stainless Steel Cleaning Towels

Stainless Steel Cleaner, towels clean, polish, brighten and protect all in one step. This powerful formula prevents water marks and corrosion and preserves the brightness of stainless steel. They are ideal for finished fabricated articles, as well as on surfaces. Removes spot marks, film, fingerprints, water marks and grease. Can be used on stainless steel, aluminium, chrome, copper and brass.



Art #	Product
MD91930	Stainless Steel Cleaner - 30 Towels

### Rollerball Paint Marker

This oil-based permanent paint marker features a heavy-duty rollerball tip and grip 'n' squeeze flow control. Capable of with-standing oil, grease and friction without the loss of legibility or brightness. This marker is excellent for colour coding parts and assembly. Users can confidently mark on both non-porous and steel surfaces with ease. Sold in Carton of 2.



Art #	Product
MS42001	Rollerball Marker - White
MS42002	Rollerball Marker - Yellow
MS42003	Rollerball Marker - Black
MS42004	Rollerball Marker - Red

### SCRUBS® Hand Cleaner Towels

SCRUBS® is an industry leading, patented, citrus-based formula combined with a tough, textured blue towel to loosen, dissolve and absorb dirt and grease leaving your hands truly clean. The effectiveness of pumice soap in a one-step, premoistened towel allows you to use SCRUBS® Hand Cleaner Towels anywhere, anytime! Dual-textured towels lock in dirt & will not transfer soils back onto hands. No rinsing necessary. Removes dirt, tar, oils, grease, paints, adhesives, epoxies, chalks, inks, dyes and lubricants. Available in buckets of 72 towels or tubs of 30 towels.



Art #	Product
MD42230	SCRUBS in-a-Tub® 30 Towels
MD42272	SCRUBS in-a-Bucket® 72 Towels

### Paint Sticks Type-B



Durable, long lasting, lead-free paint in crayon form. For use on a wide variety of materials inc wood, plastic, concrete, rubber, glass, cardboard and paper. Marks on smooth, rough, rusty or dirty surfaces and also through oil & water.

Art #	Product
MBSO	Type-B Paint Stick - Orange
MBSW	Type-B Paint Stick - White
MBSY	Type-B Paint Stick - Yellow

### "Ask Abe"

Our range of industrial marking products can be used with our measuring and lay-out tools, such as the Contour® pipe marking range (see pipe section), or your favourite weld gauge. A popular temporary marker, commonly used in welding applications, is Soapstone (or "engineers chalk"); this can be found in our stick welding section.



## Mild Steel Wire Brushes

For use with mild steel for weld cleaning and preparation.  
Our range of standard quality mild steel bristled brushes have shaped wooden handles and are available in a variety of designs and row sizes.



Art #	Product
EW0100	2 Row Mild Steel Brush
EW0103	3 Row Mild Steel Brush
EW0103C	3 Row M/S Converging Brush
EW0104	4 Row Mild Steel Brush
EW0104SC	4 Row Brush With Scraper
EW0105	5 Row Mild Steel Brush

## High-Quality Mild Steel Brushes

A range of higher-quality EU-supplied mild steel wire brushes, with thicker/stronger bristles for heavier-duty applications.  
Barcoded and offered in a variety of designs and row sizes.



Art #	Product
EW0100HQ	2 Row Brush M/S HQ
EW0103HQ	3 Row Brush M/S HQ
EW0103CHQ	3 Row Converging Brush M/S HQ
EW0104HQ	4 Row Brush M/S HQ

## Stainless Steel Wire Brushes

For stainless, copper and aluminium applications, ferrous brushes (mild steel) are not recommended.  
Our range of standard quality stainless steel-bristled brushes have shaped wooden handles and are available in a variety of designs and row sizes.



Art #	Product
EW0102SS	2 Row Stainless Steel Brush
EW0103SS	3 Row Stainless Steel Brush
EW0103SSHD	3 Row S/S Heavy Duty Brush
EW0103CSS	3 Row S/S Converging Brush
EW0104SSHD	4 Row Stainless Steel Brush

## High-Quality Stainless Steel Brushes

A range of higher-quality EU-supplied stainless steel wire brushes, with thicker/stronger bristles for heavier-duty applications. Barcoded and offered in a variety of designs and row sizes.



Art #	Product
EW0102SSHQ	2 Row S/S H/D Brush HQ
EW0103SSHQ	3 Row Wire Brush S/S HQ
EW0103SSHDHQ	3 Row S/S H/D Brush HQ
EW0104SSHDHQ	4 Row S/S H/D Brush HQ

## Taper Gauge

A simple tapering stainless gauge for quickly measuring gap size.  
Measurement range of 0-15mm.  
Metric range on one side, imperial on the reverse.

Supplied with a pouch.



Art #	Product
ET003315	1-15mm Taper Bore Gauge

## HiLo Gauge

A popular design of cost-effective, easy-to-use welders gauge, for measuring root-weld space and internal misalignment.  
Frequently used in pipe-welding applications.  
Supplied with a pouch.



Art #	Product
ET0032	HiLo Gauge

## Fillet Gauge Set c/w Pouch

Stainless steel fillet gauge set for measuring a range of fillet weld dimensions in imperial or metric units.  
Supplied with a pouch



Art #	Product
ET0030	Fillet Gauge Set
ET0030METRIC	Metric Unit Fillet Gauge Set

## Cam Type Welding Gauge

A stainless steel gauge for measuring weld preparations and completed butt & fillet welds, angle of preparation, excess weld metal, fillet leg length & throat size.

Supplied with a pouch.



Art #	Product
ET0031	Cam Type Gauge

## Squeeze Marker

The Fabricators choice! Heavy duty metal tip which produces a 1.4mm width stroke line. Works great on wet, slippery surfaces and can easily be removed without harming the surface. Excellent for colour coding. Quick drying formula marks most surfaces. Sold in Carton of 12.



Art #	Product
MS01295	Squeeze Marker - White
MS01324	Squeeze Marker - Yellow
MS01323	Squeeze Marker - Black
MS01326	Squeeze Marker - Red

## Hi-Temp Marker

Specifically formulated for marking on surfaces that are exposed to extreme high temperature environments. Marks should be made at room temperature and once dried can withstand temperatures up to 1093 degrees celcius. Line width 1.4mm. Sold in Carton of 12.



Art #	Product
MS04505	Hi-Temp Marker - White
MS04505Y	Hi-Temp Marker - Yellow
MS04505B	Hi-Temp Marker - Black

## Jumbo Marker

Designed to work in tough environments. This industrial grade, quick drying marker is excellent for use in a wide range of indoor and outdoor applications. Effective on wet, slippery surfaces. The durable wide nib, featuring pump action technology, delivers a long lasting paint supply. Features a reversible nib. Sold in Carton of 4.



Art #	Product
MS07201	Jumbo Marker - White
MS07210	Jumbo Marker - Yellow
MS07213	Jumbo Marker - Black
MS07214	Jumbo Marker - Red

## Removable Jumbo Marker

This 100% water-based, non-toxic, virtually odourless marker is perfect for indoor and outdoor applications. Easily removed with just a damp cloth, and leaves no ghosting on non-porous surfaces. Features pump action technology and a reversible nib for extended product life. Sold in Carton of 4.



Art #	Product
MS07200	Removable Jumbo Marker

## Paint Marker

Designed to work in very tough environments. This industrial grade, quick-drying, 2.3mm stroke width marker is effective on wet, slippery surfaces. Features pump action technology, non-slip, ergonomic, "Pro-grip" and reversible nib for extended product life. Sold in Carton of 12.



Art #	Product
MS04000	Paint Marker - White
MS04001	Paint Marker - Yellow
MS04002	Paint Marker - Black
MS04003	Paint Marker - Red

## Galv Steel Marker

This water-based marker is specifically designed for use by steel galvanisers. Featuring pump-action technology, this marker produces permanent marks during fabrication which come off completely in tank. Effective on wet, oily surfaces. Ergonomic, non-slip, rubber "Pro Grip" design and reversible nib for a much extended product life. Available in 4 different colours. Line width 4.5mm. Sold in Carton of 12.



Art #	Product
MS04042	Galv Steel Marker - White
MS04042Y	Galv Steel Marker - Yellow
MS04042B	Galv Steel Marker - Black
MS04042R	Galv Steel Marker - Red

## Oxygen Analyser / Purge Meter

Purge monitor GM2 is a small practical machine which measures the oxygen value in a purged chamber or vessel in ppm. With a minimum measurement of 100ppm.



Art #	Product
PVEZGM2	Purge Meter GM2 100 ppm

## Adjustable Pipe Roller

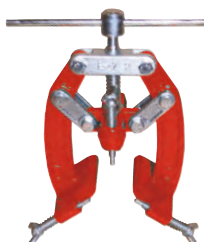
This stable, durable, heavy duty pipe roller has an adjustable working height of 740mm - 1065mm and can cater for pipes up to 1220mm diameter. Will accommodate loads up to 900kg for quick, safe and accurate rotation.



Art #	Product
PPRLADJ	Adjustable Pipe Roller
PPRLADJ55	Rubber Wheels Kit

## EQZ Fit-Up Pipe Clamps

EQZ Fit-Up pipe welding clamps, are quick and easy to use. Combining accuracy with safety. A quality product that is economically priced and available in 4 sizes. All EQZ clamps are instant centring and supplied with stainless steel shoes and thumb shoes that can be fitted quickly to the clamps. This makes the contact points of the clamp stainless, thus eliminating chance of contamination of the pipe. Suitable for both ferrous and non-ferrous materials.



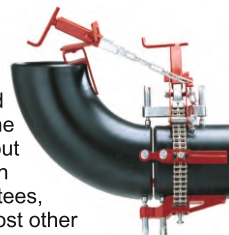
### Clamping Range:

PPEZQ02 - 22.5mm to 63mm  
PPEZQ04 - 63.5mm to 114mm  
PPEZQ08 - 114mm to 200mm  
PPEZQ12 - 200mm to 300mm

Art #	Product
PPEZQ02	EQZ Fit-Up Clamp 7/8" - 2 1/2"
PPEZQ04	EQZ Fit-Up Clamp 2 1/2" - 4 1/2"
PPEZQ08	EQZ Fit-Up Clamp 4 1/2" - 8"
PPEZQ12	EQZ Fit-Up Clamp 8" - 12"

## Pipe Chain Clamps

Lightweight design and construction for ease of use. One clamp can fit a wide range of sizes and entire circumference of the pipe can be welded without removing the clamp. Each clamp can fit-up elbows, tees, flanges, end caps and most other pipe fittings. Stainless models also available.



Art #	Product
PPPW0620	6-20" pipe dia. (153mm - 508mm)
PPPW0620SS	6-20" pipe dia. Stainless Steel
PPPW1036	10-36" pipe dia. (254mm - 914mm)
PPPW1036SS	10-36" pipe dia. Stainless Steel

## Contour Centering Heads

Centering Heads aid in the setting of centerlines, establishing angles and marks for butt-ins, locating points inside pipes and tanks, laying out keyways and measuring declivity.



Standard 12mm diameter pipe and above. Jumbo 25mm diameter pipe and above. Both feature a Y-Type head adjustable dial bubble protractor.

Art #	Product
EJ07210005	Centering Head - Standard
EJ07210006	Centering Head - Jumbo
EJ07220000	Dial & Protractor Level Combi

## Contour Radius Markers

Folding type design-three smaller models will fit conveniently into a shirt pocket. Sturdy friction joints to maintain rigidity and accuracy and arms made from lightweight, rustproof aluminum for long wear.



Art #	Product
EJ07210010	Radius Marker Mini (max 40cm dia)
EJ07210011	Radius Marker Small (max 100cm dia)
EJ07210012	Radius Marker STD (max 120cm dia)
EJ07210013	Radius Marker Jumbo (max 200cm dia)



**Fixed Leg Pipe Industrial Stands**

The fixed leg pipe stand has been designed to give you the highest quality pipe stand in today's market using a robust steel section construction.

The versatile, folding pipe stands are designed with folding legs for easy storage and transportation.

Both the models are adjustable in height from 27½" (70cm) to 48" (122cm) and available with a choice of four interchangeable head styles: Steel wheel head, Nylon wheel head and Ball transfer head.

Full 1 tonne load capacity.

The safety features which are incorporated prevent the sudden collapse of the pipe and protect against hand injuries.



Art#	Product
PP001B	Fixed Leg Pipe Stand Complete with V Head

**Folding Leg Industrial Pipe Stands**

The versatile folding pipe stands are designed with folding legs for easy storage and transportation. Adjustable in height from 70cm to 122cm. Full 1 tonne load capacity.

Standard V-Head included, which will accommodate pipes with up to 12" (30cm) maximum diameter.



Art#	Product
PP002B	Fixed Leg Pipe Stand Complete with V Head

**Optional Heads**

**Steel Wheel**  
450kg Capacity



**Stainless**  
Slippers



**Nylon Wheels**  
450kg Capacity



**Ball Transfer**  
450kg Capacity

A range of optional heads to replace the standard V on our fixed and folding stands. Supplied as sets.

Art #	Product complete with V head
PP010B	Steel Wheel Head Set
PP011B	Steel Wheel Head Set
PP012B	Nylon Wheel Head Set
PP013B	Ball Transfer Head Set

**Pipe Wrap-A-Rounds**

A popular tool for marking straight lines around pipe, made from flexible gasket material with good durability and heat resistance.



Available in regular (B) and hi-temp (GG) versions to suit a variety of pipe diameters.

Art#	Product
EJ07200004	152B Wrap-A-Round 1"-3" Dia
EJ07200007	164B Wrap-A-Round 3'-6" Dia
EJ07200010	176B Wrap-A-Round 3"-10" Dia
EJ07200013	177B Wrap-A-Round 4"-12" Dia
EJ07200016	179B Wrap-A-Round 6"-16" Dia
EJ07200030	176GG Wrap-A-Round 3"-10" Dia
EJ07200032	179GG Wrap-A-Round 6"-16" Dia

## Cutting & Grinding Discs

Medium-hardness abrasive discs for use with iron and mild steels. Flat or depressed centre versions available in a range of diameters.



Art #	Product
IM40FCM	4" (100mm) Flat Cutting Disc
IM45FCM	4½" (115mm) Flat Cutting Disc
IM70FCM	7" (180mm) Flat Cutting Disc
IM90FCM	9" (230mm) Flat Cutting Disc
IM120FCM/22	12" (300mm) Flat Cutting Disc 22mm Bore
IM140FC	14" (355mm) Flat Cutting Disc 25mm Bore
IM40DCC	4" (100mm) DCP Cutting Disc
IM45DCCM	4½" (115mm) DPC Cutting Disc
IM90DCCM	9" (230mm) DPC Cutting Disc
IM40DCGM	4" (100mm) DPC Grinding Disc
IM45DCGM	4½" (115mm) DPC Grinding Disc
IM90DCGM	9" (230mm) DPC Grinding Disc

IM451FCM 4½" Flat Cutting Disc 1mm Thick

## Sanding Discs - Ali Oxide

Electro-coated, fibre-back abrasive discs for the finishing & polishing of metals.



Art #	Product
IH40SD24	4"x16mm Bore 24 Grit
IH40SD36	4"x16mm Bore 36 Grit
IH40SD60	4"x16mm Bore 60 Grit
IH40SD80	4"x16mm Bore 80 Grit
IH45SD24	4½"x22mm Bore 24 Grit
IH45SD36	4½"x22mm Bore 36 Grit
IH45SD60	4½"x22mm Bore 60 Grit
IH45SD80	4½"x22mm Bore 80 Grit
IH45SD100	4½"x22mm Bore 100 Grit
IH50SD36	5"x22mm Bore 36 Grit
IH50SD60	5"x22mm Bore 60 Grit
IH50SD80	5"x22mm Bore 80 Grit
IH70SD24	7"x22mm Bore 24 Grit
IH70SD36	7"x22mm Bore 36 Grit
IH70SD60	7"x22mm Bore 60 Grit
IH70SD80	7"x22mm Bore 80 Grit
IH90SD36	9"x22mm Bore 36 Grit
IH90SD60	9"x22mm Bore 60 Grit

## Flap Discs



Our 2 types of flap discs provide consistent finishing performance. Reduced vibration over depressed-centre grinding discs. Zirconium is suited to most ferrous metals, for weld seam removal, surface blending, edge grinding and weld preparation. Ceramic is ideal for weld blending and surface cleaning on harder steels and stainless; also gives longer life on mild steel and cast iron.

Art #	Product
ZR36100GKW	100x22mm 36 Grit Zirc
ZR40100GKW	100x22mm 40 Grit Zirc
ZR60100GKW	100x22mm 60 Grit Zirc
ZR36115GKW	115x22mm 36 Grit Zirc
ZR40115GKW	115x22mm 40 Grit Zirc
ZR60115GKW	115x22mm 60 Grit Zirc
ZR80115GKW	115x22mm 80 Grit Zirc
ZR40125GKW	125x22mm 40 Grit Zirc
ZR60125GKW	125x22mm 60 Grit Zirc
ZR80125GKW	125x22mm 80 Grit Zirc
ZR36180GKW	180x22mm 36 Grit Zirc
ZR40180GKW	180x22mm 40 Grit Zirc
ZR60180GKW	180x22mm 60 Grit Zirc
ZR80180GKW	180x22mm 80 Grit Zirc

SC60100GKW	100x22mm 60 Grit Ceramic
SC80100GKW	100x22mm 80 Grit Ceramic
SC60115GKW	115x22mm 60 Grit Ceramic
SC80115GKW	115x22mm 80 Grit Ceramic
SC120115GKW	115x22mm 120 Grit Ceramic
SC60125GKW	125x22mm 60 Grit Ceramic
SC80125GKW	125x22mm 80 Grit Ceramic
SC80180GKW	180x22mm 80 Grit Ceramic

## Sanding Discs - Zirconium



High Performance fibre-back abrasive discs for heavy deburring and finishing of many common metals. Do not contain metal iron or iron compounds.

Art #	Product
IJ40ZD36	4"x16mm Bore 36 Grit
IJ40ZD60	4"x16mm Bore 60 Grit
IJ40ZD80	4"x16mm Bore 80 Grit
IJ40ZD100	4"x16mm Bore 100 Grit
IJ45ZD36	4½"x22mm Bore 36 Grit
IJ45ZD60	4½"x22mm Bore 60 Grit
IJ45ZD80	4½"x22mm Bore 80 Grit
IJ45ZD100	4½"x22mm Bore 100 Grit
IJ70ZD36	7"x22mm Bore 36 Grit
IJ70ZD60	7"x22mm Bore 60 Grit
IJ70ZD80	7"x22mm Bore 80 Grit
IJ70ZD100	7"x22mm Bore 100 Grit

### Caddy Style Trolley

Our most portable and versatile trolley, it features an extendable/retractable handle which can be raised to drag and lowered for lifting or transporting.

Accommodates a welding torch kit box and storage of consumable rods.

Ideal for mobile use in trucks and outside.



Art #	Product
DZ10011ALT	Caddy Style Trolley

### HD Oxy/Propane Trolley

This heavy duty trolley has a hard-wearing epoxy coated finish and chains to hold the cylinders upright.

Large rugged wheels mean the trolley can be wheeled over the roughest ground. Takes one Oxygen and one Propane cylinder.

Dimensions: 117cm (H) x 75cm (W) x 50cm (D)



Art #	Product
DZ151549ALT	HD Oxy/Prop Cylinder Trolley

### Oxy/Fuel Cylinder Trolleys

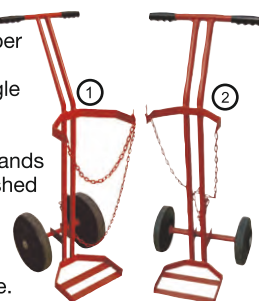
Twin cylinder trolleys with solid tyre wheels, of a robust, fully-welded construction. Versions available to support Oxygen/Acetylene (base measures 580mm x 260mm) or Oxygen/Propane (base measures 700mm x 310mm). Includes Chain and rubber grips.



Art #	Product
DZ10001	Oxy/Acetylene Trolley
DZ10002	Oxy/Propane Trolley
DZ10001PN	Oxy/Acet Twin Pneumatic
DZ10002PN	Oxy/Prop Twin Pneumatic

### Universal Cylinder Trolley

A heavy-duty trolley with 30cm solid rubber wheels, designed to accommodate a single industrial cylinder, restrained via the adjustable chain. Stands 120cm high and finished with a hard-wearing epoxy coating. Smaller (98cm) HD version also available.



Art #	Product
DZ153384ALT	Universal Cylinder Trolley ①
DZ003619ALT	HD Single Cylinder Trolley ②

### TR4 Oxy/Acet Cylinder Trolley

This heavy duty trolley has a hard-wearing epoxy coated finish and chains to hold the cylinders upright. Large rugged wheels mean the trolley can be wheeled over the roughest ground. This trolley takes one Oxygen cylinder and one Acetylene cylinder.



Dimensions:  
(H) 1305 x (W) 810 x (D) 550mm

Art #	Product
DZ004620A	TR4 Oxy/Acet Cylinder Trolley

### Portable Cylinder Trolleys

Solid wheeled trolley for use with small industrial cylinders. Two versions are available; a "small" version with a 390mm x 150mm base and a 900mm height to suit the FlamePak 20 (X/M) and a 'large' version with a 460mm x 200mm base and a 1050mm height - to suit FlamePak 50 (Y/J).

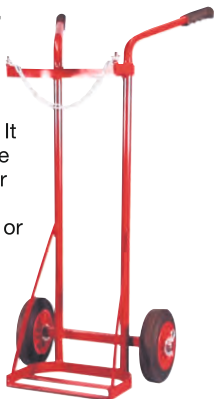


Art #	Product
DZ10004	Portable Trolley Small
DZ10005	Portable Trolley Large
DZ10014	Oxy Propane Bottle Trolley

## Single Cylinder Trolley

A cylinder trolley for a single industrial cylinder, incorporating 200mm diameter solid tyre wheels. Robust, fully-welded steel construction.

Red-painted. The base measures 285mm x 225mm. Height 1030mm. It will accommodate a single industrial size gas cylinder containing either Oxygen, Acetylene, Argon, Helium or Nitrogen, for safe storage and moving. A version suitable for Propane cylinders is also available. Includes galvanised bottle chain and rubber handle grips.



Product	
Art #	
DZ10003	Single Cylinder Trolley
DZ10003P	Propane Single Trolley

## Sack Barrow

Transports heavy objects to help prevent damage to the back, knees, etc. This trolley has a strong fully-welded tubular steel construction with solid tyre wheels. It can be loaded directly via the flat sled, or rested on its angled handles for easy horizontal loading.

Not suitable for use with gas cylinders.



Product	
Art #	
DZ10010	Sack Barrow

## Cylinder Rack

Designed to sit over your cylinder and has hooks for holding your torch, hose, headshield and other equipment.



Product	
Art #	
DZ10006	Cylinder Rack

## MIDI Trolley FP50

A 10kg Lightweight trolley which has chains to hold the cylinders upright. Large solid rubber wheels that mean the trolley can be wheeled over rough ground. This trolley takes one Oxygen cylinder and one Acetylene cylinder.

Dimensions:  
(H) 1070 x (W) 550 x (D) 340mm



Product	
Art #	
DZ003622	MIDI Trolley FP50

## MIG Inverter Trolley



A black-painted, robust and solidly-constructed trolley, designed to accommodate portable MIG welders and inverter power sources. Includes platform for gas cylinder and water cooler.

Self-assembly required.

Product	
Art #	
DZ10012	MIG / Inverter Trolley

## Portable Gas Kit Stand

A 70cm high cylinder stand, specifically designed for portable gas packages using smaller industrial cylinder sizes.

Includes shaped bar and thumbscrew cylinder restraint.



Product	
Art #	
DZ193001	Portable Gas Kit Stand



# DRYING OVENS

# sifDRY®

Professional equipment for transporting, dispensing and storing your stick welding rods in warm, dry conditions prior to welding.

Drying ovens help reduce your amount of electrode wastage, as well as ensure optimum performance to electrodes that have been moisture compromised. A wise tool to have available, especially when moisture pick-up in your manual arc electrodes is a concern.

## Sif Rod Cannister

A durable plastic airtight cannister providing great storage and safe transportation of your welding electrodes. Standard 14in (for 350mm electrodes).



Product	
Art #	
RG100SIF	14in Sif Rod Cannister

## Portable Drying Oven

Lightweight, durable and completely portable, easy to load, easy to carry, ready to provide low cost control of welding quality in the workshop or on site. This portable drying oven can help reduce operating costs by providing operators with fast access to electrodes at the point of application.

Features a 400watt heater which is thermostatically controlled to warm the rods between 60°C and 300°C. Versions are available which use a 230v or 110v supply. Weighs only 8kg with a rod lifter which can hold 2 packs of 5kg electrodes.



Product	
Art #	
ZAB200110	110v Portable Drying Oven
ZAB200230	230v Portable Drying Oven

## Electrode Quiver

This model has a 200watt (approx) heater which is thermostatically controlled to warm the rods between 80°C and 130°C and improve their welding performance. An indicator light will show when heating is in operation.

Capable of comfortably holding a full pack of 5kg electrodes. The carry handle will serve as a stand for the quiver to rest on.

Versions are available which use a 230v or 110v supply; the quiver is easy to load, easy to carry and is ideal for on-site use. Weighs only 5kg with a height of 50cm and will take 350mm electrodes.



Product	
Art #	
ZAB300110	110v Quiver
ZAB300230	230v Quiver

## Stationary Drying Oven

Our most industrial drying oven for the storage and heating of welding rods. The stationary drying oven has the capacity to hold up to 20 packs of 5kg electrodes.

The heavy-duty construction includes a durable powder-coated steel exterior, radial formed perforated shelving aiding heat convection, reinforced door, latches and handle with pockets at the base of the oven for easy transport by forklift.

Operating power of 4500 Watts. Max temperature of 400°C.

Uses a 415v supply.



Product	
Art #	
ZAB000415	415v Stationary Drying Oven



## Leak Detection Spray

Non-toxic milky spray in a 400ml can. Non oil-based solution, to prevent combustion hazard when used on pressurised Oxy/Fuel equipment setup. Can be used on hoses, regulator nuts, flashback arrestors, shank valves, headnuts and other fittings to help detect leaks. Solution will bubble on contact with leaking gas. CFC free, non-toxic and non-flammable.



Art #	Product
EG3001	Leak-Tek Spray

## Water-Based Anti-Spatter

A water-based, silicone-free, non-toxic, non-flammable anti-spatter solution that does not contain harmful solvents which can smoke and produce harmful fumes. Does not affect weld porosity. Use to prolong tip & shroud life and to prevent adhesion of weld spatter to the area surrounding the weld zone. It is available in a full range of container types and sizes from a 400ml spray to a 25ltr bulk drum.



Art #	Product
EG1001W	400ml Spray
EG1001100W	1ltr Trigger Spray
EG1001100BW	1ltr Empty Bottle
EG10015000	5ltr Bulk Bottle
EG1001BLK	25ltr Bulk Drum

## SIF Tip-Dip Gel

An anti-spatter paste to protect MIG welding torches, jigs and fixtures from spatter build-up during welding. Can increase life of tips and shrouds and it is odourless, non-toxic, non flammable and does not contain silicones. Apply by dipping warm torch nozzle in to tin. Supplied in 225 or 500g tins.



Art #	Product
FXTIPDIP22	SIF Tip-Dip - 225g
FXTIPDIP50	SIF Tip-Dip - 500g

## Flaw & Crack Detector

3 part system to highlight cracks and flaws in a finished weld. Use in sequence and leave for 10 to 20 minutes. Red dye shows cracks after developer is sprayed. Available separately. Meets ASME IX requirements.



Product	
Art #	
EG2001	Cleaner 400ml
EG2002	Penetrant 400ml
EG2003	Developer 370ml

## Solvent-Based Anti-Spatter

Low odour formula anti-spatter spray which prolongs tip and shroud life and prevents the adhesion of the weld spatter to the area surrounding the weld zone. Supplied in a 450g aerosol can.



Art #	Product	Price Per Unit Exc. VAT
EG261005	Solvent-Based Anti-Spatter 450g	

## CeraMIGuard Dry-Film Spray

INNOVATION

A protective ceramic spray specifically designed to prolong tip and shroud life in industrial MIG fabrication. It can also be applied to jigs, fixtures & cables to protect them from spatter adhesion.



Art #	Product
EG5001	CeraMIGuard Dry-Film Spray

## Cold-Galv Spray

Our cold-galv spray is 95% zinc and provides a bright cold galvanizing coating which replaces the zinc coating removed during the weld process. Sprays or brushes on cold. Helps to prevent rust and corrosion. Air dries quickly, with being set to touch in just one hour. Supplied in 400ml spray cans.



Art #	Product
EWAP50101	Cold-Galv Spray (400ml)

### SIF Pickling Paste

A strong, colourless pickling paste for use on stainless steels to remove weld oxide, and burn marks and improve the final appearance of the welded stainless metal.

Supplied in 2kg jars and shipped in cartons of 6 jars.

Brush included.

A neutraliser is also available to remove the paste from unwanted areas.


**sif**

**A HazChem transport cost may be applied.**

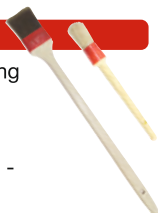
Art #	Product
FXPICK20	SIF Pickling Paste Jar 2kg
FXPICKNP	SIF Neutralising Paste 2kg

### Pickling Paste Brushes

Hand brushes for applying pickling paste.

FXBRUSH: overall length 45cm - bristles 45mm x 45mm x 10mm

EFPBRUSH: overall length 21cm - bristles 40mm x 21mm dia.



Art #	Product
FXBRUSH	Flat Brush
EFPBRUSH	Round Brush

### Sif Purging FLux

**INNOVATION**

A flux used in TIG applications to shield the rear of a weld joint from oxygen contamination, dissipate heat and oxides during welding and prevent re-oxidation.

Formulated to suit stainless steel and high nickel super alloys. To apply, mix flux with methanol & brush over rear of joint.

Sif Purging flux is inert, non-flammable and non-explosive. Ideal for pipe and tube welding applications. Supplied in 500g jar.



Art #	Product
FO210050	Sif Purging Flux 500g Jar

### Heat Block Paste

Heat Block is an insulation compound with unique heat-absorbing properties which insulates against heat transfer, preventing distortion to light gauge metals and protecting rubber and plastic components and painted or finished surfaces during soldering, brazing or welding. Non-toxic paste. Form on or around the surface of metal.

It is easily removed by wiping with wet rags or running water.



Art #	Product
EWAP77701	Heat Block 12oz (350ml)

### Gasfluxer - Model 69-D

The fluxer is specially formulated to be absorbed into the flame to enhance the quality of the weld. For use in the welding or brazing process of brass or mild steel with a silicon bronze rod.

Gas fluxers can be connected to the acetylene hose.

Additional liquid available. Minimum order of 4 x 3ltr containers.

Sifbronze No.101 is designed for capillary brazing with gas flux.



Art #	Product
FXGF69D	Gasfluxer Model 69-D
FXGF3L	Gasfluxer Liquid 3ltr (CTN 4x3L)

RO101525	Sifbronze No 101 1.5mm 2.5kg Special
RO102025	Sifbronze No 101 1.5mm 2.5kg Special
RO102525	Sifbronze No 101 2mm 2.5kg Special

## Sif Aluminium Fluxes

Powder fluxes designed to facilitate the gas brazing and welding of aluminium and its alloys. Use No12 for low-melting-point alloys, No.14 for medium-melting-point alloys (eg 4043) and No36 for higher-melting-point (eg 5356).



Art #	Product
FO120050	Aluminium No12 Flux 500g
FO140050	Aluminium No14 Flux 500g
FO360050	Aluminium No36 Flux 500g

## Sif Silver Solder Flux

A commonly-used powder flux of silver solder applications. Available in 225g and 500g jars. For a range of bare (and pre-fluxed) silver solders, see page 112.



Art #	Product
FO380022	Silver Solder Flux 225g
FO380050	Silver Solder Flux 500g

## Sifbronze Brazing Fluxes

Popular flux for general brazing work. Available in 225g and 500g jars. For a range of compatible filler rods, see page 113.



Art #	Product
FO010022	Sifbronze Flux 225g
FO010050	Sifbronze Flux 500g
FO100050	Sif 101 Brazing Flux 500g

## Sif Tool Tip / Braze Stainless Flux

A powder flux tool tipping or brazing stainless with Sifbronze No1 or No2 filler rods, which are detailed on page 113. Supplied in a 500g jar



Art #	Product
FO020050	Tool Tip/Braze Stainless Flux 500g

## Sif Stainless Flux

A powder flux for fusion welding of stainless steel. Available in a 500g jar. For a range of compatible stainless steel filler rods, see page 110.



Art #	Product
FO200050	Stainless Flux 500g

## Sif ECO Flux

A pre-mixed paste at optimal liquidity free of boric acid and suitable for brazing of mild steel and copper alloys.



This ECO flux complies to EN 1045 - FH10

Art #	Product
FO500035	Sif ECO Flux 350g

## Sif Cast Iron Flux

Sif's revolutionary powder flux for fusion welding of cast iron. Designed to be used with Super Silicon No 9 and Super SG rods, listed on page 114.



Art #	Product
FO090050	Cast Iron Flux 500g

## Sifsilcopper Brazing Flux

A powder flux for brazing and welding of copper alloys. Available in a 500g jar. For a range of copper alloy filler rods, see pages 109 and 114

Art #	Product
FO070050	Sifsilcopper Flux 500g

Sif have been manufacturing its range of fluxes since the 1930s and have always taken a responsible approach and attitude when producing and distributing fluxes and other chemicals. By risk assessment, safe usage advice and appropriate safety labelling, Sif ensure that the range of chemical products supplied are suitable for use on a variety of applications worldwide.



### Ski-Type Goggles



Ski-type goggles are available in shade 5. Panorama goggles are available in shade 3, both are designed for use in Oxy/Fuel gas welding. CE approved to EN166 & EN169

Art #	Product
DS1001	Ski-Type Goggles shade 5
DS10015	Panoramic Goggles shade 3

### 4 1/4" x 2" Flip-Up Goggles

A comfortable and convenient model of goggle with a flip-up lens holder designed for use in oxy/fuel gas welding applications.



Supplied complete with 4 1/4" x 2" clear and shade 5 lenses. Can be used up to shade 13.

Art #	Product
DS1003	Flip Up Goggles
EHW442005G	Shaded Glass 4 1/4" x 2" 5EW
EHW442006G	Shaded Glass 4 1/4" x 2" 6EW

### Resolution Goggles

Resolution are a DIN5 shaded goggle featuring a sporty soft PVC frame and adjustable wide elastic strap with pivoting buckle. Specifically designed to wear with respiratory masks and prescription spectacles and offering optimum comfort whilst protecting the eyes from both liquid splashes and the welding arc. Packed in 6pcs per display box.



Art #	Product
EP293000	Resolution Goggle

### Round Lens Flip-Up Goggles



Our most popular model of shaded goggle, for use in Oxy/Fuel gas welding. Featuring 50mm round lenses in a flip-up style lens holder. Supplied complete with clear and shade 5 lenses. Amigo model also available.

Art #	Product
DS1002	Round Lens Goggles
EF805635	Amigo Flip-up Goggles
DS5005	Plastic Round Lens Sh5 Pk10

### Panther Shade 5 Gas Welding Specs

Panther are DIN5 shaded specs featuring a nylon nosepiece and soft PVC temple tips providing optimal comfort. They also include extendable side arms, which swivel and tilt for a perfect fit, and a lanyard. Packed 10pcs per display box.



Art #	Product
EP291000	Panther Gas Welding Spectacles

### Universal Headgear Pad

A soft, washable fabric headgear pad for use in any welding helmet. Holds via velcro strip. Headgear not included.



Art #	Product
EVGPAD5	Universal Headgear Pad Pack of 5



### "Ask Abe"

Weldability safety wear is produced to offer the best balance of quality and price. We only offer products that meet our strict criteria, so that you can be sure you're buying a high level of protection at a low price.



## Flat-Front Handshield



A robust, plastic, hand-held protective welding shield with choice of apertures. Ideal for Stick & MIG welding. Easy to assemble. Replacement lens kits are available.

### Product

#### Art #

ES4434FF	4 1/4" x 3 1/4" Handshield
ES4420FF	4 1/4" x 2" Handshield
ES11090FF	110mm x 90mm Handshield
EFLNSG4310	Replacement Lenses

## Fixed-Front Handshield - Fibreglass



A popular design of hand-held welding shield that has a 4 1/4" x 3 1/4" viewable area. It is ideal for use in Stick & MIG welding. Durable & easy to assemble. Shipped complete with a kit of suitable welding lenses. Replacement lens kits are available.

### Product

#### Art #

ES4434SH	4 1/4" x 3 1/4" Handshield
ES4434SHHD	Heavy Duty Fibreglass Handshield
EFLNSG4310	Replacement Lenses

## Sif Auto-Darkening Welding Helmet



Sif LITE variable shade, auto-darkening welding helmets.

- For MIG, Arc and TIG >50amps.
- Comfortable to wear
- Large viewing area.
- Shades 9 - 13, or fixed shade 10

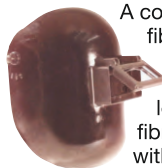


### Product

#### Art #

FXADF925	Sif LITE Plus 9-13 ADF Helmet
FXADF310	Sif ecoLITE 3/10 ADF Helmet
FXADFL310F	ADF Shade 10 Cartridge 110 x 90mm
FXADFL913V	ADF 9-13 Cartridge 110 x 90mm
FXADF925S02	SifLite Outer Lens (5pcs)
FXADF925S01	SifLite Inner Lens (5pcs)

## Flip-Up & Fixed Fibreglass Helmets



A cost-effective, durable fibreglass headshield, with a flip-up lens holder. Takes 4 1/4" x 2" (108mm x 51mm) lenses. Also available, fibreglass headshield, with a fixed- front lens holder. Takes 4 1/4" x 3 1/4" (108mm x 83mm) lenses. Supplied without lenses, which can be purchased separately in a complete kit.

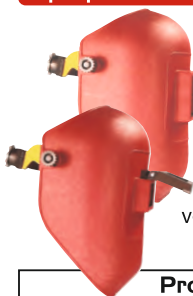


### Product

#### Art #

ES42FF	4 1/4" x 2" Flip Helmet
EFLNSG4210	4 1/4" x 2" Lens Kit
ES43F	4 1/4" x 3 1/4" Helmet
EFLNSG4310	4 1/4" x 3 1/4" Lens Kit

## Flip-Up & Fixed Thermoplastic Helmets



A solid, hard-wearing welding helmet made from durable, lightweight thermoplastic. Complete with a comfortable headgear and a lens kit. 4 1/4" x 2" flip-up lens holder version or 4 1/4" x 3 1/4" fixed lens holder version available. Replacement lens kits available separately.

### Product

#### Art #

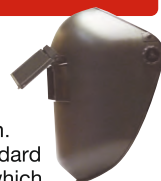
ES4434LW	4 1/4" x 3 1/4" Helmet
EFLNSG4310	Replacement Lenses
ES44X20LF	4 1/4" x 2" Flip Helmet
EFLNSG4210	Replacement Lenses

## Eco Helmets

Great value 4 1/4" x 2" flip-up and 4 1/4" x 3 1/4" fixed lens thermoplastic



helmets. Durable, lightweight design. Supplied as standard without lenses, which are available separately, and for self-assembly.



### Product

#### Art #

EP284005	4 1/4" x 2" Helmet - Unassembled
EP284005ASS	4 1/4" x 2" Helmet - Assembled
EP284010	4 1/4" x 3 1/4" Helmets - Unassembled



**SifLITE Revenge**
**NEW  
PRODUCT**

The SifLITE Revenge is a solar-powered auto-darkening welding helmet with adjustable sensitivity and delay, which helps protect the user's eyes and face from the welding arc, spatter and infrared/ultraviolet radiation. A high quality, affordable ADF welding lens and comfortable helmet solution with variable shade, large viewing area and 12 month warranty. Available in three striking colour options. Red and Gold, Blue and Silver and Yellow and Black .

- Adjustable shade 9-13
- Responsive as low as SA - Ideal for TIG
- 1/25,000 sec fast response time
- Internally adjustable sensitivity and delay


**Product**
**Art #**

FXADF700A	SifLITE Revenge - Style A (red)
FXADF700B	SifLITE Revenge - Style B (blue)
FXADF700C	SifLITE Revenge - Style C (yellow)
FXADF700CART	SifLITE Revenge Cartridge
FXADF700S01	Inner Lens for SifLITE Revenge X5
FXADF700S02	Outer Lens for SifLITE Revenge X5
FXADF700S03	Helmet Shell SifLITE Revenge
FXSTBATT	Replacement Battery
FXADF700S04	Headgear SifLITE Revenge

**Proban Balaclava**

The proban balaclava provides protection to the head, forehead, ears, the side of the face and the neck. Designed to be worn beneath a headshield. Proban is a durable, flame retardant material.


**Proban Balaclava With Cape**

This version of the proban balaclava also has a cape which provides protection to shoulders. Designed to be worn under a headshield. Proban is a durable, flame retardant material.


**Product**
**Art #**

ESF240030	Proban Balaclava
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**Product**
**Art #**

ESF240035	Balaclava C/W Cape
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## Phantom Passive Helmet

A lightweight durable, welding helmet made from strong thermoplastic, with the largest lens size for maximum visibility. Offering comfort and safety for every welder. Large 4 ½ x 5 ¼ viewing area.

Point of sale packaged for retail display



Art #	Product
FXST200	Phantom Passive DIN10/11
ES4254SP	Replacement Inner Lens
ES288520	Replacement Outer Lens

## Phantom Active Eco ADF Helmet

A professional quality auto-darkening welding helmet designed to protect the eyes and face from heat, sparks, spatter and harmful UV + IR under normal welding conditions. Shade adjustable from 9-13. Fully automatic on/off.

- 110 x 90 x 9mm Cartridge
- Auto Darkens in <1/16,000s
- 10A Minimum Current Sensitivity for many MIG, Stick & TIG tasks
- 2x Light-Detection sensors
- Adjustable sensitivity and delay



Art #	Product
FXADF500S	Phantom Active Eco
ES9547SP	Replacement Inner Lens
ES11291SP	Replacement Outer Lens

## Phantom Active Auto-Darkening Helmet

A stylish auto-darkening welding helmet, suitable for all welding and cutting applications down to 10 Amps. Externally adjustable from shade 9-13. Fully automatic on/off. Comfortable and lightweight with 'tribal' decal design.

- 110 x 90 x 9mm Cartridge
- Auto Darkens in <1/16,000s
- 10A Minimum Current Sensitivity for many MIG, Stick & TIG tasks
- 2x Light-Detection sensors
- Adjustable sensitivity and delay



Art #	Product
FXADF600S	Phantom Active 9-13 Variable
ES9547SP	Replacement Inner Lens
ES11291SP	Replacement Outer Lens

## Phantom Impact ADF Helmet

A stylish auto-darkening welding helmet, suitable for all welding, cutting and grinding applications. Fully automatic on/off. Ice and checker plate decal design. Comfortable and lightweight. Complies to EN 175B

- 110 x 90 x 9mm Cartridge
- Auto Darkens in <1/16,000s
- 10A Minimum Current Sensitivity for many MIG, Stick & TIG tasks
- 2x Light-Detection sensors
- Adjustable sensitivity and delay
- Grind Mode



Art #	Product
FXADF725S	Phantom Impact 9-13 Variable
ES9547SP	Replacement Inner Lens
ES11291SP	Replacement Outer Lens

**Phantom XL Large-Lens ADF MKII**

An attractive auto-darkening welding helmet, suitable for all welding and cutting applications down to just 2Amps. Fully automatic on/off. Internal adjustment from shade 9-13. Complies to EN 175B.

- 133 x 114 x 9mm Cartridge
- Auto-Darkens in <1/25,000s
- 2A Minimum Current
- Sensitivity for precision TIG applications.
- 4x Light detection sensors
- Adjustable sensitivity and delay
- Grind Mode


**Phantom eXtreme Large-Lens ADF Helmet**

A modern high specification welding helmet, with high-impact resistant nylon shell compliant to EN 175B, providing protection in grinding applications. Internal adjustment from shade 5-13

- 133 x 114 x 9mm Cartridge
- Auto-Darkens in <1/25,000s
- 2A Minimum current
- Sensitivity for precision TIG applications
- 4x Light Detection sensors
- Adjustable sensitivity and delay
- Grind Mode



Art #	Product
FXADF800S	Phantom XL 9-13 Variable
ES9866SP	Replacement Inner Lens MKI
ES9766SP	Replacement Inner Lens MKII
ES133114SP	Replacement Outer Lens

Art #	Product
FXADF950S	Phantom eXtreme 5-13 Variable
ES9766SP	Replacement Inner Lens
ES133114SP	Replacement Outer Lens

**Phantom Air Powered Air-Purifying Respirator System**
**INNOVATION**

The Weldability Phantom Air PAPR system has been designed to offer heavy protection from externally contaminated air caused by welding, cutting or gouging. It delivers clean air to the users breathing zone.

The supply of filtered air through the hose from the blower unit attached to the belt creates positive pressure inside of the helmet which enables the user to work safely and comfortably and to breath clean air whilst welding.



Designed for use with a wide range of welding, cutting and grinding applications. Other features include:

- 2-speed
- Replacement battery
- Quick to charge
- Grind Mode



Art #	Product
FXPAPR180	Phantom Air PAPR system with Grind mode
FXPAPRADF	Phantom Air Replacement Headshield
ES9445SP	Replacement Inner Lens
ES11090SP	Replacement Outer Lens
FXPAPRCLIP	Hose Clip
FXPAPRS16	Replacement Battery
FXPAPRFILT	Replacement Filter
FXPAPRPFILT	Replacement Pre-Filter (pk 10)
STDUFFLE	Weldability Duffle Bag

## Shaded Glass Welding Lenses

Tempered solid shaded pencil-edged lenses in a range of shades/sizes.

For improved welding protection to EN169



Art #	Product
EHW442005G	4 1/4" x 2" Shade 5ew
EHW442006G	4 1/4" x 2" Shade 6ew
EHW442008G	4 1/4" x 2" Shade 8ew
EHW442009G	4 1/4" x 2" Shade 9ew
EHW442010G	4 1/4" x 2" Shade 10ew
EHW442011G	4 1/4" x 2" Shade 11ew
EHW442012G	4 1/4" x 2" Shade 12ew
EHW442013G	4 1/4" x 2" Shade 13ew

EHW443408G	4 1/4" x 3 1/4" Shade 8ew
EHW443409G	4 1/4" x 3 1/4" Shade 9ew
EHW443410G	4 1/4" x 3 1/4" Shade 10ew
EHW443411G	4 1/4" x 3 1/4" Shade 11ew
EHW443412G	4 1/4" x 3 1/4" Shade 12ew
EHW443413G	4 1/4" x 3 1/4" Shade 13ew

EHW425405G	4 1/2" x 5 1/4" Shade 5ew(HD)
EHW425406G	4 1/2" x 5 1/4" Shade 6ew(HD)
EHW425408G	4 1/2" x 5 1/4" Shade 8ew(HD)
EHW425409G	4 1/2" x 5 1/4" Shade 9ew(HD)
EHW425410G	4 1/2" x 5 1/4" Shade 10ew(HD)
EHW425411G	4 1/2" x 5 1/4" Shade 11ew(HD)
EHW425412G	4 1/2" x 5 1/4" Shade 12ew(HD)
EHW425413G	4 1/2" x 5 1/4" Shade 13ew(HD)

EHW1104508G	110 x 45mm Shade 8ew
EHW1104509G	110 x 45mm Shade 9ew
EHW1104510G	110 x 45mm Shade 10ew
EHW1104511G	110 x 45mm Shade 11ew
EHW1104512G	110 x 45mm Shade 12ew
EHW1104513G	110 x 45mm Shade 13ew

EHW1106008G	110 x 60mm Shade 8ew
EHW1106009G	110 x 60mm Shade 9ew
EHW1106010G	110 x 60mm Shade 10ew
EHW1106011G	110 x 60mm Shade 11ew
EHW1106012G	110 x 60mm Shade 12ew
EHW1106013G	110 x 60mm Shade 13ew

EHW1109005G	110 x 90mm Shade 5ew
EHW1109006G	110 x 90mm Shade 6ew
EHW1109008G	110 x 90mm Shade 8ew
EHW1109009G	110 x 90mm Shade 9ew
EHW1109010G	110 x 90mm Shade 10ew
EHW1109011G	110 x 90mm Shade 11ew
EHW1109012G	110 x 90mm Shade 12ew
EHW1109013G	110 x 90mm Shade 13ew

## Gold Shaded Welding Lenses

Gold plated welding filter lenses providing heat reflective quality in high current applications.

Art #	Product
EHW1109010GOLD	110 x 90mm Shade 10
EHW1109011GOLD	110 x 90mm Shade 11
EHW442010GOLD	4 1/4" x 2" Shade 10
EHW442011GOLD	4 1/4" x 2" Shade 11
EHW443410GOLD	4 1/4" x 3 1/4" Shade 10
EHW443411GOLD	4 1/4" x 3 1/4" Shade 11

## Clear Glass Cover Lenses

Popular sizes. For use in front of a shaded lens.

Art #	Product
ES442000G	4 1/4" x 2" Clear Glass
ES443400G	4 1/4" x 3 1/4" Clear Glass
ES425400G	4 1/2" x 5 1/4" Clear Glass
ES11060G	110 x 60mm Clear Glass
ES11090G	110 x 90mm Clear Glass

## 'Polycarb' Lenses

Meets EN166. Strong, clear safety plates, for use behind filter lenses.

Art #	Product
ES11060SP	110 x 60mm
ES11066SP	110 x 66mm
ES11090SP	110 x 90mm
ES11097SP	110 x 97mm
ES11291SP	112 x 91mm
ES133114SP	133 x 114mm
ES50SP	50mm (2") Round

ES4420SP	4 1/4" x 2" Inner Lens
ES4430SP	4 1/4" x 3 1/4" Inner Lens
ES4254SP	4 1/2" x 5 1/4" Inner/Outer Lens
ES9445SP	94 x 45mm Inner Lens
ES9547SP	95 x 47mm Inner Lens
ES9766SP	97 x 66mm Inner Lens
ES9866SP	98 x 66mm Inner Lens

## 4 1/4" x 2" Magnifying Lens

Aid viewing of the weld zone.

Art #	Product
EHW4420010	1.0 Diopter Mag - 4 1/4" x 2"
EHW4420015	1.5 Diopter Mag - 4 1/4" x 2"
EHW4420020	2.0 Diopter Mag - 4 1/4" x 2"
EHW4420025	2.5 Diopter Mag - 4 1/4" x 2"



### 'CR' Type Lens

To EN166. Protect filters from spatter in 1.4mm and 2mm thicknesses (HD) either individually or in bulk quantities. Each lens is individually enveloped.



Art #	Product
ES288120	4 1/4" x 2"
ES420PBLK	4 1/4" x 2" Box 100
ES420PBLKHD	4 1/4" x 2" (2mm) Box 50
ES288220	4 1/4" x 3 1/4"
ES430PBLK	4 1/4" x 3 1/4" Box 100
ES430PBLKHD	4 1/4" x 3 1/4" (2mm) Box 50
ES288520	4 1/2" x 5 1/4"
ES450PBLK	4 1/2" x 5 1/4" Box 100
ES288320	110 x 60mm
ES1160PBLK	110 x 60mm Box 100
ES288420	110 x 90mm
ES1190PBLK	110 x 90mm Box 100
ES100120PBLK	110 x 120mm Box 100
ES5000P	50mm (2") Round

### Compatible Shaped Lenses

A range of special shaped, clear cover lenses, compatible with popular helmet models including Optrel® and 3M/Hornell®.



Art #	Product
EH426000	Speedglass® Outer Lens (Pk 10)
EWT0491405P1	Optrel 107mm x 51mm (Pk 5)
EWT0491416P10	Optrel 110mm x 85mm (Pk 10)

### Compatible Clear Lenses

A range of replacement compatible clear lenses for use in a wide variety of popular 3rd party manufacturers welding helmets. All brands are © by their respective owners.

Art #	Product
EE700000010	Eyeteck® Type 115mm x 93mm
EE700000011	Eyeteck® Type 45mm x 98mm
EH227000	Speedglass® Type 117mm x 72mm (Pk 10)
EH228000	Speedglass® Type 103mm x 47mm (Pk 5)
EH327000	Speedglass® Type 126mm x 90mm (Pk 10)
EH328000	Speedglass® Type 117mm x 59mm (Pk 10)
EH428000	Speedglass® Type 90mm x 42mm (Pk 5)
EH428010	Speedglass® Type 104mm x 53mm (Pk 5)
EHB770237	Hobart® Type 108mm x 51mm
EHB770240	Hobart® Type 114mm x 85mm
EM10751	Modulo® Type 107mm x 51mm
EM137120	Modulo® Type 137mm x 120mm



### Replacement Lens Kits

Complete welding lens kits include 2 clear CR lenses and a shaded glass filter.



Art #	Product
EFLNSG4210	4 1/4" x 2" Shade 10 Kit
EFLNSG4211	4 1/4" x 2" Shade 11 Kit
EFLNSG4310	4 1/4" x 3 1/4" Shade 10 Kit
EFLNSG4311	4 1/4" x 3 1/4" Shade 11 Kit

### Blue Welding Lenses

Blue shaded welding lenses for use in oxy/acetylene gas-fluxed brazing jobs. 2 sizes.



Art #	Product
EHW4420BLUE	4 1/4" x 2" Blue Lens
EE1990BLUE	2" Round Blue Lens

### 50mm (2") Round Lenses

Replacement lenses for use in the round lens goggles and leather mask goggles.



Art #	Product
EE19900GS	50mm Dia Clear
EE19903	50mm Dia 3ew
EE19904	50mm Dia 4ew
EE19905	50mm Dia 5ew
EE19906	50mm Dia 6ew
EE19909	50mm Dia 9ew
EE19910	50mm Dia 10ew
EE19911	50mm Dia 11ew
EE19912	50mm Dia 12ew

# WELDING SAFETY



## Kromer Caps

The most famous and widely used brand of welding caps. Hand crafted in the USA for over 100 years & individually checked. They are available in a range of head sizes, and eye-catching designs. Double stitched with a comfortable cotton sweatband and are washable. Kromer Style A.



Art #	Product
ESF287000	Kromer Cap 6 7/8"
ESF287001	Kromer Cap 7"
ESF287002	Kromer Cap 7 1/8"
ESF287003	Kromer Cap 7 1/4"
ESF287004	Kromer Cap 7 3/8"
ESF287005	Kromer Cap 7 1/2"
ESF287006	Kromer Cap 7 5/8"
ESF287007	Kromer Cap 7 3/4"
ESF287008	Kromer Cap 7 7/8"

## Comeaux

### Comeaux Reversible Caps



The USA market leaders in welders cap design. Fixed size or elasticated, 2-sided reversible, in assorted design. **Sold individually.**

Art #	Product	Price Per Unit Exc. VAT
EC2000E	Reversible 1-Size	

EC2678	Reversible 6 7/8"
EC2700	Reversible 7"
EC2712	Reversible 7 1/2"
EC2714	Reversible 7 1/4"
EC2718	Reversible 7 1/8"
EC2738	Reversible 7 3/8"
EC2758	Reversible 7 5/8"
EC2778	Reversible 7 7/8"

### Heavy Duty Rigger Gloves

Superior quality for increased protection. good tear and puncture resistance. This glove is CE approved to EN420.



Art #	Product
EAD004	Power Riggers - Pair

## Welder's Bandana

Doorag Style, fits beneath welding helmet, or ties at neck. Available in one size in assorted patterns.



Art #	Product
EC7000	Bandana - Assorted
EC7000W	Bandana - Union Flag Design

## Crazy Caps

Flame retardant comfortable welders caps in a neutral orange colour.



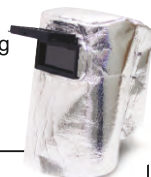
'One size fits all' thanks to their elasticated fit.

### Sold individually

Art #	Product
ESF1002	Crazy Cap

## Aluminised Flip-Up Welding Hood

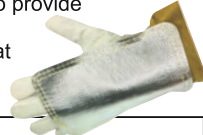
A welding hood can be a preferable alternative to a welding helmet. This aluminised hood incorporates a flip-up 4 1/4" x 2" window for observation.



Art #	Product
ESF240040	Aluminised Flip-front Hood
EHW442010G	4 1/4" x 2" 10ew Lens
ES4420SP	4 1/4" x 2" Clear Lens

## Aluminised Heat-Guard Pad

Small, aluminised, slip-on protective sleeves, worn over welding gloves to provide additional protection to the hands in close-up, high-heat applications. Can be used on either hand.



Art #	Product
EAD010AMB	Heat Guard Ambidextrous

## Rigger Gloves

General handling gloves. The CE approved chrome riggers offer low abrasion & piercing protection and are typically used as a more short-term disposable solution.



Art #	Product
EAD002	Chrome Riggers - Pair



**Green GP Gauntlets**

Fully lined. Green split leather with a one-piece back, welted thumb and fingers.



Art #	Product
EAD000	GP Green Gloves

**Gold Welders' Gauntlets**

Comfortable, lined, comfortable high quality Cat 2 welders' gauntlets.



Art #	Product
EAD012	Gold Welding Gloves


**Green Welders' Mitts**

Fully-lined, green split leather with thumb, index and mitt-style fingers. 'Cat 2' type product for welding.



Art #	Product
EAD017	Green Lined Mitts

**Reversible Green Gauntlets**

Fully lined. Green split leather. Central thumb, enabling glove to be used on either left or right hand.



Art #	Product
EAD000REV	Reversible Gloves

**Mordant Leather TIG Gloves**

Designed to be lightweight and comfortable to wear and allow easy movement of a TIG rod across the palm. Soft leather palm and fingers.



Art #	Product
EAD005	Mordant TIG Gloves


**Red Superior Gauntlets**

By popular demand, our red superior gauntlets are fully lined and provide a high level of comfort & protection.



Art #	Product
EAD009	Red Superior Gauntlets


**Skintex Blue Gloves**

Fully-lined & padded Skintex offer good protection to the wearer in MIG, Stick or Oxy/Fuel welding and in Plasma or Oxy/Fuel cutting. Ultra comfortable



Art #	Product
EAD007	Skintex Blue Gloves

**Fine Hide TIG Gloves**

Popular among TIG welders the fine hide design allows easy movement of a TIG rod across the palm and are comfortable to wear.



Art #	Product
EAD006	Fine Hide TIG Gloves


**EN 388**

**MECHANICAL HAZARDS**

- (A) Abrasion Resistance
- (B) Blade-cut Resistance
- (C) Tear Resistance
- (D) Puncture Resistance

**Performance Level**

- 0-4
- 0-5
- 0-4
- 0-4

**EN 407**

**THERMAL HAZARDS**

- (A) Burning Behaviour
- (B) Contact Heat
- (C) Convective Heat
- (D) Radiant Heat
- (E) Small Splashes of Molten Metal
- (F) Large Splashes of Molten Metal

**Performance Level**

- 0-4
- 0-5
- 0-4
- 0-4
- 0-4
- 0-4

## Clear Safety Specs

Comfortable and stylish clear safety spectacles providing protection from a clear single-piece lens to eyes from liquid splashes and "high speed particles - low energy impact" from the front and side angles. The black, nylon frame includes durable arms and is lightweight. These safety specs are suitable for most face sizes and are CE approved to EN166.



Art #	Product
EP282100	Clear Safety Specs

## Clear PC Visitor Specs

Strong, lightweight and comfortable safety spec for protection against "High Speed Particles - Low Energy Impact". Ideal for visitors who are not continuously exposed to ocular hazards for long periods of time. Can be worn over prescription glasses. Complete with side impact shields to offer good protection.



Art #	Product
DS2001	Clear Visitor Over-Spec

## Mustang Specs - Clear

Single piece, polycarbonate, clear safety specs, combining both style and affordability. Designed to be lightweight and comfortable, these specs provide a high level of protection from both the front and sides. CE approved to EN166



Art #	Product
EP282200	Mustang Clear Specs

## Green Safety Specs

Comfortable and stylish green or smoke safety spectacles providing protection from a green single-piece lens to eyes from liquid splashes and "high speed particles - low energy impact" from the front and side angles. Durable, black, nylon frame and anti-flash, green, shaded lens. These specs are suitable for most face sizes and are CE approved to EN166



Art #	Product
EP282105	Green Shaded Safety Specs
EP282106	Smoke Shaded Safety Specs

## Green PC Visitor Specs

Strong, lightweight and comfortable safety spec for protection against "High Speed Particles - Low Energy Impact". Ideal for use by visiting personnel who are not continuously exposed to ocular hazards for long periods of time. Can be worn over prescription glasses. Anti-flash shaded. Side impact protection shields to help protect the eyes from hazards at all feasible angles.



Art #	Product
DS2002	Green Visitor Over-Spec

## Mustang Specs - Blue Mirror

Single piece, polycarbonate, blue-mirror safety specs, combining style and affordability. Designed to be lightweight and comfortable, these specs provide a high level of protection from both the front and sides. CE approved to EN166



Art #	Product
EP282206	Mustang Shaded Specs

**Clear Goggles**

Made of a flexible PVC frame, with a strong, clear, single-piece screen. Comfortable fit, weighing <75 grams.

Three versions available, with a choice of either indirect or direct ventilation and anti-fog. All are CE approved and meet the requirements of EN166 for ocular safety & protection.



Art #	Product
ES1000	Clear Goggles - Direct Vent
ES1001	Clear Goggles - Indirect Vent

**6in Visor System**

This comfortable, lightweight browguard and headgear system protects the user in a range of applications.



The shade 5 visor is for Oxy/Fuel and Plasma.

The clear visor provides high optical quality

Art #	Product
EP294000	Headgear
EP294002	Shade 5 Visor
EP294001	PC Clear Visor

**Ear Plugs**

Represent high quality and value for money. Good attenuation and comfortable to wear. Cylindrical, soft-foam, compress-to-fit plugs for general purpose use in low to medium volume environments. Packed in pairs in cellophane pouches.

Available in a box of 200 pairs  
CE approved and meets EN 352.



Art #	Product
ES1011236B	Ear Plugs - Box 200 Pairs



All Weldability-Sif safety products and personal protective equipment meet the necessary standards and are CE approved - for your peace of mind.

**Wide Vision Goggles**

A clear panorama goggle for a wider field of vision. Lightweight, comfortable design. Provides good ventilation and CE approved to EN166.



Art #	Product
ES1001001	Wide Vision Goggles

**Clear Visor**

An economical browguard with adjustable pivot headgear for all head sizes.

Clear visor supplied separately



Art #	Product
ES281000	Browguard
ES281010	Clear Visor

**Hard Hat**

Made from polyethylene, this hard hat is fitted with a comfortable 4-point suspension system and a fully-adjustable ratchet-operated headgear, with sweatband. Designed to fit all head sizes. CE approved and conforming to the requirements of EN397.



Art #	Product
DS3000	Yellow Hard Hat

**Ear Defenders**

Designed to protect your hearing and ears in areas where a danger of loud noise or physical damage exists. Consist of comfortable, noise-reducing ear muffs on a durable headband. CE approved to EN352



Art #	Product
EAH1001	Ear Defenders

## Chrome Leather Skull Cap

Worn over the head to provide protection from spatter, sparks and heat. One Size Fits All' elasticated rim. CE approved to EN470.



Art #	Product
ESF4007	Chrome Leather Skull Cap

## Chrome Leather Sleeve

Worn over shirt sleeve for protection with elasticated cuffs. Two sizes available. CE approved to EN470.



Art #	Product
ESF4002	Standard Sleeve (each)
ESF4002L	Large Sleeve (each)

## Chrome Leather Trousers

Leather 'over trousers' to protect from heat, dirt, spatter and sparks. Made from quality chrome leather. Comfort fit with fly and belt popper. Available in four sizes. CE approved to EN470



Art #	Product
ESF4015	Chrome Leather Trouser - M
ESF4016	Chrome Leather Trouser - L
ESF4017	Chrome Leather Trouser - XL
ESF4018	Chrome Leather Trouser - XXL

## Yellow Leather Apron

This yellow-leather apron has durable plastic clip fasteners and good heat-resistance protection.



Art #	Product
ESF240100Y	Leather Apron

## Cotton-Back Chrome-Palm Glove

An economy glove for general maintenance. CE approved to EN420.



Art #	Product
EAD011	Chrome Palm Gloves - Pair

## Chrome Leather Aprons

Worn over clothes to protect the wearer from spatter, sparks & heat. Supplied with ties. Made from quality chrome leather. Available in 36" and 42" sizes. Also available with buckle and strap. CE approved EN470.



Art #	Product
ESF4003	Apron - 36"
ESF4003BCK	Apron - 36" Buckle & Strap
ESF4009	Apron - 42"

## Chrome Leather Jackets

Protect upper body & arms from spatter, and heat. High quality chrome leather. Velcro & poppers. Many sizes available. CE approved to EN470.



Art #	Product
ESF40012	Chrome Lthr Jacket - S
ESF4004	Chrome Lthr Jacket - M
ESF4005	Chrome Lthr Jacket - L
ESF4008	Chrome Lthr Jacket - XL
ESF4010	Chrome Lthr Jacket - XXL

ESF4011	Chrome Lthr Bolero - L
ESF4012	Chrome Lthr Bolero - XL
ESF4013	Chrome Lthr Bolero - XXL

## Chrome Leather Knee Pad

Made from chrome leather, the kneepad is hard-wearing and cushioned by an inner pad. One size.



Art #	Product
ESF240006	Knee Pad (each)

## Chrome Leather Spat

To protect shoes and trousers from spatter, sparks and heat. Two sizes available. Standard has a velcro seam, large has buckles. CE approved.



EN470

Art #	Product
ESF4006	Standard Spat (each)
ESF4006L	Large Spat (each)

### Red HR Leather Aprons

Worn over clothes to protect the wearer from spatter, sparks and heat. Supplied with ties. Made from high quality red leather which has a good heat resistance and more durability than standard chrome leather. Available only in a 36" long size.



CE approved to EN470.

Art #	Product
ESF240100	HR Red Apron - 36" c/w Ties

### Red HR Leather Trousers

Worn over a welders normal trousers to protect from heat spatter and sparks. Made from high quality red leather which has a good heat resistance. Comfort fit. CE approved to EN470.



Art #	Product
ESF240152	Red HR Trouser - M
ESF240153	Red HR Trouser - L
ESF240154	Red HR Trouser - XL

### Chrome Leather sleeve

Worn over shirt sleeve to protect clothes and arm. Standard 18in long, with elasticated cuffs. CE approved to EN470.



Art #	Product
ESF4002	Standard Sleeve (each)
ESF4002L	Large Sleeve (each)

### Red HR Leather Jacket

Worn over garments to protect upper body & arms from spatter, sparks and heat. Velcro & popper fastenings with covering flap. Red leather provides good heat resistance and durability. Available in 5 sizes. CE approved to EN470.



Art #	Product
ESF240101	Red HR Jacket - S
ESF240102	Red HR Jacket - M
ESF240103	Red HR Jacket - L
ESF240104	Red HR Jacket - XL
ESF240105	Red HR Jacket - XXL

### Flame-Resistant Overalls



The Weldability-Sif flame-resistant overall meets the requirements of:  
EN ISO 11611:2007 and EN ISO 11612:2008.

The garment features a robust studded front, side pockets, button-up cuffs, large front top pocket, rule pocket and an elastic waist for heightened comfort.

Typical uses include welding, cutting and grinding within electrical, oil and gas industries, automotive and many more.

Come's in a stylish navy blue and is available in 5 sizes from medium to XXXL.



Art #	Product
PV500102	Flame Resistant Overall - M Chest Size 40" - 41"
PV500103	Flame Resistant Overall - L Chest Size 42" - 44"
PV500104	Flame Resistant Overall - XL Chest Size 46" - 48"
PV500105	Flame Resistant Overall - XXL Chest Size 50" - 52"
PV500106	Flame Resistant Overall - XXXL Chest Size 54" - 55"



## Portable Welding Screen Kits

Easy-assembly, sturdy, mobile welding frame and curtain. Supplied in either 1.8m x 1.8m or 1.8m x 2.4m sizes.

Packaged for easy shipping and assembly.

Approved to EN1598. Available in Low Vis Green or High Vis Amber PVC material. Replacement curtains available separately



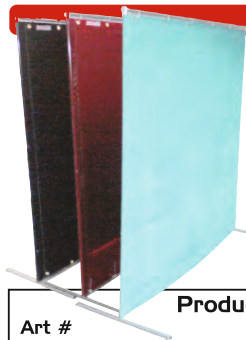
ZFRAMBER

### Product

#### Art #

EZFRAMBER	Portable Welding Screen Kit Amber	1.8m x 1.8m (6ft x 6ft)
EZFRAGREEN	Portable Welding Screen Kit Green	1.8m x 1.8m (6ft x 6ft)
EZFRAMBER8	Portable Welding Screen Kit Amber	1.8m x 2.4m (6ft x 8ft)
EZFRAGREEN8	Portable Welding Screen Kit Green	1.8m x 2.4m (6ft x 8ft)
EZFR6X6HA	Replacement Curtain Amber	1.8m x 1.8m (6ft x 6ft)
EZFR6X6LG	Replacement Curtain Green	1.8m x 1.8m (6ft x 6ft)
EZFR6X8HA	Replacement Curtain Amber	1.8m x 2.4m (6ft x 8ft)
EZFR6X8LG	Replacement Curtain Green	1.8m x 2.4m (6ft x 8ft)

## Welding Curtains



A range of welding curtains available in a choice of 3 materials; flame retardant green canvas, low visibility dark green PVC are all suitable for MIG, TIG and Stick with high visibility amber PVC suitable for Oxy/Fuel and Plasma.

They are supplied with top eyelets and side envelope seams.

All of these curtains are offered in 3 sizes; 6ft x 4ft, 6ft x 6ft and 6ft x 8ft. All PVC curtains meet EN1598.

### Product

#### Art #

EZ6X4C	Welding Curtain - Flame Retardant Canvas	6ft x 4ft
EZ6X4LG	Welding Curtain - Low Vis Green PVC	6ft x 4ft
EZ6X4HA	Welding Curtain - High Vis Amber PVC	6ft x 4ft
EZ6X6C	Welding Curtain - Flame Retardant Canvas	6ft x 6ft
EZ6X6LG	Welding Curtain - Low Vis Green PVC	6ft x 6ft
EZ6X6HA	Welding Curtain - High Vis Amber PVC	6ft x 6ft
EZ6X8C	Welding Curtain - Flame Retardant Canvas	6ft x 8ft
EZ6X8LG	Welding Curtain - Low Vis Green PVC	6ft x 8ft
EZ6X8HA	Welding Curtain - High Vis Amber PVC	6ft x 8ft
EZRING51	Split Ring	

## Strip Curtain

Sold by the metre, our made-to-measure strip curtains are 300mm wide and 2mm thick PVC. Available in green, amber or clear.

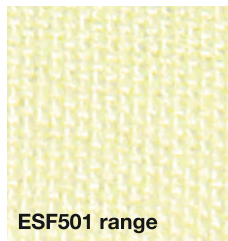
Custom made-to-order curtains are also available upon request.



### Product

#### Art #

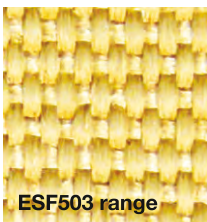
ECP26250291	Amber Strip Per Mtr (50mtr roll MOQ)
ECP26290291	Green Strip Per Mtr (50mtr roll MOQ)
ECP26200291	Clear Strip Per Mtr (50mtr roll MOQ)

**Protecto 500 Super Light Duty Blanket**


Uncoated Super-light Duty 550°C Glass Fibre Welding Blanket. 580g/m weight. Approved to BSEN 1869:1997. Available in 2x1mtr and 2x2mtr, 50mtr rolls and tested to BS476:Pt7 Class 1.

**ESF501 range**

Art #	Product
ESF5010	550°C Blanket 1 mtr x 2 mtr
ESF5011	550°C Blanket 2 mtr x 2 mtr
ESF5015	550°C Blanket 1 mtr x 50 mtr
ESF5016	550°C Blanket 2 mtr x 50 mtr

**Protecto 1000 Medium Duty Blanket**


Medium Duty 1000°C Glass Fibre Welding Blanket with high temperature resistant coating to improve slide and cut resistance. 1000g/m weight. Tested to European standard DIN 4102, Class B2.

**ESF503 range**

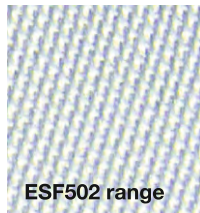
Art #	Product
ESF5030	1000°C Blanket 1 mtr x 2 mtr
ESF5031	1000°C Blanket 2 mtr x 2 mtr
ESF5035	1000°C Blanket 1 mtr x 50 mtr
ESF5039	1000°C Blanket Made-To-Measure

**Dial Thermometer**

A handy dial thermometer for use in a variety of applications. Can be screwed into pipework, cabinets, fume extraction equipment to establish the internal heat applicable inside. With readings from 10 degrees F to 700 degrees F and 0 to 350 degrees Centigrade. Very simple to install, just drill the correct sized hole (M10) and screw in. The rear probe detects the heat level and feeds this information through to the dial.



Art #	Product
ZMR06008	Dial Thermometer

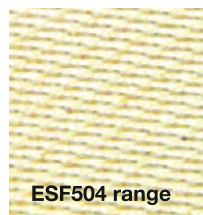
**Protecto 600 Light Duty Blanket**


Light Duty 600°C Glass Fibre Welding Blanket with fire retardant PU-coating with aluminium pigments to increase anti-slip properties and resistance to fraying. 710g/m weight. Ideal for use on ships and mobile offshore units.

**ESF502 range**

Tested to BS476:Pt7 Class 1.

Art #	Product
ESF5020	600°C Blanket 1 mtr x 2 mtr
ESF5021	600°C Blanket 2 mtr x 2 mtr
ESF5025	600°C Blanket 1 mtr x 50 mtr
ESF5029	600°C Blanket Made-To-Measure

**Protecto I200 Heavy Duty Blanket**


Heavy Duty 1150°C Silica Fabric Welding Blanket treated to provide excellent abrasive and fraying resistance. 1150g/m weight. Retains flexibility after exposure to heat.

**ESF504 range**

Art #	Product
ESF5040	1150°C Blanket 1 mtr x 2 mtr
ESF5041	1150°C Blanket 2 mtr x 2 mtr
ESF5045	1150°C Blanket 0.9 mtr x 50 mtr
ESF5049	1150°C Blanket Made-To-Measure
ESF5042	1150°C Blanket 1 mtr x 3mtr
ESF5046	1150°C Blanket 25 mtr Roll

**Digital Thermometer 850°C**

A digital thermometer with laser targeting and temperature detection via infrared, operated via trigger control. Ideal for pre-heating, interpass-temperature measurement and controlled-cooling tasks. Can be used on practically all solid surfaces and is battery-operated, with an LCD screen. Includes K-type probe.



Art #	Product
TTFX850C	Sif Temp IR Thermometer

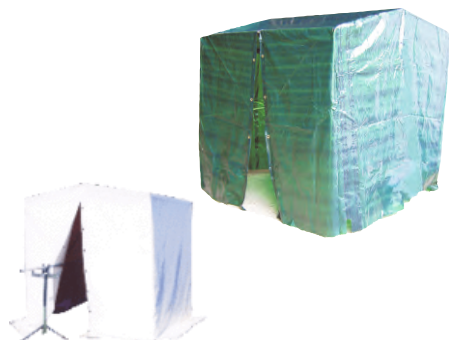
## Welding Table

A sturdy, fabricated welding table with steel grid surface, designed to allow jigs and clamps to be bolted in place through the slatted grid, to connect to your choice of clamp. Measuring 600mm x 600mm, this table is a cost-effective modular work surface, suitable for use in fabricator welding bays, workshops, colleges and training centres etc.



Art #	Product
PC600630T	Welding Table 600mm x 600mm
PC600C1300X	Clamp Kit 1m x 0.5m

## 2m x 2m x 2m Work Shelters



For welding on-site to protect the weld from the elements and passers-by or colleagues from the welding arc and spatter. Our work shelters all measure 2m high x 2m wide x 2m deep and are available in 2 materials - white opaque PVC I ow visibility green PVC.

Self Assembly Kit  
Frame and Corner Sold Separately

Art #	Product
EZTENTWSFRM	Work Shelter - Frame 2m x 2m x 2m
EZTENTWSCOV	Work Shelter - White Opaque Cover
EZTENTTGCOV	Work Shelter - Low-Vis Green Cover

## Nuisance Dust Mask

A classic style respirator that provides reliable, effective protection against nuisance level dusts and fine particulates. The convex shape, nose clip and twin-strap design make this mask suitable for a range of different face shapes and sizes. The respirator is disposable and comfortable to wear. Fully CE approved and sold in boxes of 50.



Art #	Product
ERSH605A	Dust Mask Pk 50

## Particulate Respirators

Our range of comfort-fit, valved respirators incorporate nose clips and adjustable twin-straps to fit a range of face sizes. Each provides protection against dusts, mists and metal fumes to their respective levels under EN149. They include an exhalation valve to allow exhaled air to be vented from the masks without compromising their protection. This reduces perspiration and increases comfort. The soft-sealing inner ring provides a reliable seal close to the face.



Art #	Product
ERSH3710V	FFP1S Mask Respirator Pk 10
ERSH3720V	FFP2S Mask Respirator Pk 10
ERSH8360V10	FFP3S Mask Respirator Pk 10



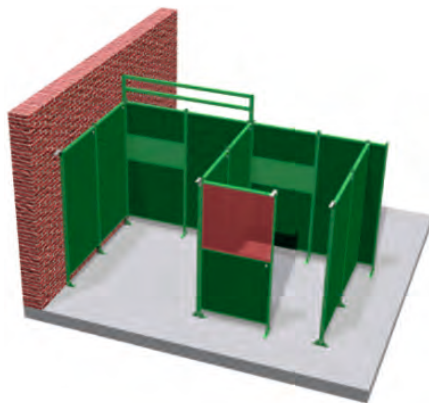
## "Ask Abe"

Controlling exposure to welding fumes for welder and their colleagues is vital. for a selection from our fume extraction range, see pages 94-98.



**Sonic Acoustic Panelling 2m (h) X 1m****NEW  
PRODUCT**

Our range of acoustic panelling used to provide welding bays to any configuration. A series of accessories are available to allow strip curtains, services and fume extraction to be mounted on all panels. Panels are manufactured from powder coated U-profile steel frames with perforated steel plate on both sides and a black glass fibre sound-absorbing mineral wool inner.



Art #	Product
ECP4500002010	Custom Design & Installation

**Extractability**

With years of experience working with air treatment solutions, Extractability has developed a reliable approach to ensure clean air in your working environment with a cost effective and easily operated system. The process involves analysis and design to supply, installation, commissioning and service, all included in a value for money package.

**Planning**

Once all the information has been received from the initial investigation phase we start to create a formula for achieving the best possible solution for your work environment. We choose products from our extensive product range, to customise a system, which provides a durable and optimal solution for ensuring ease of operation and a healthy work environment.

**Installation**

When the design phase is finished we have the ability to install your customised system. We have vast experience of delivering turn-key solutions which will operate perfectly, enabling you to focus on your core business.

**Commission**

Once we have completed installation, we commission the system ensuring all parameters are set correctly. Our constant drive for perfection creates an air cleaning system which is a reliable investment today and for years to come.



# FUME EXTRACTION



110v 1ph



30v 1ph  
6A/32A



400v  
1ph/3ph

## ProtectoVac MAX

The ProtectoVac MAX high quality, low-cost, highly portable extraction unit. It is an ideal modular unit that can be modified or purpose-built for specific applications to support the extraction of fumes and dust directly at the source. Designed specifically to extract the filter metal particulate fumes created in the welding processes, the ProtectoVac MAX is suitable for use in the workshop, demonstration, training bay, garage and on-site. The 'Dust Stop' semi-automatic cleaning system allows the operator to clean the filter with ease, by simply lifting the flap on the chamber. It operates from a 110v/230v mains input supply.

NEW  
PRODUCT



Art #	Product
EXTSVACMAX110	Single motor head with 15ltr body 110V
EXTSVACMAX230	Single motor head with 15ltr body 230V
EXTSVAC12	Carbon brush 110V 1000W
EXTSVAC14	Carbon brush 230V 1150W
EXTSVAC03	Carbon brush 230V 1150W
EXTSVAC10	Spare hose

CE

## SifVac

INNOVATION

The SifVac high-vacuum industrial system can deliver multiple forms of mobile extraction, including on-torch. It is an ideal modular unit that can be modified or purpose-built for specific applications to support the extraction of fumes and dust directly from the point of origin. When used in combination with the SifGun Fume Extraction MIG Torch, the extraction of MIG welding fumes and filtration of particles maximises the safety of the operator by eliminating fumes at source and before they enter the breathing zone.



## SifGun Fume Extraction Torch

The SifGun fume extraction torch is an innovative MIG welding torch with integrated extraction at the nozzle of the welding torch. Therefore the extraction is close to the weld pool, so the fumes coming from the welding process are extracted immediately. As a result the user's exposure to welding fumes is reduced by up to 95%.



Product		
Art #	110v	230v
EXTSVAC110S15	EXTSVAC230S15	Package 1 - Single motor head with 15ltr body
EXTSVAC110T15	EXTSVAC230T15	Package 2 - Single motor head with 15ltr body
EXTSVAC110C15	EXTSVAC230C15	Package 3 - Brushless turbine motor head with 15ltr body
EXTSVAC01		HD Vacuum brush kit
EXTSVAC02		Branch Connector + Airflow Reg
EXTSVAC03		Cartridge
EXTSVAC10		Spare hose
EXTSVAC12		SifVac Carbon brush 110V 1000W
EXTSVAC13		SifVac Carbon brush 110V 750W
EXTSVAC14		SifVac Carbon brush 230V 1150W
EXTMT2504		Air-cooled Fume Extraction MIG Torch 4M
EXTMT3004		Air-cooled Fume Extraction MIG Torch 4M
EXTMT5004		Water-cooled Fume Extraction MIG Torch 4M



## ProtectoXtract Fume Extractor

A mobile, high-efficiency, fume-extraction solution specifically designed to extract and filter metal particulate created in welding processes.

The ProtectoXtract is available in 110v and 230v models and features a 3m positional cantilever arm and canopy, designed for use in a welding bay, workshop and garage.

Operating with low noise (<72dB[A]) and fitted with castors for easy manoeuvrability. The ProtectoXtract incorporates a 4-step filtration system, with 4 replaceable filters. An optional spark arrestor filter is available for use in grinding or close-up extraction. This fume extractor should not be used for filtering fumes containing oil, solvents, explosive dust/gases or hybrid mixtures of wastes, etc. The ProtectoXtract is BGIA-certified and is suitable for category W3 stainless welding fumes (>30% nI+Cr).



### Product

#### Art #

EXT1MOB110	ProtectoXtract Mobile Extractor 110v
EXT1MOB230	ProtectoXtract Mobile Extractor 230v
EXT978003	Replacement Gross filter (Pack10)
EXT978004	Replacement Pre-Filter
EXT978005	Replacement Main Filter
EXT978006	Replacement Activated Carbon Filter
EXT978014	Optional Spark Arrestor Filter
EXT978013	ProtectoSpark RetroFit Kit

## ProtectoSpark

NEW PRODUCT

The ProtectoSpark is a Grinding Dust pre-filter for use in the ProtectoXtract Fume Extraction unit, allowing it to be used for extracting grinding dust in addition to welding fume.

The ProtectoSpark pre-filter can be fitted into a ProtectoXtract in seconds and once installed grinding dust is delivered to a collection tray for easy disposal.



CE

### Product

#### Art #

EXT978013	ProtectoSpark RetroFit Kit
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## Phantom Air PAPR System

INNOVATION

A lightweight helmet that can be used in most popular MIG and Stick welding applications. Conforms with EN379, EN175B and EN 166B. Supplied complete with a Powered Air Purification Respirator unit capable of providing an air flow of 170 or 220 lpm. 8 hour battery life on a full charge.

- Grind mode
- Lightweight and belt mounted PAPR unit
- Audible blocked filter and low battery alarms



CE

### Product

#### Art #

FXPAPR180	Phantom Air PAPR system
FXPAPRS16	Replacement Battery
ES9445SP	Replacement Inner Lens
ES11090SP	Replacement Outer Lens

The PAPR system has been designed to offer heavy protection from inhaling the contaminated air caused by welding applications. See more details on page 80.

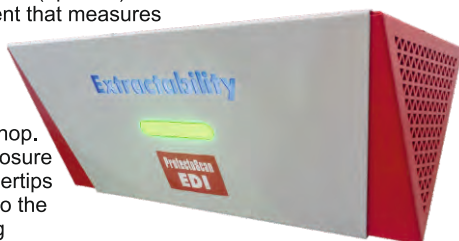




## ProtectoScan EDI

INNOVATION

The ProtectoScan EDI is an Environmental Detection Instrument (EDI) that provides intelligent, data-driven protection and interaction (optional) in the industrial workplace. An indoor air monitoring instrument that measures and records real-time data for dust/fume particulate, noise, temperature and humidity, EDI catches the eye with an LED traffic light display, alerting users to any notable issues, giving users instant feedback and a visual representation of what is going on in their workshop. Users will also benefit from EDI email alerts when exposure limits are surpassed. All live data sits at the users' fingertips via WiFi on the dedicated WebApp, turning the EDI into the perfect cloud-based solution, monitoring and recording exposure levels for every second of the day, 365 days a year.



Exposure to environmental hazards has always been difficult to monitor in the workplace, but the ProtectoScan EDI is about to change all that. It's easy to see why the ProtectoScan EDI is independently certified. The continuous monitoring of air quality in the workplace can contribute significantly to protecting the health of employees by enabling employers to take appropriate measures and set up automatic integration of fans or similar devices. Just as essential for the employer duty of care is the Extractability service and provision of a full report and certificate of calibration for competent risk assessment.



Dust Exposure (mg/m<sup>3</sup>)



### Product

#### Art #

EXT201701402111	ProtectoScan EDI
EXT201701502111	Air Controller for EDI

## ProtectoEco Cube

The ECO-Cube product line is a filter unit equipped with filter cartridges applicable for nearly every task in the area of fume and dust filtration. The polluted air is extracted by means of the ventilator and guided towards the filtering section. The toxic particles are deposited on the surface of the filter cartridges.

The cartridges are cleaned automatically by compressed air. The particles deposited on the cartridge are detached by the compressed air blast and reach a dust collecting tank. The cleaned air is recycled to the working space without any heat loss.



### Product

#### Art #

EXT3CUB11	EcoCube 415V 11KW
EXT3CUB55	EcoCube 415V 5.5KW
EXT3CUB75	EcoCube 415V 7.5KW

# Vent to Atmosphere Systems

VTA Systems offer a range of self supporting extraction arms and fans that extract welding fumes at the point of source and vent to atmosphere. VTA systems are available for wall mounting or ceiling mounting with additional supports. You can choose from a range of extraction arm lengths and fans from 230v 1ph or 415v 3ph capabilities.

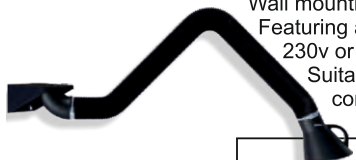
## Telescopic Suction Arms

**NEW  
PRODUCT**


Wall mounting Vent to Atmosphere Fume Extraction package with 1.2m to 2.0m arm. Supplied with 230v or 415v 1ph 0.75kw fan producing air movement of 2000 m/hr, Telescopic Arm and wall fixings. Suitable for connection to central units and individual fans. Ideal to extract pollutants produced by fixed welding benches, e.g. in welding booths.

Art #	Product
EXT1VTA1	1.2m-2m Telescopic Arm + Fan, Wall Bracket, Duct Kit 230v
EXT3VTA1	1.2m-2m Telescopic Arm + Fan, Wall Bracket, Duct Kit 415v

## Articulated Suction Arms

**NEW  
PRODUCT**


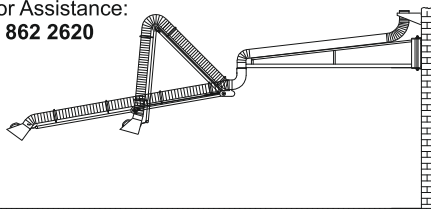
Wall mounting Vent to Atmosphere Fume Extraction packages. Featuring a range of arm Lengths from 2 - 4m. Supplied with either a 230v or 415v 1ph 0.75kw fan producing air movement of 2000 m/hr. Suitable for welding fume extraction - The arms can either be connected to individual fans or to central suction and filter systems

Art #	Product
EXT1VTA2	2m Articulated Arm + Fan, Wall Bracket, Duct Kit 230v
EXT3VTA2	2m Articulated Arm + Fan, Wall Bracket, Duct Kit 415v
EXT1VTA3	3m Articulated Arm + Fan, Wall Bracket, Duct Kit 230v
EXT3VTA3	3m Articulated Arm + Fan, Wall Bracket, Duct Kit 415v
EXT1VTA4	4m Articulated Arm + Fan, Wall Bracket, Duct Kit 230v
EXT3VTA4	4m Articulated Arm + Fan, Wall Bracket, Duct Kit 415v

## Long Reach Suction Arms

**NEW  
PRODUCT**


Suitable for welding fume extraction. The arms can either be connected to individual fans or to central suction and filter systems. Designed for use in large workshops and factories. Available with 5 - 8 meter self supporting articulated arm. Please call for Assistance:  
**0845 862 2620**



Extraction arms and fans are sold separately. For further assistance, help and advice please call Extractability on 0845 862 2620 or visit [www.extractability.eu](http://www.extractability.eu) for a full list of services.

FUME EXTRACTION

Custom Installation & Design

Extractability offers professional design and installation of extraction packages, tailored appropriately to each individual project. As with our welding fume extraction systems, we provide a complete package from design right through to installation and servicing.

For fume and dust control solutions to work to their maximum efficiency a consistent flow of air from the work zone must be maintained.

Buildings vary greatly, so it is essential that systems are installed by experienced teams that have a comprehensive understanding of air flow technology.

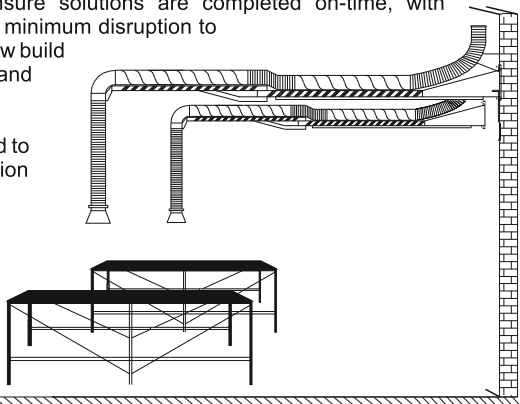
Our experienced installation teams will ensure solutions are completed on-time, with installation being planned with you to ensure minimum disruption to your day-to-day business operations or any new build schedule. All work is carried out in a safe and professionally managed way.

Installations are fully tested and commissioned to check they meet the original agreed specification and all necessary legal requirements.

Product

Custom Design & Installation

Call +44 (0) 845 862 2620 or  
Email [sales@extractability.eu](mailto:sales@extractability.eu) for information



Fume Extraction COSHH Testing

Local Exhaust Ventilation systems (LEV) require testing every 14 months under the current Control Of Substances Hazardous to Health Regulations (COSHH).

Extractability provides a comprehensive LEV Testing service to ensure your company is meeting these requirements as laid out by Regulation 9 of COSHH and the HSG258 guidance notice.



Regulation 9 of the Control of Substances Hazardous to Health 2002 Act states that “every employer who provides any control measure to prevent exposure of an employee to a substance hazardous to health, shall ensure that it is maintained in an efficient state, in efficient working order and in good repair”. In addition, where engineering controls are provided, the employer shall ensure that thorough examinations and tests are carried out and a suitable record of these be kept and made available for at least 5 years.

In the case of local exhaust ventilation systems (LEV) the examinations and tests must be performed at least once every 14 months. (In certain circumstances this period is reduced to every 6 months e.g. where metallic dust is being controlled).

We are able to provide a complete service to test, maintain and (where required) install complete fume extraction systems. This is a vital service due to increasing pressure on companies to watch their environmental footprint and to avoid health complaints from employees.

Product

Art #

EXTCOM01	Site Visit and First Test - Up to 3 units
EXTET02	Annua Renewal Re-Test Visit - Up to 3 units

**Shirts**

Branded shirts in either white or black.  
Available in a range of sizes to suit all.  
85% cotton  
15% polyester



Art #	Product
STLSWL	Branded White Shirt L
STLSWXL	Branded White Shirt XL
STSSBL	Branded Black Shirt L
STSSBXL	Branded Black Shirt XL
STPOLOL	Branded Black Polo L
STPOLOXL	Branded Black Polo XL

**Ball-Point Pen**

Blue-ink click-top branded pens with gel grip.



Art #	Product
STPEN50	Ball-Point Pen (Weldability)
STPEN50S	Ball-Point Pen (Sif)

**Baseball Caps**

Comfortable, adjustable, breathable baseball caps with hard peaks.  
Recreational wear only (not flame retardant).



Art #	Product
ST05B	Baseball Cap Black
ST05R	Baseball Cap Red

**Coffee Mugs**

White, Weldability and Sifbronze branded drinking mugs.



Art #	Product
WBCUPSIF	Cup Sifbronze
WBCUPWWS	Cup Weldability

**Carrier Bags**

Weldability Sif branded white plastic carrier bags.  
50cm x 30cm (e). (MOQ 20 Pcs)



Art #	Product
STBAGW	Promo Carrier Bags

**Jacket**

Durable and comfortable, our branded wind resistant and water repellent soft shell jacket is perfect for outdoor use, and on the road.  
Features fleece lining with internal pockets and zip-up outer pockets.



Art #	Product
STZIPBL	Branded Jacket L
STZIPBXL	Branded Jacket XL
STZIPBXXL	Branded Jacket XXL

**A4 Folder**

A black, zip-up A4 document wallet with a lined pad, pen-holder, business-card pouch and space for leaflets. Weldability-Sif branded.



Art #	Product
STPRESFLD	Presentation Folder

**Umbrella**

A Weldability-Sif branded large-diameter golf umbrella.



Art #	Product
STUMBGOL	Golf Umbrella

**Showroom POS Display**

We encourage our Trading Partners to hold stock, which can be merchandised on our 1m x 2m white peg-metal display stand with a base shelf and central shelf.

Supplied complete with a Weldability Sif header board and 20x euro hooks for hanging blister-packed and header-carded products.  
Excludes stock.



Art #	Product
WBPOS1X2M	Weldability Sif Pos Display 1x2m



## eLearning Welding Tutorial

INNOVATION

The Weldability Sif Foundation supports the training of welders to recognised standards in foundation welding studies at a network of training centres. We have developed an audio/visual welding and Fabrication eLearning tutorial for both home based learning and to compliment hands on college/workshop based training. This package will guide you through the range of welding processes and enable you to put your new skills into practice in the safety of a 3D interactive workshop environment.

- Basic Setup, Health & Safety and step by step instruction
- Mapped to NOS and EAL qualifications
- Supports college/training centre Guided Learning Hours (GLH)

This software gives learners the opportunity to study each of the recognised modern welding and cutting processes in a flexible learning solution. Alternatively, this is perfect for distributors wanting to broaden their knowledge of the welding processes.



Art #	Product
WBLEARN01	Single User eLearning DVD Level 1+2
WBLEARN00	Education Server License Lvl 1+2
WBLEARN06	Single User eLearning DVD Level 3+4
WBLEARN05	Education Server License Lvl 3+4

## Virtuweld VR Welding Simulator

INNOVATION

Virtuweld VR is an industry leading welder training simulator, which allows a realistic virtual welding bay to be set up in a classroom/office environment. Virtuweld VR provides a highly engaging, fully interactive training environment, which creates a realistic welding arc and welding sound effect. Dexterity guides are displayed in real time to assist the user in developing welding biased muscle memory. This in turn enables optimum torch geometry and travel speed to be perfected prior to entering a practical welding workshop. Virtuweld is the ideal companion to the Weldability Sif eLearning package and provides an opportunity to virtually weld coupons in an immersive environment. the user can select from either mild steel, stainless steel or aluminium in a range of welding configurations. Virtuweld VR will dramatically reduce raw material costs and the use of physical test coupons is kept to a minimum.



## Virtuweld Live

INNOVATION

Virtuweld Live is a welder training and educational tool that provides an interim step from simulation to unsupervised real welding. The live guidance system helps users maintain proper welding position, speed and technique whilst welding using real MIG welding equipment.

The Virtuweld Live system provides users with immediate in-helmet feedback on three core aspects of welding technique: speed, work angle and travel angle. This real-time feedback occurs inside the welding helmet and is set in the user's peripheral vision, so both the feedback and the weld puddle can be monitored simultaneously. By monitoring feedback, the user can see – while they weld – whether they need to correct their speed, work angle or travel angle. Virtuweld Live connects to any MIG welding torch.

The rig and helmet require no external power so are completely portable.



Art #	Product
WBLEARN31	Virtuweld VR Welding Simulator - MIG
WBLEARN32	MMA Add-On for Virtuweld VR

Art #	Product
WBLEARN33	Virtuweld Live Welding Guidance System

**Gas Equipment Inspection Training Course**

Weldability Sif provide 2 day Gas Equipment Inspection Training Courses, offering complete training and certification to inspect portable Oxy/Fuel Cutting and Welding equipment installations in accordance with the Provision & Use of Work Equipment Regulations 1998, and the British Compressed Gases Association Code of Practice 7.

**Learn how to:**

- Test equipment for functionality and safety
- Identify and replace non-compliant equipment
- Diagnose and prevent equipment problems
- Provide safe, compliant, leak-free installations
- Manage a 'tagging' process for annual inspections



Successful delegates will receive a certificate, identity card and a comprehensive inspection pack, including tool kit.

Art #	Product
WBCP7Q2D	2 Day Gas Inspectors Course
WBCP7R1D	1 Day Gas Inspector Refresher

We also offer one day refresher training courses, for those who are already qualified and are looking to renew or convert. Our refresher course is open to those qualified by other schemes and is valid for three years. For more information please contact our Training Team on 0345 130 7757

**Weld Procedures, Welder Coding & Welding Co-ordinating**

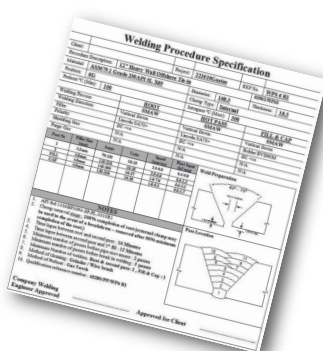
Weldability Sif offer a consultant weld procedure, development and welder testing service.

Covering a range of standards from the minimum requirement through to high-integrity applications you can be assured that your weld and welder are fit for the job.

Our service can be tailored to your requirements and we are able to assist with the creation of weld procedure specification (WPS) and can arrange for insurance backed welder certification. Our welding specialists are able to support the testing of welders to the following standards:

- BS4872 - Minimum requirements for welder competence
- BS EN 287-1 - Welder Qualification testing
- BS EN ISO 9606 - Welder Qualification testing
- BS EN ISO 15614 - Welding procedure testing
- ASME IX - Welding performance and procedure testing
- EN 1090-1 - Coordinating Welding Operations

Art #	Product
WBQCP01	Fillet Weld Qualification Test (Steel) ISO 9606
WBQCP07	Butt Weld Qualification Test (Steel) ISO 9606
WBQPS03	WPQR Procedure Development ISO 15614



**Gas Equipment Inspection Training Course**

# LEARN to WELD

Learn-To-Weld is the training and qualification division of Weldability Sif, delivering a suite of practitioner and professional vocational courses in welding. As an EAL-approved centre, the courses on offer range from Level 1 process introductions (in MIG, TIG, Stick, Oxy/Fuel, Brazing and Cutting), to Level 4 Responsible Welding Coordinator (ISO 3834).



Programmes are delivered flexibly - to assist with time management for busy learners and employers - as well as through a Sector-Based Work Academy model. Learn-To-Weld assists eligible learners with finding sources of funding for their training, and uses the latest digital training tools to increase achievement and improve learner-engagement.

Art #	Product
WBQ1MIG	EAL Level 1 MIG Welding Course (1 Week)
WBQ1TIG	EAL Level 1 TIG Welding Course (1 Week)
WBQ1MMA	EAL Level 1 Stick Welding Course (1 Week)
WBQ1OXY	EAL Level 1 Oxy/Fuel Welding Course (1
WBQWC3D	EAL Level 3 Welding Coordinator Course (3-Day Class + eLearning)
WBQRWC4D	EAL Level 4 Responsible Welding Coordinator Course (4-Day Class + eLearning)

**The Weldability Sif Foundation**

Weldability Sif Foundation has a number of partner studios in UK colleges nationally offering a Traineeship and Apprenticeships leading to a career in the welding industry.

The Welding industry offers bright and rewarding career opportunities, which range from traditional metal working workshop jobs to off-shore, construction, automotive, surface and sub-sea oil and shipbuilding. Opportunities arise world wide. Once you've gained some experience, your career could move towards welding supervision, design and inspection or lecturing. It is also possible to branch out into technical sales, marketing and production management roles.

There has never been a more exciting time to move into a career in the welding industry, and the structured Traineeship and Apprenticeship programmes from Weldability Sif provides the best possible start!



## Fume Extractor COSHH Testing

The COSHH regulations require that all LEV systems are subject to a thorough examination. The HSE require LEV (oil mist, welding fume, smoke and dust extraction) systems to be tested every 14 months, by a competent person. Inadequate testing can result in employers being prosecuted, insurance being invalidated and employees getting ill. Extractability provide a comprehensive LEV COSHH testing service on all makes and types of extraction equipment, working strictly in accordance with HSG258 guidelines. The pass or failure status, together with results and observations, are reported within 1 week of test. To ensure you are compliant - and prepared in anticipation of a routine HSE visit - contact Extractability today to make your booking.



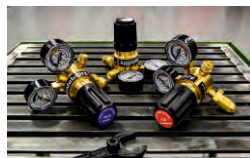
Art #	Product
EXTCOM01	Fume Extractor COSHH Testing

## Gas Equipment CP7 Testing & Tagging

Dangers such as fire, explosion, self-ignition, asphyxiation and poisoning are associated with compressed gases, depending on the type and conditions of gas used.

The UK Provision & Use of Work Equipment Regulations stipulate that equipment should be fit-for-purpose, maintained in a safe condition and regularly inspected by a 'competent person' with records kept. Furthermore, most insurance companies now insist on competent maintenance and documented annual inspection of compressed gas equipment for welding and cutting.

The British Compressed Gases Association Code of Practice #7 (CP7) gives valuable technical guidance on the safe use, inspection and maintenance of compressed Oxy-Fuel Gas Equipment (individual portable or mobile cylinder supply).



Art #	Product
EXTCP7TAG01	CP7 Training and Tagging

## Arc Equipment Validation

For quality control and repeatable performance to qualified welding procedures, it is vital that the calibration of your welding equipment meters is validated annually. Increasingly, client work is requiring fabricators to be able to demonstrate that their machines are accurate, with supporting certification.

Weldability Sif offer a proactive annual facility, for your clients' peace of mind. Our team of Field Service Technicians provide an on-site welding machine validation service, to BS EN 50504, resulting in a detailed report for each unit. Each machine is inspected, vacuumed, electronically checked, weld-tested and validated at a range of output settings. The pass or failure status, together with results and observations, are reported and/or certified, and documentation is provided within 1 week.

Art #	Product
EXTVALID01	Arc Equipment Validation

## Welder Qualification

Via their PCN/CSWP-approved associate Inspectors, Weldability Sif assist clients with developing and qualifying their welding procedures, to enable consistent welding results to be obtained and welders to be independently qualified ('coded') in compliance with them.

Weldability Sif facilitate a process review, preliminary WPS drafting, UKAS lab testing of testpieces, and witnessing of welders' work to qualified procedures, resulting in a pack of documents demonstrating repeatable results – required by professional clients, trade bodies and insurers in today's quality-assured market environment. Contact Weldability Sif with your welder-coding or procedurising requirements today.

Art #	Product
WBQPS03	Welding Procedure (WPS/PQR) Development
WBQCP09	Fillet Weld PQR Lab Test ISO
WBQCP08	Butt Weld PQR Lab Test ISO
WBQCP00	1 Day On-Site Visit For Weld Test Witnessing
WBQCP01	Fillet Weld Qualification Lab Test ISO 9606
WBQCP07	Butt Weld Qualification Lab Test ISO 9606

## Aluminium

MIG	Page 105	TIG	Page 111	GAS	Page 117	Brazing	Page 117	ARC	Page 121
SIFMIG 1050 SIFMIG 4043 SIFMIG 4047 SIFMIG 5356 SIFMIG 5183 SIFMIG 5556		SIFALUMIN No 14 SIFALUMIN No 15 SIFALUMIN No 16 SIFALUMIN No 27 SIFALUMIN No 28 SIFALUMIN No 37		SIFALUMIN No 14 SIFALUMIN No 15 SIF FLUXCORE ALUMINIUM		SIFALUMIN No 16 SIF 555 AL SOLDER		SIFTRODE ALU Si12	

## Brass/Bronze

MIG	Page 106	TIG	Page 112	GAS	Page 117	Brazing	Page 115/116	ARC	Page 121
SIFMIG 8 SIFMIG 328 SIFMIG 967 SIFMIG 968		SIFPHOSPHOR BRONZE No 8 SIFPHOSPHOR BRONZE No 82 SIFSILCOPPER No 968		SIFPHOSPHOR BRONZE No 8 SIFPHOSPHOR BRONZE No 82		SIF SILVER SOLDER No 39/40/43 SIFBRONZE No 1		SIFTRODE BRONZ CUSN	

## Cast Iron

MIG	Page 108	TIG	Page 112	GAS	Page 117	Brazing	Page 115	ARC	Page 121
SIFMIG 8 SIFMIG 328		SIFPHOSPHOR BRONZE No 8		SUPER SILICON No 9 SUPER SG CAST IRON		SIFBRONZE No 1		SIFTRODE CAST Ni SIFTRODE CAST NiFe SIFTRODE CAST IRON	

## Copper

MIG	Page 108	TIG	Page 112	GAS	Page 117	Brazing	Page 115	ARC	Page 121
SIFMIG 985 SIFMIG 968 SIFMIG 8 SIFMIG 328 SIFMIG 44 SIFMIG 967		SIFSILCOPPER No 985 SIFSILCOPPER No 968 SIFPHOSPHOR BRONZE No 8 SIFPHOSPHOR BRONZE No 82 SIFALBRONZE No 32 SIFALBRONZE No 44		SIFSILCOPPER No 7		SIFCUPRON No 17 SIFCUPRON No 17-2Ag SIFCUPRON No 17-5Ag SIFCUPRON No 17-15Ag SIF SILVER SOLDER No 39.40/43 SIFSILVERCOAT No 43		SIFTRODE BRONZ CUSN	

## Magnesium

TIG	Page 111				
	SIFMAGNESIUM No 23				

## Stainless

MIG	Page 108	TIG	Page 113	GAS	Page 117	Brazing	Page 115/116	ARC	Page 120
SIFMIG 308LSi SIFMIG 316LSi SIFMIG 347 SIFMIG 309LSi SIFMIG 312 SIFCORED e308LT1 SIFCORED e309LT1 SIFCORED e316LT1		SIFSTEEL STAINLESS 308L SIFSTEEL STAINLESS 316LSi SIFSTEEL STAINLESS 347 SIFSTEEL STAINLESS 309L SIFSTEEL STAINLESS 312 SIFSTEEL STAINLESS 310 SIFSTEEL DUPLEX		SIFSTEEL STAINLESS 308L SIFSTEEL STAINLESS 316LSi SIFSTEEL STAINLESS 347		SIFBRONZE No2 SIF SILVER SOLDER No43 SIFSILVERCOTE No43		SIFCHROME 308 L-17 SIFCHROME 316 L-17 SIFCHROME 307 SIFCHROME 309L SIFCHROME 312 L-17	

## Steel


MIG	Page 107	TIG	Page 114	GAS	Page 118	Brazing	Page 116	ARC	Page 119
SIFMIG SG2 SIFMIG ZERO SG2 SIFMIG SG3 SIFMIG ZERO SG3 SIFMIG A15 SIFMIG A32 SIFMIG H/600 SIFMIG 120S-G SIGMIG Ni2 FLUX CORED WIRES SIFMIG GASLESS SIFCORED 600 SIFCORED E71T-1 SIFCORED E11T1-Ni SIFCORED E70C-6M SIFCORED E110C-G		SIFSTEEL A15 SIFSTEEL A17 SIFSTEEL A18 SIFSTEEL A31 SIFSTEEL A32 SIFSTEEL A33 SIFSTEEL HF6		SIFSTEEL No 11 SIFSTEEL No 22		SIFBRONZE No 1 SIFBRONZE No 2 SIF AUTOBRONZE SIFBRONZE No 101 SIFREDICOTE No 1 SIFREDICOTE NO 2		SIFTRODE 6013R SIFTRODE 7018VR SIFTRODE 6013M SIFTRODE 7018M SIFTRODE SPEZIAL 7016 SIFTRODE 7024 SIFTRODE 6010	



Aluminium **AL****SIFMIG 1050**

A pure aluminium (99.5% min) shaved wire which produces a ductile weld equal in strength to that of the base metal.

EN ISO 18273 - S Al 1070 (Al99.7),  
BS: 2901 1050A, (GIB) (NG3)



	Dia mm	Art #	6.5kg Spl	
	0.8	WO140865		
	1.0	WO141065		
	1.2	WO141265		
	1.6	WO141665		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	90	15	118

**SIFMIG 4043**

An Aluminium alloy with 5% silicon giving excellent flow characteristics and penetration. Suitable for welding duralumin, cast and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised.

EN ISO 18273 S Al 4043A (AlSi5),  
BS: 2901 4043A, (NG21)

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
0.8	WO150805 ★		WO150820		WO150865 ★	
1.0	WO151005 ★		WO151020		WO151065 ★	
1.2	WO151205 ★		WO151220		WO151265 ★	
1.6					WO151665 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
5 Si Bal Al	635	120	40	118		

**SIFMIG 4047**

Aluminium alloy containing 12% Silicon, for high silicon alloys and automotive work.

EN ISO 18273 S Al 4047A (AlSi12),  
BS: 2901 4047A, (NG2)

Dia mm	Art #	2.0kg Spl	Art #	6.5kg Spl
1.0	WO161020		WO161065 ★	
1.2			WO161265 ★	
1.6			WO161665 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
12 Si Bal Al	585	130	50	118

**SIFMIG 5356**

A general purpose aluminium wire with 5% magnesium that has excellent corrosion resistance and high strength. Suitable for welding magnesium bearing aluminium alloys such as 5251 (N4), 5154 (N5), 5454 (N51) and also heat treatable alloys 6063 (H9), 6061 (H20) and 6082 (H30)

EN ISO 18273 S Al 5356 (AlMg5),  
BS: 2901 5356, (NG6)

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
0.8	WO270805 ★		WO270820		WO270865 ★	
1.0	WO271005 ★		WO271020		WO271065 ★	
1.2	WO271205 ★		WO271220		WO271265 ★	
1.6					WO271665 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
5 Mg Bal Al	640	250	60	118		

**SIFMIG 5183**

Special aluminium alloy containing 5% Magnesium and 0.75% Manganese, for improved weld strength.

EN ISO 18273 S Al 5183  
(AlMg4.5Mn0.7), BS: 2901 5183

Dia mm		Art #	6.5kg Spl	
1.0		WO281065		
1.2		WO281265		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
5 Mg, 0.75 Mn, Bal Al	640	275	65	118

**SIFMIG 5556**

Aluminium alloy containing 5.3% Magnesium; all elements are closely controlled for optimum weld strength. Normally used on 5083 (N8) and for military applications

EN ISO 18273 S Al 5556A  
(AlMg5Mn), BS: 2901 5556

Dia mm	Art #	0.5kg Spl	Art #	2.0kg Spl	Art #	6.5kg Spl
1.0					WO371065 ★	
1.2	WO371205		WO371220		WO371265 ★	
1.6					WO371665 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
5 Mg, 0.8 Mn, 0.1Cr, 0.1Ti Bal Al	640	300	70	118		

### Copper & MIG Brazing **CU**

#### SIFMIG 8

This phosphor bronze wire contains 7% tin and is suitable for fusion welding of phosphor bronze castings and copper alloys (brass). It is also used for MIG brazing on ferrous and dissimilar metals or for applying a bearing surface.

**ISO 24373 Cu 5180A (CuSn6P)**  
**BS: 2901 C11**

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO080807		WO080840		WO080812	
1.0	WO081007		WO081040		WO081012	
1.2	WO081207		WO081240		WO081212	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
7 Sn, Bal Cu		900-1050	260	80	132 & 133	

#### SIFMIG 328

This is a 92/8 aluminium bronze wire suitable for welding materials of a similar composition and copper alloys. It is ideal for MIG brazing, dissimilar metal joints and maintenance applications.

**ISO 24373 Cu 6100 (CuAl17)**  
**BS: 2901 C12/C28**

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl	Art #	200kg Drum
0.8	WO320840A		WO320812A		WO3208200A	
1.0	WO321040A		WO321012A		WO3210200A	
1.2	WO321240A		WO321212A		WO3212200A	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
8 Al, Bal Cu		1030	430	85		

#### SIFMIG 44

Nickel aluminium bronze for Ab2 material and marine/corrosive applications.

**EN ISO 24373 Cu 6328 (CuAl9Ni15)**  
**BS: 2901 C20/C26**

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8			WO440812	
1.2	WO441240		WO441212	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
83 Cu, 9 Al, 3 Fe, 4 Ni, 1 Mn	1050	700	290	

#### SIFMIG 967

A copper wire containing 2% silicon and 1% manganese. Has optimised flow characteristics and suitable for variable root gaps. Reduces weld spatter and offers increased corrosion resistance.

**ISO 24373 Cu 6511 (CuSi2Mn1)**

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl	Art #	200kg Drum
0.8	WO970840		WO970812		WO9708200	
1.0	WO971040		WO971012		WO9710200	
1.2	WO971240		WO971212		WO9712200	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
1 Mn, 2 Si, Bal Cu		1030-1050	285	62	128	

#### SIFMIG 968

A copper wire containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for MIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications.

**ISO 24373 Cu 6560 (CuSi3Mn1)**  
**BS: 2901 C9**

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl	Art #	200kg Drum
0.8	WO960807		WO960840		WO960812		WO9608200	
1.0	WO961007		WO961040		WO961012		WO9610200	
1.2			WO961240		WO961212		WO9612200	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page			
1 Mn, 3 Si, Bal Cu		980-1020	350	90	128			

#### SIFMIG 985

High quality wire containing a minimum of 98.5% copper with deoxidizing elements. It is ideal for MIG welding of copper.

**ISO 24373 Cu1898 (CuSn1)**  
**BS: 2901 C7**

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO980840		WO980812	
1.0	WO981040		WO981012	
1.2	WO981240		WO981212	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.25 Mn, 0.25 Si, Bal Cu, P 0.01, Sn 0.85	1025	220	70	132

### Steels & Self Shielding Cored Wire **STL**

#### SIFMIG S92

Copper coated mild steel MIG wire for welding mild and medium tensile steels for impact toughness down to -30°C

**EN ISO 14341-A G 42 3 M21 3Si1**  
**EN 440 G3Si1, (BS 2901: A18)**  
**(DIN S92)**

Dia mm	Art #	0.7kg Spl	Art #	5.0kg Spl	Art #	15kg Spl	Art #	250kg Drum
0.6	WA180607		WA180650		WA180615			
0.8	WA180807		WA180850		WA180815		WA1808250	
1.0			WA181050		WA181015		WA1810250	
1.2					WA181215		WA1812250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page			
0.1 C, 0.8 Si, 1.3 Mn		1450	400	120	134			

## Steels & Self Shielding Cored Wire STL

### SIFMIG ZERO SG2

Double-deoxidised mild steel MIG wire, free from copper coating with increased silicon and manganese content.

EN ISO 14341-A G 42 3 M21 3Si1  
AWS A5.18:ER70S-6

Dia mm	Art #	18kg Spl	Art #	250kg Drum
1.0 - 18kg spool	WA201018			
1.0 - 25kg drum			WA2010250	
1.2 - 18kg spool	WA201218			
1.2 - 25kg drum			WA2012250	

### SIFMIG SG3

Copper coated steel MIG wire with increased silicon and manganese for improved UTS

EN ISO 14341-A G 46 3 M21 4Si1  
EN 440 G4Si1 (DIN SG3)

Dia mm	Art #	15kg Spl	Art #	250kg Drum
0.8	WG030815		WG0308250	
1.0	WG031015		WG0310250	
1.2	WG031215		WG0312250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN
0.1C, 1.0Si, 1.75Mn		1450	600	120
				134



### SIFMIG ZERO SG3

Copper free steel MIG wire providing a low spatter arc with low noise and visible fume for high productivity applications. Increased silicon and manganese for improved UTS

EN ISO 14341-A 46 3 M21 G4Si1  
EN 440 G4Si1 (DIN SG3)

Dia mm	Art #	15/18kg Spl	Art #	250kg Drum
0.8 - 15kg spool	WA190815			
1.0 - 18kg spool	WA191018		WA1910250	
1.2 - 18kg spool	WA191218		WA1912250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN
0.1C, 1.0Si, 1.75Mn		1450	600	120
				134

### SIFMIG A15

Triple deoxidised mild steel MIG wire.

EN ISO 636-A W2Ti  
BS: 2901 A15



Dia mm	Art #	15kg Spl
0.8	WA150815	
1.0	WA151015	
1.2	WA151215	
% Metal Composition		Melting°C
0.1 C, 0.6 Si, 1.3 Mn, 0.2 Al		1450
		440
		120
		134

### SIFMIG A31

A copper-coated alloy steel wire containing 1.25% molybdenum. Suitable for use on low temperature pressure vessel and pipe work applications.

EN ISO 14341-A-G4Mo  
BS: 2901 A31, AWS: ER 80S-D2

Dia mm	Art #	15kg Spl
0.8	WA310815	
1.0	WA311015	
1.2	WA311215	
% Metal Composition		Melting°C
0.1 C, 0.7 Si, 1.8 Mn, 1.25 Mo		1450
		460
		180
		134

### SIFMIG A32

A copper coated, alloy steel wire containing 1.0% chromium and 0.5% molybdenum. It is ideal for low alloy and creep resistant steels.

EN ISO 21952-A: G CrMo1Si (1CM)  
AWS: A5.28 : ER80S-B2  
BS: 2901 A32

Dia mm	Art #	15kg Spl
0.8	WA320815	
1.0	WA321015	
1.2	WA321215	
% Metal Composition		Melting°C STL
0.1 C, 0.5 Si, 1 Mn, 1.3 Cr, 0.5 Mo		1450
		500
		180
		134

### SIFMIG GASLESS

Self shielding steel MIG wire; ideal for DIY use

AWS: E71T-GS

Dia mm	Art #	0.45kg Spl	Art #	0.9kg Spl	Art #	4.55kg Spl
0.8	WG180805 ★		WG180809		WG180845	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.25 C, 0.4 Si, 0.7Mn, 2.4 Al		1450	400	120		

### Steel Flux & Metal Cored Wire STL

#### SIFCORED E71T-1

Rutile flux cored wire for welding thin sheet steels or low alloyed structural steels in all positions. Argon/cO<sub>2</sub> shielding gas.

EN ISO 17632-A-T 42 2 P M 1 H5  
AWS: E71T-1M

Dia mm	Art #	5kg Spl	Art #	15kg Spl
1.2	WO711250		WO711215 ★	
1.6			WO711615 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.05 C, 0.48 Si, 1.22 Mn 0.013 P, 0.009 S	1450	570	105	

#### SIFCORED E81T1-Ni

Rutile flux cored wire for welding low temperature applications which require post-weld heat treatment (PWHT).

EN ISO 17632-A-T 46 6 1Ni P M 2 H5  
AWS: E81T1-Ni 1M-J

Dia mm	Art #			15kg Spl
1.2	WO811215			
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.05 C, 0.32 Si, 1.26 Mn, 0.95 Ni, 0.006 P, 0.006 S	1450	582	135	

#### SIFCORED E70C-6M

Metal cord wire for mild steel and 490MPa high tensile steels.

EN ISO 17632-A-T 42 4 M M 3 H5  
AWS: E70C-6M

Dia mm	Art #	5kg Spl	Art #	15kg Spl
1.2	WO701250		WO701215 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.08 C, 0.52 Si, 1.39 Mn 0.009 P, 0.009 S	1450	600	105	

#### SIFCORED E110C-G

Metal cored wire for welding 110ksi class high strength steels and can provide excellent mechanical properties and crack resistance.

EN ISO 18276-A-T 69 6 Mn2.5Ni M M 3 H5  
AWS: E110C-G H4

Dia mm			Art #	12.5kg Spl
1.2			WO111212	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.06 C, 0.48 Si, 1.87 Mn,	1450	791	115	

### Stainless SS

#### SIFMIG 347

Stainless steel wire, niobium stabilised to prevent weld decay, giving excellent corrosion resistance. Suitable for use on 18/8 type stainless steel, Nb and Ti stabilised, such as 304, 321 and where the weld is subjected to temperatures above 400°C.

EN ISO 14343 19 9 NB  
BS: 2901 347 S96

Dia mm			Art #	12.5kg Spl
0.8			WO200815	
1.0			WO201015	
1.2			WO201215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.04 C, 0.8 Si, 1.5 Mn, 10 Ni, 20 Cr, 0.6 Nb	1440	650	180	133

#### SIFMIG 316LSi

A molybdenum bearing, stainless steel with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steels.

EN ISO 14343: 19 12 3 LSi,  
BS: 2901 316 S93  
AWS A5.9 : ER316LSi (0.7kg)

Dia mm	Art #	0.7kg Spl	Art #	3.75kg Spl	Art #	12.5/15kg Spl
0.6	WO210607		WO210640		WO210612	
0.8	WO210807		WO210840		WO210815 ★	
1.0	WO211007		WO211040		WO211015 ★	
1.2	WO211207		WO211240		WO211215 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
0.02 C, 0.8 Si, 1.5 Mn, 12 Ni, 19 Cr, 2 Mo	1440	650	180	133		

#### SIFMIG 308LSi

Stainless steel filler wire suitable for welding 18/8 (304) austenitic stainless steels, providing good corrosion and wear resistance.

EN ISO 14343: 19 9 LSi  
BS: 2901 308 S93

Dia mm	Art #	0.7kg Spl	Art #	3.75kg Spl	Art #	12.5/15kg Spl
0.8	WO330807		WO330840		WO330815 ★	
1.0	WO331007		WO331040		WO331015 ★	
1.2	WO331207		WO331240		WO331215 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
0.02 C, 0.8 Si, 1.5 Mn, 10 Ni, 21 Cr	1440	650	180	133		

#### SIFMIG 309LSi

This stainless steel wire contains higher chromium and Nickel. It can be used for joining material of similar composition and also dissimilar stainless steels.

EN ISO 14343: 23 12 LSi  
BS: 2901 309 S93

Dia mm	Art #	3.75kg Spl	Art #	12kg Spl	Art #	15kg Spl
0.8	WO340840		WO340812		WO340815 ★	
1.0	WO341040				WO341015 ★	
1.2	WO341240				WO341215 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page		
0.1 C, 0.4 Si, 1.5 Mn, 13 Ni, 26 Cr	1440	650	180	133		

## Stainless SS

## SIFMIG 310

Corrosion resistant, chrome-nickel wire for welding heat-resistant austenitic stainless steels.

EN ISO 14343-A 25 20  
BS 2901 310 594

Dia mm		Art #	15kg Spl	
0.8		WO360815		
1.0		WO361015		
1.2		WO361215		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C, 0.4 Si, 1.7 Mn, 9 Ni, 30 Cr, 0.1 Mo	1440	750	200	133

## SIFMIG 312

This is a 29.9 stainless MIG wire, suitable for difficult-to-weld steels (Mn steels, tool and spring steels), also dissimilar materials. High resistance to weld metal cracking.

EN ISO 14343: 29 9  
BS 2901 312 594

Dia mm	Art #	5kg Spl	Art #	15kg Spl
0.8	WO350840		WO350815	
1.0	WO351040		WO351015	
1.2			WO351215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C, 0.4 Si, 1.7 Mn, 9 Ni, 30 Cr, 0.1 Mo	1440	750	200	133

## SIFMIG DUPLEX

A 2209 duplex wire for welding austenitic-ferritic stainless alloys providing intergranular, pitting and stress corrosion resistance.

EN ISO 14343-A 22 9 3 NL  
AWS A5.9 ER2209

Dia mm			Art #	15kg Spl
0.8			WO220815	
1.0			WO221015	
1.2			WO221215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
1.7Mn, 22.5Cr, 8.5Ni, 3.3Mo	1420	765	240	

## Stainless Steel Flux Cored Wire SS

## SIFCORED E308LP

Rutile flux cored wire for welding 18-8 stainless steel. Suitable for butt and fillet welding in all positions including verticle down.

EN ISO 17633-A-T 19 9 L P C/M 1  
AWS: E308LP

Dia mm				Art #	15kg Bkt
1.2				WF331215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
10.4 Ni, 18.7 Cr, 1.3Mn, 0.03 C 0.6 Si, 0.018 P, 0.004 S	1450	400	120		

## SIFCORED E309LP

Rutile flux cored wire for welding dissimilar metals. Suitable for butt and fillet welding in all positions including verticle down.

EN ISO 17633-A-T 23 12 L P C/M 1  
AWS: E309LP

Dia mm				Art #	15kg Bkt
1.2	WF341215				
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
12.6 Ni, 23.3 Cr, 1.3 Mn, 0.03C 0.7 Si, 0.018 P, 0.005 S	1450	400	120		

## SIFCORED E316LP

Rutile flux cored wire for welding 18-12-2 stainless steel. Suitable for butt and fillet welding in all positions including verticle down.

EN ISO 17633-A-T 19 12 3 L P C/M 1  
AWS: E316LP

Dia mm			Art #	15kg Bkt
1.2			WF211215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
12.3 Ni, 18.4 Cr, 2.9 Mo, 0.03C 0.7 Si, 1.4 Mn, 0.019 P, 0.006 S	1450	400	120	

## Hardfacing STL

## SIFCORED 600

Metal cored wire for wear resistant surfacing parts of steel, cast steel and high Mn steel, subject to abrasion, metal to metal wear, impact and/or compression stresses.

EN 14700 T Fe8  
DIN 8555: MSG6-4Z-60

Dia mm	Art #	5kg Spl	Art #	15kg Spl
1.0			WO601015	
1.2	WO601250		WO601215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.5C, 0.6Si, 1.5Mn, 5.5Cr, 0.6Mo	n/a	n/a	600	

## SIFCORED HF600

Solid hard facing MIG wire, for high wear resistance.

EN 14700 S Fe8  
DIN 8555: MSG6-GZ-60

Dia mm	Art #	5kg Spl	Art #	15kg Spl
1.0	WF601050		WF601015	
1.2	WF601250		WF601215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.45 C, 3 Si, 0.4 Mn, 9 Cr	1450	n/a	570-650	



### Low-Alloy MIG STL

#### SIFMIG 120S-G

A low-alloy MIG wire with cr. Mo and Ni for high-strength steel applications such as earth-moving equipment and crane manufacture.

EN ISO 16834-A: G 89 4 M

(Mn4Ni2CrMo),

AWS A5.28 ER120S-G

Dia mm				Art #	15kg Spl
0.8				WG120815	
1.0				WG121015	
1.2				WG121215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
1.9Mn, 2.1Ni, 0.5Mo, 0.4Cr		690			

#### SIFMIG Ni2

A fine-gained low-alloy steel with 2% nickel for low-temperature applications requiring good toughness, such as offshore platform and pipeline construction.

EN ISO 14341-D G50 6M G2 Ni2

AWS A5.28 ER80S-Ni2

Dia mm			Art #	15kg Spl
1.0			WG721015	
1.2			WG721215	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 2.1Ni, 1.0Mn		620		

# sif TIG PROCESS

### TIG Special Alloys STL AL NI CU SS

#### SIFALLOY No73

A copper-nickel-ferrous rod with 30% nickel particularly suitable for highly-stressed corrosion-resistant weld surfacing on cast iron and on unalloyed and low-alloyed steel in applications such as plant engineering.

ISO 24373 Cu7158 (CuNi30)

Dia mm		Art #	5.0kg Ctn	
1.6		RT731650		
2.4		RT732450		
3.2		RT733250		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
30.7Ni, 0.5Fe, Cu Bal	1180	420	115	

#### SIFALLOY No79

A copper-nickel-ferrous rod with 10% nickel particularly suitable for highly-stressed corrosion-resistant weld surfacing on cast iron and on unalloyed and low-alloyed steel in applications such as plant engineering.

ISO 24373 Cu7061 (CuNi10)

Dia mm		Art #	5.0kg Ctn	
1.6		RT791650		
2.4		RT792450		
3.2		RT793250		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
10.2Ni, 0.5Fe, Cu Bal	1120	300	80	

#### SIFALLOY No75

One of the most widely used titanium alloys. Its high strength, ability to be heat treated, weldability, excellent fatigue strength and hardness make this alloy excellent for a wide range of applications.

AMS 4954, AWS A5. 16 ERTI-5

Dia mm	Art #	2.5kg Ctn		
1.6	RT751625			
2.4	RT752425			
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.5C, 5.8Al, Ti Bal	1668	890	334	

#### SIFSTEEL HF6

Hard surfacing rod for metal to metal wear, such as wire guides, high speed steel, die and tool steel.

Dia mm	Art #	12 rod/ Pkt	Art #	1.0kg Pkt
1.6	ROHF61612		ROHF61601	
2.4	ROHF62412		ROHF62401	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
1 C, 0.5 Si, 0.3Mn, 4Cr, 8Mo, 2V, 1.5W	n/a	n/a	60 HRC	

### Aluminium AL

#### SIFALUMIN No 14

A pure aluminium (99.5% min) shaved rod which produces a ductile weld equal in strength to that of the base metal. The weld is capable of being hammered, stretched and drawn into shape without fracture.

EN ISO 18273 - S AL 1070 (Al99.7),

BS: 2901 1050A, (GIB) (NG3)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO141601		RO141625	
2.4	RO142401		RO142425	
3.2	RO143201		RO143225	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	105	35	126

**SIFALUMIN No 15**

An Aluminium alloy with 5% silicon giving excellent flow characteristics and penetration. Suitable for welding duralumin, cast (LM25) and wrought alloys 6063 (H9), 6061 (H20) and 6082 (H30). Weld will discolour if anodised.

EN ISO 18273 S AL 4043A (AISi5), BS: 2901 4043A, (NG21)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO151601		RO151625	★
2.4	RO152401		RO152425	★
3.2	RO153201		RO153225	★
5.0			RO155025	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
5 Si, Bal Al	635	120	40	126

**SIFALUMIN No 16**

Aluminium rod containing 12% silicon. It has good mechanical properties, excellent corrosion resistance. Suitable for silicon bearing cast aluminium alloys and wrought alloys. do not use if fabrication is to be anodised.

EN ISO 18273 S AL 4047A (AISi12), BS: 2901 4047A, (NG2)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO161601		RO161625	★
2.4	RO162401		RO162425	★
3.2	RO163201		RO163225	★
5.0			RO165025	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
12 Si, Bal Al, 0.3Mn	585	150	50	126

**SIFALUMIN No 27**

A general purpose aluminium rod containing 5% magnesium that has excellent corrosion resistance and high strength. Suitable for welding magnesium bearing aluminium alloys such as 5251 (N4), 5154 (N5), 5454 (N51) and also heat treatable alloys 6063 (H9), 6061 (H20) and 6082 (H30).

EN ISO 18273 S AL 5356 (AlMg5), BS: 2901 5356, (NG6)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO271601		RO271625	★
2.4	RO272401		RO272425	★
3.2	RO273201		RO273225	★
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
5 Mg, Bal Al	640	250	60	126

**SIFALUMIN No 28**

Special aluminium alloy containing 5% Magnesium and 0.75% Manganese, for improved weld strength.

EN ISO 18273 S AL 5183 (AlMg4.5Mn0.7), BS: 2901 5183

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO281601		RO281625	
2.4	RO282401		RO282425	
3.2	RO283201		RO283225	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
5 Mg, 0.75 Mn, Bal Al	640	275	65	126

**SIFALUMIN No 37**

Aluminium alloy containing 5.3% Magnesium: all elements are closely controlled for optimum weld strength. Normally used on 5083 (N8) and for military applications.

EN ISO 18273 S AL 5556A (AlMg5Mn), BS: 2901 5556

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO371601		RO371625	★
2.4	RO372401		RO372425	★
3.2	RO373201		RO373225	★
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
5.3Mg, 0.8Mn, 0.1Cr, 0.1Ti, Bal Al	640	300	70	126

**SIF MAGNESIUM No 23**

Magnesium rod with 6% Aluminium suitable for welding magnesium aluminium alloy castings of similar composition, crankcases, gearboxes, sumps, wheels etc.

AZ61A

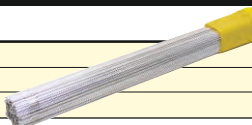
Dia mm	Art #	12 rod/ Pkt	Art #	1kg Pkt
3.0	RO233212		RO233201	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
6 Al, 0.6 Zn, 0.3Mn, Bal Mg	610	280	N/A	

**Copper & TIG Brazing** CU**SIFSILCOPPER No 7 HQ**

Refined especially for TIG applications, with an improved surface finish, No7 HQ is an easy-flowing, porosity-free rod for deoxidised copper. Suitable for copper tanks, pipe, sheet and bar. For standard No7 (for oxy/fuel) see page 120.

EN ISO 24373 Cu 1897 (CuAg1) BS 1453 C1

Dia mm		Art #	5.0kg Ctn	
1.6		RO071650HQ		
2.4		RO072450HQ		
3.2		RO073250HQ		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
1 Ag, Bal Cu	1060	200	75	132



**SIFPHOSPHOR BRONZE No 8**

The phosphor bronze rod contains 7% tin and is suitable for fusion welding of phosphor bronze castings and copper alloys (brass). It is also used for TIG brazing on ferrous and dissimilar metals.

ISO 24373 Cu 5180A (CuSn6P),  
BS: 2901 C11

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.2	RO081201		RO081225		RO081250	
1.6	RO081601		RO081625		RO081650	
2.4	RO082401		RO082425		RO082450	
3.2	RO083201		RO083225		RO083250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
7 Sn, Bal Cu		900-1050	260	80	129	

**SIFPHOSPHOR BRONZE No 82**

Phosphor bronze rod with 12% Tin, for improved colour match on brass and bronze.

ISO 24373 Cu 5410 (CuSn12P),  
BS: 2901 C27

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO821601		RO821625		RO821650	
2.4	RO822401		RO822425		RO822450	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
12 Sn, 0.2 P, Bal Cu		850-1000	320	120	132	

**SIFALBRONZE No 32**

This is a 90/10 aluminium bronze rod suitable for welding materials of a similar composition. It is used for surfacing and dissimilar metal joints, also TIG brazing on ferrous and dissimilar metals.

ISO 24373 Cu 6180 (CuAl10Fe),  
BS: 2901 C.13

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO321601		RO321625		RO321650	
2.4	RO322401		RO322425		RO322450	
3.2	RO323201		RO323225		RO323250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
10 Al, 1 Fe, Bal Cu		1030	500	95	129	

**SIFALBRONZE No 44**

Nickel aluminium bronze for Ab2 material and marine/corrosive applications.

ISO 24373 Cu 6328 (CuAl9Ni5Fe3Mn2),  
BS: 2901 C20/C26

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
2.4	RO442401		RO442425		RO442450	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
83 Cu, 9 Al, 3 Fe, 4 Ni, 1 Mn		1050	700	290		

**SIFSILCOPPER No 968**

A copper rod, containing 3% silicon and 1% manganese used for fusion welding materials of similar composition, copper alloys (brass) and for TIG brazing steels. It is also suitable for surfacing steel and dissimilar metal applications.

ISO 24373 Cu 6560 (CuSi3Mn1),  
BS: 2901 C9

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.2	RO961201		RO961225		RO961250 ★	
1.6	RO961601		RO961625		RO961650 ★	
2.4	RO962401		RO962425		RO962450 ★	
3.2	RO963201		RO963225		RO963250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
1 Mn, 3 Si, Bal Cu		980-120	350	90	129	

**SIFSILCOPPER No 985**

High quality rod containing a minimum of 98.5% copper with deoxidizing elements. It is ideal for TIG welding of copper.

ISO 24373 Cu 1898 (CuSn1)  
BS: 2901 C7

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.2	RO981201		RO981225		RO981250	
1.6	RO981601		RO981625		RO981650	
2.4	RO982401		RO982425		RO982450	
3.2	RO983201		RO983225		RO983250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.25 Mn, 0.25 Si, Bal Cu		1025	220	70	132	

**Stainless SS**
**SIFSTEEL STAINLESS 347**

Stainless steel filler rod, niobium stabilised to prevent weld decay, giving excellent corrosion resistance. Suitable for use on 18/8 type stainless steel, Nb and Ti stabilised, such as 304, 321 and where the weld is subjected to temperatures above 400°C

EN ISO 14343: 19 9 Nb,  
BS: 2901 347S96

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.0	RO201001		RO201025		RO201050	
1.2	RO201201		RO201225		RO201250	
1.6	RO201601		RO201625		RO201650	
2.4	RO202401		RO202425		RO202450	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.04 C, 0.4 Si, 1.5 Mn, 10 Ni, 20 Cr 0.6 Nb		1440	650	180	133	

**SIFSTEEL STAINLESS 308L**

Stainless steel filler rod suitable for welding 18/8 (304) austenitic stainless steels, providing good corrosion and wear resistance.

EN ISO 14343: 19 9 L  
BS: 2901 308S92

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO331601		RO331625		RO331650	★
2.4	RO332401		RO332425		RO332450	★
3.2	RO333201		RO333225		RO333250	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.02 C, 0.4 Si, 1.5 Mn, 10 Ni, 21 Cr		1440	650	180	133	

**SIFSTEEL STAINLESS 316L**

A molybdenum bearing, stainless steel filler rod with low carbon content. It is corrosion resistant for welding molybdenum bearing austenitic stainless steels.

EN ISO 14343: 19 12 3 L  
BS: 2901 316S92

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
0.8	RO210801		RO210825			
1.0	RO211001		RO211025		RO211050	★
1.2	RO211201		RO211225		RO211250	★
1.6	RO211601		RO211625		RO211650	★
2.4	RO212401		RO212425		RO212450	★
3.2	RO213201		RO213225		RO213250	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.02 C, 0.4 Si, 1.5 Mn, 12 Ni, 19 Cr, 2 Mo		1440	650	180	133	

**SIFSTEEL STAINLESS 310**

A solid corrosion-resistant, chromium-nickel rod for TIG welding heat-resistant austenitic steels with high 25% cr / 20% Ni contents. Offers good general oxidation resistance - especially at high temperatures - and is therefore common in industrial furnaces and heat exchangers. Fully austenitic therefore sensitive to hot cracking.

EN ISO 14343: G 25 20  
AWS A5.9 ER310

Dia mm	Art #	2.5kgCtn		
1.2	RT701225			
1.6	RT701625			
2.4	RT702425			
3.2	RT703225			
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 1.8Mn, 26Cr, 21Ni	1440	590	200	

**SIFSTEEL STAINLESS 309LSI**

This stainless rod contains higher chromium and nickel. It can be used for joining material of similar composition and also dissimilar stainless steels.

EN ISO 14343: 23 12 LSi  
BS: 2901 309S93

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO341601		RO341625		RO341650	★
2.4	RO342401		RO342425		RO342450	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.02 C, 0.7 Si, 1.8 Mn, 13 Ni, 23 Cr		1440	650	180	133	

**SIFSTEEL STAINLESS 312**

This is a 29.9 stainless TIG filler rod, suitable for difficult-to-weld steels (Mn steels, tool and spring steels), also dissimilar materials. High resistance to weld metal cracking.

EN ISO 14343: 29 9  
BS: 2901 312S94

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.0	RO351001		RO351025		RO351050	
1.2	RO351201		RO351225		RO351250	
1.6	RO351601		RO351625		RO351650	
2.4	RO352401		RO352425		RO352450	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.1 C, 0.4 Si, 1.7 Mn, 9 Ni, 30 Cr, 0.1 Mo		1440	750	200	133	

**SIFSTEEL STAINLESS DUPLEX**

A 2209 duplex wire for welding austenitic-ferritic stainless alloys providing intergranular, pitting and stress corrosion resistance.

EN ISO 14343-A 22 9 3 N L  
AWS A5.9 ER2209

Dia mm		Art #	5.0kgCtn	
1.6		RT741650		
2.4		RT742450		
3.2		RT743250		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
1.7Mn. 22.5Cr. 8.5Ni. 3.3Mo		765	240	

**SIFSTEEL STAINLESS SUPER DUPLEX**

A 2594 super duplex rod for welding austenitic-ferritic stainless alloys where a high corrosion resistance is required.

EN ISO 14343-A 25 9 4 N L  
AWS A5.9 ER2594

Dia mm		Art #	5.0kgCtn	
1.6		RT781650		
2.4		RT782450		
3.2		RT783250		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.4Mn, 25.0Cr, 9.8Ni, 4.0Mo		850	250	

### Steel **STL**

#### SIFSTEEL A15

A copper-coated triple deoxidised mild steel rod. Used with the TIG process it enables sound porosity free welds to be made on mild and low-alloy steels. Typical applications include pipe welding and root runs on heavy vessels.

EN ISO 636-A : 2008 W2Ti  
BS: 2901 A15, AWS ER70S-2  
EN 1668: W2Ti

Dia mm	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.0	RA151025		RA151050	
1.2	RA151225		RA151250	
1.6	RA151625		RA151650 ★	
2.4	RA152425		RA152450 ★	
3.2	RA153225		RA153250 ★	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 0.6Si, 1.3Mn, 0.2Al	1450	440	120	134

#### SIFSTEEL A17

Low carbon, double deoxidised rod for TIG welding mild steel.

BS: 2901 A17

Dia mm			Art #	5.0kg Ctn
1.6			RA171650	
2.4			RA172450	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 0.3 Si, 1 Mn	1450	400	120	134

#### SIFSTEEL A18

copper coated deoxidised steel rod for TIG welding of mild steel.



EN ISO 636-A W3Si1  
BS: 2901 A18  
AWS: ER70S-6

Dia mm	Art #	5.0kg Ctn		
1.0	RA181050			
1.2	RA181250			
1.6	RA181650	★		
2.4	RA182450	★		
3.2	RA183250	★		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 1 Si, 1.3 Mn	1450	400	120	134

#### SIFSTEEL A31

A copper-coated alloy steel rod containing 0.5% molybdenum. Suitable for use on low temperature pressure vessel and pipe work applications.

EN ISO 14341-A G4Mo,  
BS: 2901 A31, AWS: ER 80S-D2

Dia mm		Art #		5.0kg Ctn	
1.6		RA311650			
2.4		RA312450			
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C, 0.7 Si, 1.8 Mn, 0.5 Mo		1450	460	180	134

#### SIFSTEEL A32

A copper coated alloy steel rod containing 1.0% chromium, 0.5% molybdenum. Ideal for creep resistant steels of a similar composition.

EN ISO 21952-A - W Z CrMo1Si  
BS: 2901 A32, AWS ER80S-B2

Dia mm	Art #	5.0kg Ctn		
1.0	RA321050			
1.2	RA321250			
1.6	RA321650			
2.4	RA322450			
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 1.3 Cr, 0.5 Mo	1450	500	180	134

#### SIFSTEEL A33

A copper-coated alloy steel rod containing 2.5% chromium, 1.0% Molybdenum. It is suitable for high temperature and pressure applications on materials of similar composition.

EN ISO 21952-A - W Z CrMo2Si (2C1M)  
BS: 2901 A32, AWS ER80S-B2

Dia mm		Art #	5.0kg Ctn	
1.6		RA331650		
2.4		RA332450		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 2.4 Cr, 1 Mo	1450	525	200	134

#### SIFSTEEL Ni2

A fine-grained low-alloy TIG rod with 2% Nickel for applications such as pipeline and offshore platform construction, where good fracture-toughness is required at low temperatures (eg -60°C).

EN ISO 636-A W2Ni2,  
AWS A5.28 ER80S-Ni2

Dia mm		Art #	5.0kg Ctn	
1.6		RT721650		
2.4		RT722450		
3.2		RT723250		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 2.1Ni, 1.0Mn		620		



## Copper/Phosphorous & Silver Solder Cu

### SIFCUPRON No 17

This copper phosphorus alloy rod is self-fluxing on copper. Its good electrical conductivity and corrosion resistance make it ideal for copper tubing, switchgear, motors etc.

EN ISO 17672 CUP 182

EN 1044: CP201, BS: 1845 CP3

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.5	RO171501		RO171525	★	RO171550	★
2.4	RO172401		RO172425	★	RO172450	★
3.2	RO173201		RO173225	★	RO173250	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
7 P, Bal Cu		705-800	500	200	130	

### SIFCUPRON No 17-2Ag

A copper phosphorus alloy with the addition of 2% silver to improve ductility and flowing characteristics. Highly resistant to corrosion and not subject to dezincification. It is ideal for hot water cylinders, electric motors and also general maintenance work.

EN ISO 17672 CUP 279

EN 1044: CP105, BS: 1845 CP2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO181601		RO181625	★	RO181650	★
2.4	RO182401		RO182425	★	RO182450	★
3.2	RO183201		RO183225	★	RO183250	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
2 Ag, 6 P, Bal Cu		645-740	430	195	130	

### SIFCUPRON No 17-5Ag

Copper/Phosphorus alloy with 5% silver, having ductility and capillary flow characteristics between 17-2 Ag and 17-15 Ag.

EN ISO 17672 CUP 281

EN 1044: CP102, BS: 1845 CP4

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.5	RO1815015Ag		RO1815255Ag		RO1815505Ag	
2.5	RO1825015Ag		RO1825255Ag		RO1825505Ag	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
5 Ag, 6 P, Bal Cu		645-730	600	190	130	

### SIFCUPRON No 17-15Ag

Copper/Phosphorus alloy with 15% silver for stressed applications. Ideal for poor fitting joints.

EN ISO 17672 CuP 284

EN 1044: CP102, BS: 1845 CP1

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt		
1.5			RO181506			
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
15 Ag, 5 P, Bal Cu		645-700	640	185	130	

### SIF SILVER SOLDER No 39

CADMIUM FREE Silver Solder suitable for use on all ferrous and non-ferrous metals, except aluminium. It can be used with a range of heat sources. Use SIF SILVER SOLDER flux.

EN ISO 17672 Ag 138

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt	Art #	1kg Pkt
1.5			RO391506		RX391500	
2.0					RX392000	
2.5	RO392504				RX392500	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
38 Ag, 32 Cu, 28 Zn, 2 Sn		650-725	460	140	130	

### SIF SILVER SOLDER No 40

A popular grade of Silver Solder offering good capillary action and ductility in many ferrous and non-ferrous applications. Use with SIF SILVER SOLDER flux.

EN ISO 17672 Ag 140

Dia mm		Art #		1kg Pkt	
1.5		RX401500			
2.5		RX402000			
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
40 Ag, 30 Cu, 28 Zn, 2 Sn		670-710	440	130	130

### SIF SILVER SOLDER No 43

CADMIUM FREE 55% Silver Solder, which is free flowing and ideal for close fitting capillary joints and for colour match on stainless. Use SIF SILVER SOLDER flux.

EN ISO 17672 Ag 155

EN 1044: AG 103, BS: 1845 AG14

Dia mm			Art #	6 rod/Pkt	Art #	1kg Pkt
1.5			RO431506		RX431500	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
55 Ag, 21 Cu, 22 Zn, 2Sn		630-660	415	145	130	

### SIF SILVERCOTE No 43

CADMIUM FREE Silver Solder No.43 with full flux coating.

EN ISO 17672 Ag 155

EN 1044: AG 103, BS: 1845 AG14

Dia mm			Art #	6 rod/Pkt	Art #	1kg Pkt
1.5			RR431506		RR431501	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
55 Ag, 21 Cu, 22 Zn, 2Sn		630-660	415	145	130	

For SIF Silver Solder bulk 1kg; prices available on application.

### General Brazing (Silicon Bronze), Nickel Bronze CU

#### SIFBRONZE No 1

Original multi-purpose Sifbronze low temperature rod for brazing and bronze welding of steels, cast iron, copper and its alloys. Ideally suited for general mild steel work, galvanised steel and dissimilar metal applications. Use SIFBRONZE flux

BS EN ISO 17672: CU470  
EN 1044: CU302,  
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO011601		RO011625	★	RO011650	★
2.4	RO012401		RO012425	★	RO012450	★
3.2	RO013201		RO013225	★	RO013250	★
4.8					RO014850	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	130 & 131	

#### SIFREDICOTE No 1

This rod is Sifbronze No.1 with a full flux coating providing the added benefit of faster, continuous brazing through not having to flux-dip. It is ideally suited for general mild steel work, galvanised steel and dissimilar metal applications.

BS EN ISO 17672: CU470  
EN 1044: CU302,  
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RR011601		RR011625	★		
2.4	RR012401		RR012425	★	RR012450	★
3.2	RR013201		RR013225	★	RR013250	★
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	130	

#### SIF AUTOBRONZE

Free flowing flux impregnated brazing rod, ideal for brazing clean mild steel.

BS EN ISO 17672: CU470  
EN 1044: CU302,  
BS: 1845 CZ6A,  
1453 C2



Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
2.4	RS412401		RS412425		RS412450	
3.2	RS413201		RS413225		RS413250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
60 Cu, 0.3 Sn, 0.3 Si, Bal Zn		875-895	430	120	130	

#### SIFBRONZE No 101

A special brazing rod containing specific additions of Manganese and Tin, giving it free flowing characteristics. It is particularly suitable for use with 'gas flux'.

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.5	RO101501		RO101525		RO101550	
2.0	RO102001		RO102025		RO102050	
2.5	RO102501		RO102525		RO102550	
3.0	RO103001		RO103025		RO103050	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
60 Cu, 0.2 Mn, 0.1 Si, 0.1 Sn, Bal Zn		870-890	460	130	130 & 131	

#### SIFBRONZE No 2

Brazing rod containing 9% nickel, for use on cast iron, copper alloys, stainless and alloy steels. It has excellent wearing properties and high strength making it ideal for tubular structures, brazing cutting tips and as a general maintenance alloy. Use SIFBRONZE or SIF TOOL TIP/BRAZE STAINLESS flux.

EN ISO 17672 Cu773  
EN 1044: CU305,  
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO021601		RO021625		RO021650	
2.4	RO022401		RO022425		RO022450	
3.2	RO023201		RO023225		RO023250	
4.8					RO024850	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
48 Cu, 10 Ni, 0.3 Si, Bal Zn		920-980	540	200	130 & 131	

#### SIFREDICOTE No 2

This rod is Sifbronze No.2 with a full flux coating and with similar characteristics. The UTS is approximately 25% greater than Sifredicote No.1 and is ideal for high strength production and maintenance applications.

EN ISO 17672 Cu773  
EN 1044: CU305,  
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
2.4	RR022401		RR022425		RR022450	
3.2	RR023201		RR023225		RR023250	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
48 Cu, 10 Ni, 0.3 Si, Bal Zn		920-980	540	200	130	

## Aluminium, Cast Iron, Copper, Stainless

AL NI CU

## SIF FLUXCORE ALUMINIUM

Flux cored 5% Silicon Aluminium rod:  
ideal for oxy/acetylene general repair  
work.

Dia mm	Art #	1kg Pkt			
3.0	RO153001F				
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page
5 Si, Bal Al	635	120	40		126

## SIF 555 AL SOLDER

Self fluxing solder for use on  
Aluminium and its alloys. Separate  
instruction sheet available.

Dia mm	Art #	12 rod/Pkt	Art #	1kgCtn	Art #	2.5kgCtn
3.0	RO553212		RO553201		RO553225	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page	
93 Zn, 4 Al, 3 Cu	380	200	100			127

## SIFPHOSPHOR BRONZE No 8

The phosphor bronze rod contains 7%  
tin and is suitable for fusion welding of  
phosphor bronze castings and copper  
alloys (brass). It is also used for TIG  
brazing on ferrous and dissimilar  
metals.

ISO 24373 Cu 5180A (CuSn6P),  
BS: 2901 C11

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.2	RO081201		RO081225		RO081250	
1.6	RO081601		RO081625		RO081650	
2.4	RO082401		RO082425		RO082450	
3.2	RO083201		RO083225		RO083250	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page	
7 Sn, Bal Cu	900-1050	260	80			129

## SIFALUMIN No 16

Aluminium rod containing 12% silicon.  
It has good mechanical properties,  
excellent corrosion resistance.  
Suitable for silicon bearing cast  
aluminium alloys and wrought alloys.  
do not use if fabrication is to be  
anodised.

EN ISO 18273 S AL 4047A (AlSi12),  
BS: 2901 4047A, BS: 1845 (NG2)

Dia mm	Art #	1kg/Pkt	Art #	2.5kgCtn		
1.6	RO161601		RO161625	★		
2.4	RO162401		RO162425	★		
3.2	RO163201		RO163225	★		
5.0			RO165025			
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page	
12 Si, Bal Al, 0.3Mn	585	150	50			127

## SIFSILCOPPER No 7


An easy flowing, high quality copper  
rod for full fusion welding of deoxidised  
copper. Suitable for fabrication and  
repairs to copper pipes, tanks etc. Use  
SIFSILCOPPER flux

EN 14640 Cu 1897 (CuAg1)  
BS: 1453 C1

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO071601		RO071625		RO071650	
2.4	RO072401		RO072425		RO072450	
3.2	RO073201		RO073225		RO073250	
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page	
1 Ag, Bal Cu	1060	200	75			132

## SUPER SILICON No 9

The rod is suitable for full fusion  
welding of cast iron, providing a high  
strength weld metal which is easily  
machinable. It gives an excellent colour  
match and has the same structure as  
grey cast iron. Use SIF CAST IRON  
flux.

Dia mm	Art #	1kg Pkt	Art #	5.0kgCtn	
4.0	RO094001		RO094050		
5.0			RO095050		
6.0			RO096050		
10.0			RO091050		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
3.3 C, 3.0 Si, 0.7 Mn, 0.1 S, 0.5 P		1250	200	180	134

## SIF SUPER SG CAST IRON

The rod is suitable for full fusion  
oxy-acetylene welding of Spheroidal  
Graphite cast iron, providing a  
machinable weld.  
Use SIF CAST IRON flux.

Dia mm	Art #	1kg Pkt	Art #	5.0kgCtn	
6.0	RO296001		RO296050		
10.0			RO291050		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
3.7 C, 2.5 Si, 0.1 Mn		1250	400	190	134

## SIFSTEEL STAINLESS 308L

Stainless steel filler rod suitable for  
welding 18/8 (304) austenitic stainless  
steel. for gas welding use SIF  
STAINLESS flux

EN ISO 14343: 19 9 L,  
BS: 2901 308S92

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kgCtn
1.6	RO331601		RO331625		RO331650	★
2.4	RO332401		RO332425		RO332450	★
3.2	RO333201		RO333225		RO333250	★
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS	Page	
0.02 C, 0.4 Si, 1.5 Mn, 10 Ni, 21 Cr	1440	650	180			133

### Steel

#### SIFSTEEL No 11

A low-carbon mild steel rod ideal for all types of mild steel and wrought iron welding. It is free-flowing and produces a high strength ductile weld. It is copper coated to ensure long shelf life. Particularly suitable for sheet metal panels, plates, tubes and fittings.

EN 12536 01

BS: 1453 A1, EN 12536: 01

Dia mm	Art #	1kg Pkt	Art #	2.5kg Ctn	Art #	5.0kg Ctn
1.6	RO111601		RO111625		RO111650	★
2.4	RO112401		RO112425		RO112450	★
3.2	RO113201		RO113225		RO113250	★
4.8					RO114850	
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page	
0.06 C, 0.4 Mn		1450	350	120	134	

#### SIFSTEEL No 22

A special alloy steel rod containing manganese for toughness. It provides a weld deposit of high strength and ductility. Recommended for oxy/acetylene welding of pipelines and pressure vessels.

EN 12536: 011, BS: 1453 A2

Dia mm		Art #	5.0kg Ctn	
1.6		RO221650		
2.5		RO222550		
3.0		RO223050		
% Metal Composition	Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1 C. 0.1 Si. 1.1 Mn	1450	350	120	134

### Flux powder & GasFlux

#### ALUMINIUM

Powder fluxes for gas welding and brazing aluminium and its alloys.

EN 1045 - FL10

Art #	500g Jar
FO120050	For low-melting point alloys
FO140050	For medium-melting point alloys
FO360050	For higher-melting point alloys

#### CAST IRON

Powder flux for fusion welding cast iron.

EN 1045 - FH20

Art #	500g Jar
FO090050	

#### SIFBRONZE BRAZING

Powder flux for general brazing work.

EN 1045 - FH10

Art #	225g Jar	Art #	500g Jar
FO010022		FO010050	★
FO100050		Frame Builders Flux	★

#### ECO FLUX PASTE

A pre-mixed paste at optimal liquidity free of boric acid and suitable for brazing of mild steel and copper alloys.

EN 1045 - FH10

Art #	350g Jar
FO050035	

#### SIFSILCOPPER

Powder flux for brazing and welding copper alloys.

EN 1045 - FH11

Art #	500g Jar
FO070050	

#### SILVER SOLDER

Powder flux for silver solder operations.

EN 1045 - FH10

Art #	500g Jar
FO380050	★

#### TOOL TIP/BRAZE STAINLESS

Powder flux for Tool Tipping or brazing stainless with Sifbronze No 1 or No 2. Also for oxy/fuel welding of stainless.

EN 1045 - FH12

Art #	500g Jar
FO020050	

#### GASFLUXER - MODEL 69-D

Gas fluxer unit with removeable filling tank.

Art #	SIF TIPS page
FXGF69D	131

#### SIF GASFLUX LIQUID

Specially formulated liquid which allows fuel gas (acetylene) to absorb flux into the torch flame. It is a flammable liquid UN No 1993.

EN 1045 - FH10 £35 hazardous goods freight surcharge applies to all shipments.

Art #	3L container	Qty	SIF TIPS page
FXGF3L		4 containers per ctn	131



## ROD LENGTH

1000mm

Average Qty Rods  
Per Kilo

Diameter mm	1.0	1.2	1.6	2.4	3.2	4.8
Aluminium			200	90	48	20
Brazing & Copper		105	60	28	15	7
Flux Coated			42	25	14	
Stainless & Steel	170	115	65	30	16	7

## ROD LENGTH

500mm

Average Qty Rods  
Per Kilo

Diameter mm	1.5	2.5	4.0	6.0	10.0
Cast Iron			16	7	3
Silver Solder (bare)	119	44			
Sil Sol flux coated	80				

## SIFTRODE MK10 STEEL STL

## SIFTRODE 6013-M

General purpose multi-positional rutile-coated mild steel electrode with stable arc and easy-lifting slag.

EN ISO 2560 E 42 0 RC 1  
AWS A5.1: E 6013



Dia mm	Art #	2.5kg Pkt	Art #	5.0kg Ctn	Pcs/Pkt
2.5	RE652525	★	RE652550	★	265
3.2	RE653225		RE653250	★	170
4.0	RE654025		RE654050	★	115

## SIFTRODE 6013-R

A versatile and general purpose rutile-coated mild steel MMA electrode.

EN ISO 2560-A : E 42 0 RC 11  
AWS A5.1 E 6013

Dia mm	Art #	Pkt Wt	Pcs/Pkt
2.0mm	RE802050	5.0kg	3
2.5mm	RE802550	5.0kg	3
3.2mm	RE803250	5.0kg	3
4.0mm	RE804050	5.0kg	3

## SIFTRODE 6013

General purpose multi-positional rutile-coated mild steel electrode with stable arc and easy-lifting slag.

CE EN13479

EN ISO 2560 E 42 0 RC 11  
AWS A5.1: E 6013

Dia mm	Art #	2.5kg Pkt	Art #	5.0kg Ctn	Pcs/Pkt
1.6	RE601602	★			285
2.5			RE602550	★	265
3.2			RE603250	★	170
4.0			RE604050	★	115

## SIFTRODE 7018-M

basic-coated low-hydrogen electrode with high efficiency and good mechanical properties.

E: 42 4 B 42 HS  
AWS A5.1: E 7018



Dia mm	Art #	1.5kg Vac Pack	Art #	5.0kg Ctn	Pcs/Pkt
2.5			RE752550	★	220
3.2			RE753250	★	140
4.0			RE754050	★	90

## SIFTRODE 7018

basic-coated low-hydrogen electrode with high efficiency and good mechanical properties.

EN ISO 2560 E 42 4 B 42 H5  
AWS A5.1: E 7018



Dia mm	Art #	Art #	5.0kg Ctn	Pcs/Pkt
2.5	RE762501	RE702550	★	220
3.2	RE762501	RE703250	★	140
4.0	RE764001	RE704050	★	90

## SIFTRODE SPEZIAL 7016

Double coated rutile-basic universal electrode. Ideal for use in pipelines and steel construction.

E 7016 E 42 2 B® 12 H10  
AWS A5.1 EN ISO 2560



Dia mm	Art #	1.5kg Ctn	Pcs/Pkt
2.5	RE761501		6
3.2	RE853201		6
4.0	RE854001		6

## SIFTRODE 7024

An iron-powder rutile-coated electrode with about 150% efficiency. For butt & fillet welds on medium to thick plates in shipbuilding and structural steel.

EN ISO 2560-A: E 42 0 RR 54,  
AWS A 5.1: E7024



Dia mm	Art #	5.0kg Ctn
3.2	RE723250	
4.0	RE724050	
5.0	RE725050	



**Stainless SS**
**SIFCHROME 308L**

Rutile coated electrode for welding austenitic stainless steel (304). Suitable for dairy and cold storage applications. Self-releasing slag and an excellent weld appearance.

**EN ISO 3581:E 19 9 LR 32**

**AWS: E308L-17**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
2.5	RC3082540	4.0kg	225 ★		
3.2	RC3083240	4.0kg	120 ★		
4.0	RC3084040	4.0kg	80 ★		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.03C, 0.8 Si, 0.8Mn, 19.8 Cr, 10.2 Ni 0.03P 0.025S		n/a	>550	n/a	133

**SIFCHROME 316L**

Rutile coated electrode for welding molybdenum alloyed 18/12 and similar cr/Ni/Mo steels. High resistance against general and intergranular corrosion. Self-releasing slag and an excellent weld appearance.

**EN ISO 3581:E 19 12 3 LR 12**

**AWS: E316L-17**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
1.5	RC3161540	4.0kg	705 ★		
2.0	RC3162040	4.0kg	350 ★		
2.5	RC3162540	4.0kg	225 ★		
3.2	RC3163240	4.0kg	110 ★		
4.0	RC3164040	4.0kg	80 ★		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.03C, 0.86 Si, 0.8Mn, 18.8 Cr, 11.7 Ni 2.7Mo, 0.03P 0.025S		n/a	>550	n/a	133

**SIFCHROME 316L CRYO**

A 316L grade low carbon stainless steel electrode suitable for use in applications where the mechanical requirements are tough. It provides good impact toughness at low temperatures and 100% recovery. Re-dry at 200°C for 2 hours.

**EN ISO 3581:E 19 12 3 LB 22**

**AWS: A5.4 E316L-15**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
2.5	RC3162540CRYO	4.0kg	225 ★		
3.2	RC3163240CRYO	4.0kg	110 ★		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.03C, 0.8 Si, 1.7Mn, 18.5Cr, 12 Ni, 2.7Mo 0.3Cu 0.5 Si		n/a	>550	n/a	133

**SIFCHROME 312**

Rutile coated high cr/Ni electrode for welding of difficult-to-weld steels like armour plate, austenitic Mn steel, high carbon steel and cr/Ni steels. Self-releasing slag and an excellent weld appearance.

**EN ISO 3581:E 29 9 R 32**

**AWS: E312-17**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
2.5	RC3122540	4.0kg	225		
3.2	RC3123240	4.0kg	120		
4.0	RC3124040	4.0kg	80		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.1C, 1.2Si, 0.7Mn, 28.5Cr, 9.5Ni, 0.025P, 0.02S		n/a	>800	n/a	133

**SIFCHROME 309L**

A Rutile coated electrode for welding corrosion resistant and heat resistant CrNi steels, joining dissimilar metals and buffering. Suitable for clad steels and ensures good cracking resistance.

**EN ISO 3581-A: E 23 12 L R 12**

**AWS: E309L-16**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
2.5	RC3092540	4.0kg	225		
3.2	RC3093240	4.0kg	120		
4.0	RC3094040	4.0kg	80		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.02C, 0.7Si, 0.8Mn, 23.2Cr, 12.5Ni, 0.030P, 0.030S		n/a	>550	n/a	133

**SIFCHROME 307**

A Rutile basic-coated electrode for joining dissimilar steels and difficult-to-weld steels. Recommended for buffer layers prior to surfacing. Excellent weld appearance and durability.

**EN ISO 3581-A: E 18 8 Mn Mo R 12**

**AWS: E307-17**

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/Pkt	
2.5	RC3072540	4.0kg	225		
3.2	RC3073240	4.0kg	120		
4.0	RC3074040	4.0kg	80		
% Metal Composition		Melting°C	U.T.S. N/mm <sup>2</sup>	Hardness BHN	SIF TIPS Page
0.10C, 0.7Si, 6.50Mn, 18.8Cr, 8.80Ni, 0.030P, 0.030S		n/a	>650	n/a	133

SIFTRODE Electrodes

STLNI CUALSS

SIFTRODE 6013-R

A versatile and general purpose rutile-coated mild steel MMA electrode.

EN ISO 2560-A : E 42 0 RC 11  
AWS A5.1 E 6013

Dia mm	Art #	Pkt Wt	Pcs/Pkt
2.0mm	RE802050	5.0kg	3
2.5mm	RE802550	5.0kg	3
3.2mm	RE803250	5.0kg	3
4.0mm	RE804050	5.0kg	3

SIFTRODE 7018-VP

Basic coated, low hydrogen electrode with recovery about 120%, excellent welding characteristics.

EN ISO 2560-A: E 42 4 B 31 H5  
AWS A5.1 E7018

EN ISO 2560-A: E 42 4 B 31 H5

Dia mm	Art #	Pkt Wt	Pcs/Pkt
2.5mm	RE762501	1.5kg	6
3.2mm	RE763201	1.5kg	6
4.0mm	RE764001	1.5kg	6

SIFTRODE 6010

A vac-packed cellulosic electrode for pipe welding, performing well in all positions, especially vertical down.

EN 499 E 42 3 C 25,  
AWS A5.1 E 6010

Dia mm	Art #	5.0kg Tin
2.5	RE612550V	
3.2	RE613250V	
4.0	RE614050V	

SIFTRODE CAST NiFe

Cast iron electrode with NiFe bimetal core wire. EN ISO 1071-A  
AWS A5.15 E C Ni-CI

Dia mm	Art #	Pkt Wt	Pcs/Pkt
2.5mm	RE4002501	1.0kg	8
3.2mm	RE4003201	1.0kg	8
4.0mm	RE4004001	1.0kg	8

SIFTRODE CAST Ni

Cast iron electrode with Ni pure core wire. Dedicated for cold welding grey and malleable cast iron. EN ISO 1071-A

AWS A5.15 E C Ni-CI

Dia mm	Art #	Pkt Wt	Pcs/Pkt
2.5mm	RE5002501	1.0kg	8
3.2mm	RE5003201	1.0kg	8
4.0mm	RE5004001	1.0kg	8

SIFTRODE ALU Si12

Electrode for rapidly joining cast aluminium alloys. AWS A5.3 E 4047

Dia mm	Art #	Pkt Wt	Pcs/Pkt
3.2mm	RE1003201	1.0kg	8

SIFTRODE BRONZE

CuSn

Basic coated tin bronze electrode.

E CuSn-A E CuSn-7

AWS A5.6 DIN 1733

Dia mm	Art #	Pkt Wt	Pcs/Pkt
3.2mm	RE3003201	1.0kg	8

SIFTRODE HF-600

Hardfacing general purpose electrode providing 57 – 62 HRC hardness. EN ISO 14700-A E Fe8  
DIN 8555 E 6-UM-60

Dia mm	Art #	Pkt Wt	Pcs/Pkt
3.2mm	RE6003250	5.0kg	3
4.0mm	RE6004050	5.0kg	3
5.0mm	RE6005050	5.0kg	3

SIFTRODE CUT

Electrode for cutting and gouging.

Dia mm	Art #	Pkt Wt	Pcs/Pkt
3.2mm	RE903250	5.0kg	3
4.0mm	RE904050	5.0kg	3

## SifLITE® & Sif ecoLITE

The Sif LITE variable shade, auto-darkening welding helmet features adjustable sensitivity and variable delay (0.1s - 0.9s). Sif LITE is a high quality, low cost ADF welding lens and helmet solution with comfortable headgear. Sif LITE is CE approved and meets EN379, EN175 and ANSI Z87.1.



A fixed shade 10 Sif ecoLITE ADF is also available and ideal for MIG, Arc and TIG applications.

Art #	Product
FXADF913	Sif LITE 9-13 ADF Helmet
FXADF310	Sif ecoLITE 3/10 ADF Helmet
ES288420	Outer Lens
EH228000	Inner Lens

## CeraMIGuard Dry-Film Spray

INNOVATION

A protective ceramic spray specifically designed to prolong tip and shroud life in industrial MIG fabrication. It can also be applied to jigs, fixtures & cables to protect them from spatter adhesion. 400ml



Art #	Product
EG5001	CeraMIGuard Dry-Film Spray

## Digital Thermometer 850°C

INNOVATION

A digital thermometer with laser targeting and temperature detection via infrared, operated via trigger control. Ideal for pre-heating, interpass-temperature measurement and controlled-cooling tasks. Can be used on practically all solid surfaces and is battery-operated, with an LCD screen. Includes K-type probe.



Art #	Product
TTFX850C	Sif Temp IR Thermometer

## SifLITE®Revenge

The SifLite Revenge is a solar powered auto-darkening welding helmet with adjustable sensitivity and delay, which helps protect the users eyes and face from the welding arc, spatter and infrared / ultraviolet radiation. A high-quality, affordable ADF welding lens and comfortable helmet solution with variable shade, large viewing area and 12 month warranty. Available in 3 striking colour options: Red and Gold, Yellow and Black and Blue and Silver



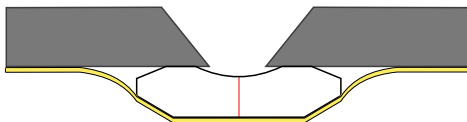
Art #	Product
FXADF700A	SifLITE Revenge - Style A (red)
FXADF700B	SifLITE Revenge - Style B (blue)
FXADF700C	SifLITE Revenge - Style C (yellow)

## SifCeramibac®

# Sif CeramiBac®

Our new and improved ceramic backing range, which consists of ceramic backing tiles based on a strong self-adhesive aluminium backing tape, therefore allowing easy application to the welding area.

Ceramic backing protects the backside of the weld from the atmosphere, which minimises oxidation of the weld bead. Available in various sizes.



Art #	Product
PV290806100SF	Rounded Groove
PV290806152SF	Square Groove
PV290806715SF	1/8" Segmented Circle
PV290806307SF	Round 6mm Diameter
PV290806310SF	Round 9mm Diameter
PV290806312SF	Round 12mm Diameter



# SIFDRY

# sif

## SifDRY®

Professional equipment for transporting, dispensing and storing your stick welding rods in warm, dry conditions prior to welding.

Drying ovens help reduce your amount of electrode wastage, as well as ensure optimum performance to electrodes that have been moisture compromised. A wise tool to have available, especially when moisture pick-up in your manual arc electrodes is a concern.

### Sif Rod Cannister

A durable plastic airtight cannister providing great storage and safe transportation of your welding electrodes. Standard 14in (for 350mm electrodes).



Art #	Product
RG100SIF	14in Sif Rod Cannister

### Portable Drying Oven

Lightweight, durable and completely portable, easy to load, easy to carry, ready to provide low cost control of welding quality in the workshop or on site. This portable drying oven can help reduce operating costs by providing operators with fast access to electrodes at the point of application.

Features a 400watt heater which is thermostatically controlled to warm the rods between 60°C and 300°C. Versions are available which use a 230v or 110v supply. Weighs only 8kg with a rod lifter which can hold 2 packs of 5kg electrodes.



Art #	Product
ZAB200110	110v Portable Drying Oven
ZAB200230	230v Portable Drying Oven

### Electrode Quiver

This model has a 200watt (approx) heater which is thermostatically controlled to warm the rods between 80°C and 130°C and improve their welding performance. An indicator light will show when heating is in operation.

Capable of comfortably holding a full pack of 5kg electrodes. The carry handle will serve as a stand for the quiver to rest on.

Versions are available which use a 230v or 110v supply; the quiver is easy to load, easy to carry and is ideal for on-site use. Weighs only 5kg with a height of 50cm



Art #	Product
ZAB300110	110v Quiver
ZAB300230	230v Quiver

### Stationary Drying Oven

Our most industrial drying oven for the storage and heating of welding rods. The stationary drying oven has the capacity to hold up to 20 packs of 5kg electrodes.

The heavy-duty construction includes a durable powder-coated steel exterior, radial formed perforated shelving aiding heat convection, reinforced door, latches and handle with pockets at the base of the oven for easy transport by forklift.

Operating power of 4500 Watts. Max temperature of 400°C.

Uses a 415v supply.



Art #	Product
ZAB000415	415v Stationary Drying Oven

### SifWeld® TS 200 AC/DC Inverter Welder

A professional, microprocessor-controlled inverter welding power-source for AC TIG, DC TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich.

High Frequency ignition and a pulse function on both AC and DC mode make this machine ideal for sheet metal and fine precision work. The TS 200 AC incorporates a user-friendly LCD control panel for logical operation. It suitable for AC MMA, DC+ MMA, DC- MMA, DC TIG & AC TIG welding.

**Suitable for:**

- Aluminium
- Sheet Metal Work, Inc. Pipe/Tube
- Stainless Steel Fabrication
- Process Engineering
- Repair & Maintenance
- General Fabrication



Art #	Product
TSX1T200ACPKG	SifWeld TS200 AC/DC TIG Package
TWX1T200KIT	TIG Torch, Reg & Clamp Kit
AU200	Flowmeter 0-15 LPN
DZ10012	MIG/Inverter Trolley
TWX1COOL230	230v 1ph Water Cooler



Optional trolley

### SifWeld® TS 200 DC Inverter Welder

A professional, microprocessor-controlled inverter welding power-source for TIG & MMA applications. The use of IGBT technology providing a compact and lightweight machine that is feature rich.

High Frequency ignition and a pulse function make this machine ideal for sheet metal and fine precision work. The TS 200 DC incorporates a user-friendly control panel with logical layout for operation in MMA or TIG modes. It suitable for DC+ MMA, DC- MMA & DC TIG welding.

**Suitable for:**

- Sheet Metal Work
- Stainless Steel Fabrication
- Process Engineering
- Repair & Maintenance
- General Fabrication



Art #	Product
TSX1T200DC	SifWeld TS200 DC Power Source
TWX1T200KIT	TIG Torch, Reg & Clamp Kit
AU200	Flowmeter 0-15 LPN
DZ10012	MIG/Inverter Trolley



Optional trolley



## SifWeld® ST180

NEW  
PRODUCT

A professional, microprocessor-controlled inverter welding power-source for MMA & TIG applications. The use of IGBT technology delivers a compact and lightweight professional welding machine for all types of welding electrode including cellulosic. The ST180 Pro incorporates a user-friendly control panel with logical layout for operation in MMA or TIG modes. It is suitable for DC+ MMA, DC-MMA & DC TIG welding. Target applications include general fabrication, sheet metal work, precision pipe work, stainless steel fabrication, process engineering and repair maintenance.



Art #	Product
TSX1ST180	SifWeld TS180 Pro package
DZ10012	Inverter trolley

## SifWeld® Cut 40 Plasma Cutter

NEW  
PRODUCT

The SifWeld Cut40 Digital is a professional 40Amp plasma cutting system designed for hand-held efficient cutting, manufacturing, sheet metal, general maintenance industries and automotive. Featuring IGBT inverter technology, the SifWeld Cut40 Digital plasma cutter is engineered to consistently deliver heavy-duty cutting performance. This is ideal to cut up to 12mm thick steel.



Art #	Product
TSX1P40	Cut40 Digital Package
TSX1P4003	Cut40 Digital 4m torch
SWPD116-08	Tip
SWPR110	Electrode
SWPC116	Shield Cup
SWPE106	Air diffuser
TSX1P4004	Earth return
TSX1P4005	Hi-flow air connector

## SifWeld® Cut 100 Plasma Cutter

The SifWeld Cut100 is a professional 100Amp 3ph plasma cutting system designed for hand-held efficient cutting in the heavy fabrication, manufacturing, demolition and general maintenance industries. Featuring IGBT inverter technology, the SifWeld Cut100 plasma cutter is engineered to consistently deliver heavy-duty cutting performance. This is ideal to cut up to 30mm thick steel. The SifWeld Cut100 can be used to efficiently cut mild and low-alloy steels, stainless, aluminium, copper, titanium and nickel alloys.

Art #	Product
TSX3P100	Cut100 Package
TSX3PTA101	Cut40 Digital 4m torch
SWPD101-11	Cutting Tip 1.1mm
SWPD101-14	Cutting Tip 1.4mm
SWPD101-17	Cutting Tip 1.7mm
SWPR101	Electrode
SWPC109	Nozzle
SWPE101	Air Diffuser
SWCV11	Stand-off Spring
TSX3D400MTSTR	SifWeld MTS Trolley





110v 1ph

230v 1ph  
16A/32A400v  
1ph/3ph**SIFWELD****sif****SifWeld® MTS 200 Multi-Process Inverter Welder**

A professional, microprocessor-controlled inverter welding power-source for MIG, MMA & Lift-TIG applications, featuring IGBT technology and providing a lightweight, multi-process machine. An integral wire feed system accommodates D-200 (5kg) wire spools.

The MTS 200 is designed to be user-friendly and easy to operate, with simple menu control to select MIG, MMA or TIG modes. The smooth DC output is ideal for MIG welding of steel, stainless steel, aluminium & copper alloys.

For MIG applications a standard Euro fitting torch can be used and can also be used with a spool-on gun for difficult to reach applications. It can also suitable for DC MMA welding (DC+ & DC-) and lift-start TIG welding.



Art #	Product
TSX1D200MTSPKG	SifWeld MTS 200 Inverter Package
FXMT2003	SifGun MIG Torch 200 amp 3m
TSX1D200SOG	SifGun Spool-On MIG Torch
TSX1D200TIG	TIG Welding Torch Kit - 4m
C500301	Stick Welding Lead - 3m

**SifWeld® MTS 250 Multi-Process Inverter Welder**

The SifWeld MTS 250 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and integral 4-roll wire feed system which accommodates up to 15kg D300 wire spools. The SifWeld MTS 250 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyards tasks.

This unit can be used to weld mild steel, low-alloy, stainless and aluminium in solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG welding.

The SifWeld MTS 250 control system allows infinitely-variable welding voltage and wire feed speed, burnback control & wire inching in MIG mode. The power source also benefits from 4T/2T torch-latching & spool gun selection.



Art #	Product
TSX1D250MTSPKG	SifWeld MTS 250 Package
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package
TSX1D250SOG	SifGun Spool-On MIG Torch



## SifWeld® MTS 300 Industrial Multi-Process Inverter

The SifWeld MTS 300 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and 5m standard interconnecting cables, along with an external 4-roll wire feed system which accommodates up to 15kg D300 wire spools.

The SifWeld MTS 300 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyard tasks.

This unit can be used to weld mild steel, low-alloy, stainless and aluminium in solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG welding.

Art #	Product
TSX1D300MTSPKG5	SifWeld MTS 300 Package
TSX3D400MTSWFU	SifWeld MTS Wire Feed Unit
TSX3D400MTSIC5	SifWeld MTS 5m IC Cable
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package



## SifWeld® MTS 400 Industrial Multi-Process Inverter

The SifWeld MS 400 is an electronically controlled MIG/MAG/MMA industrial welding package featuring IGBT inverter technology. With clear digital displays, low-spatter, polarity reversal (for FCAW) and 5m standard interconnecting cables, along with an external 4-roll wire feed system which accommodates up to 15kg D300 wire spools.

The SifWeld MS 400 is designed for use in heavy-duty fabrication applications such as structural steel and marine/shipyard tasks.

This unit can be used to weld mild steel, low-alloy, stainless and aluminium in solid and flux-cored MIG applications. It can also be used for DC MMA welding (DC+/DC-) and scratch-start TIG welding.

Art #	Product
TSX3D400MTSPKG5	SifWeld MTS 400 Package
TSX3D400MTSWFU	SifWeld MTS Wire Feed Unit
TSX3D400MTSIC5	SifWeld MTS 5m IC Cable
TSX3D400MTSTR	SifWeld MTS Trolley
FXMT3003	SifGun MIG 300 3m
TSX3DMTSTIG	SifWeld MTS TIG Torch Package



### Sif IOI Brazing Flux

Sif 101 brazing flux power is manufactured from an original Sif formula and is especially effective for Chrome-molly tube, steel, stainless steel, brazing bronze, brass, copper malleable iron and heat-resistant alloys. It aids deep penetration of filler brazing allow into the joints, resulting in high bond-strength. The flux dissolves to remove oxides rapidly. Sif 101 flux is engineered for frame builders and tube-brazing applications.



Art #	Product
FO100050	Sif 101 Brazing Flux 500g

### Sif Purging Flux

**INNOVATION**

A flux used in TIG applications to shield the rear of a weld joint from oxygen contamination, dissipate heat and oxides during welding and prevent re-oxidation. Formulated to suit stainless steel and high nickel super alloys. To apply, mix flux with methanol & brush over rear of joint. Sif Purging flux is inert, non-flammable and non-explosive. Ideal for pipe and tube welding applications. Supplied in 500g jar.

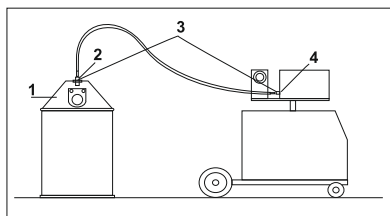


Art #	Product
FO210050	Sif Purging Flux 500g

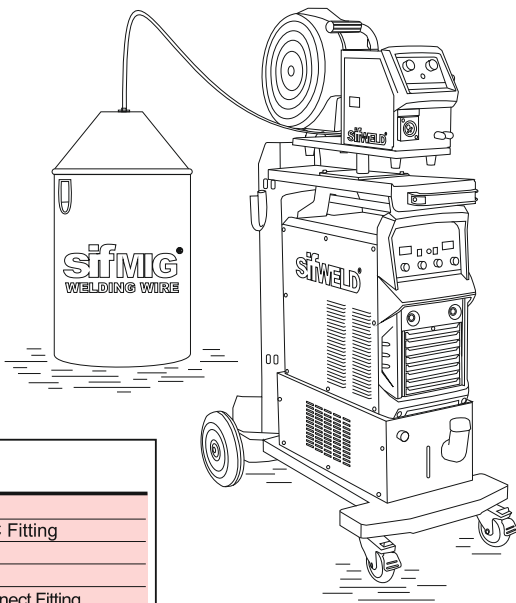
### QuickPak Wire Delivery System

The QuickPak wire delivery system is design to transport welding wire from bulk storage drums to the welding machines wire feed unit. The system includes fittings for the bulk drum and wire feed unit and metal-spiral lined conduits that can be purchased pre-fitted or by the metre to manufacture to a custom length.

The drum cone fitting is designed to fit all SifMIG bulk drums and the wire feed unit fitting is supplied with a range of bushes to allow it to be used on all wire feed units that have an inlet guide diameter of 9mm to 22mm. The quick connect end fittings allow conduits to be changed within seconds at both drum and wire feed unit.



- 1 FX250CONE
- 2 FX250LQCD
- 3 FX250LQCC
- 4 FX250LQCA
- 5 FX250LNR3MQ



Art #	Product
FX250CONE	Cone For Bulk MIG Drum
FX250LNR3MQ	QuickPak Fitted Conduit c/w QC Fitting
FX250LQCD	QuickPak Drum Cone Fitting
FX250LQCA	QuickPak Wire Feed Unit Fitting
FX250LQCC	QuickPak Replacement Quick Connect Fitting



# ALUMINIUM



Years ago aluminium was considered a difficult material to weld. When using oxy-acetylene there was no colour change to indicate the metal's temperature so suddenly it could melt and collapse!

With the introduction of TIG and MIG welding processes, these welder fears have been put to one side, providing that the properties of aluminium are understood. This article is intended to give a general overview. Aluminium and its alloys have special properties of lightness, strength, conductivity and malleability making it a particularly useful material in a variety of industries. The metal can be either in cast form or extruded (wrought), which then

divides into non-heat treatable and heat treatable. Generally, aluminium is weldable, but it is important to understand some of its characteristics:

## OXIDATION

In air, aluminium immediately forms an oxide layer on its surface, which will increase in thickness with time. This oxide layer must be controlled during the welding process, by chemically and mechanically cleaning the metal, using an aggressive flux or ensure the arc has reverse polarity (electrode positive). Correct gas shielding (argon) will prevent oxides reforming in the weld.

## THERMAL CONDUCTIVITY

As aluminium is a very good thermal conductor, it will rapidly disperse heat. Care must be taken to avoid distortion and possibly cracking.

## COLOUR

Unlike steel, there is no change in colour in aluminium as it is being heated. Look out for a 'wet' appearance. For gas brazing, melting of flux powder is a temperature indicator.

## PREPARATION

Smooth all edges of workpiece to minimise trapped dirt. Use a commercial degreaser and stainless steel brush to remove dirt, oil, paint. Dry surface thoroughly. If TIG welding, wipe filler rod clean of any surface oil.

## APPLICATION

Support the joint to be welded, preferably with a jig, but spot tacking can be used. Keep the arc travelling at the right speed to build up a bead of the right proportions. Do not stop/start on one weld, as this can lead to oxidation/porosity. Carry out the weld quickly to minimise distortion. ■



# **sif tips**



Technical advice in the original SifTips style was started in 1932. 'Sifbronzing' is an almost universally recognised way of describing the low temperature bronze welding of sheet steel, cast iron and other metals. This explains why Sifbronze, the company which first developed and promoted the technique, is generally considered to be a supplier of high quality welding rods, wires, fluxes and equipment.

'Will the Welder' was a SifTips magazine that was produced in the early 1930s. The aim was to provide users with ideas and tips on how to get the most out of their welding equipment.

Sif is renowned for its UK manufacturing heritage as well as its complete range of quality welding consumables used globally for almost a century.

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PHONE: (+44) 845 130 7757 FAX: (+44) 81462 482202  
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Sifbronzing is an almost universally recognised way of describing the low temperature bronze welding of sheet steel, cast iron and other metals. The reason behind this fact summarises why Sifbronze, the company which first developed and promoted the technique, is generally considered to be a supplier of top-quality welding rods, wires, fluxes and equipment.

In 1914 a young man called Louis Tibbenham took on part of a factory in Stowmarket which had gone bankrupt, and set up his own company, the Suffolk Iron Foundry, to make castings such as flywheels and ploughshares. Just as the business got going, the Great War started, the bank-rate went up and business ground to a halt. It looked as though the company was doomed.

However, Louis Tibbenham struggled on, picking up small contracts and learning, in many cases by bitter experience, about business. At one stage, having built up a good trade in ploughshares, he signed a contract which, he discovered later, forced him to stop making them. So he turned to making mangles; then, before the age of the tumble-drier, an essential part of every household's washing equipment.

By the end of the Great War the company was doing well. It had grown too big for its premises and so another site, some six acres of bog and rubbish tip by the River Gipping in Stowmarket, was bought for £500. The railway company provided a siding close by and work began on the site. The whole site was planned by Louis Tibbenham, and the buildings were designed by him, resulting in his winning a first prize in a competition run by the Foundry Trade Journal.

The new factory coincided with a major contract which took up nearly all the Foundry's capacity and then, in the form of having too many eggs in one basket, disaster struck and the contract was cancelled. Louis Tibbenham had to find something to fill the void and so he decided to turn to specialist castings. Prime amongst these was the lawn mower, soon to become recognised as the 'Suffolk' range.

Though casting and iron -founding was a major part of the business, Louis Tibbenham had always been interested in welding, and during the Great War he had met a young engineer in London who was experimenting with welding cast-iron using an oxy-acetylene flame. Suffolk Iron Foundries was asked to supply a few cast-iron rods containing extra silicon. They



Louis Tibbenham, the founder, photographed in the early 1920's.

performed so well that they became a production item in due course, under the brand name, 'Super-Silicon Rod'.

At around this time Mr Tibbenham learned of the techniques of low temperature bronze welding for cast-iron, so he developed a rod which, subsequently, was found to be suitable for welding virtually any metal except aluminium. Taking the initials SIF from Suffolk Iron Foundry, and adding 'bronze', he gave a name to the technique and formed a division to handle the products. The name Sifbronze has remained a fact in welding ever since, and has come to describe a technique which is universally accepted.

Over the years the nature of the company at Stowmarket has changed little beyond expanding to meet increased demand and keeping ahead of technology. During the Second World War most of the company's efforts were devoted to war work, largely for the Royal Air Force. This included the production of ground equipment such as the bomb-trolleys which were a prominent feature of so many air stations. Sifbronze was used for, amongst many other military applications, the fabrication of air frames.

In 1954 the first fully powered lawn mower, the 'Suffolk Colt', was introduced, heralding a whole new era of development in this field. The Sifbronze division extended its range to include welding equipment such as blowpipes and gas regulators.

Louis Tibbenham decided to retire in 1955, handing over to his son, Frank. In 1958 the company became apart of the Qualcast Group and then, in 1967 Qualcast merged with Birmid Industries. Subsequently, Louis' grandson, Paddy, became the Director responsible for Sifbronze.

Developments in welding in the 1960s were such that new techniques like semi-automatic MIG-welding were introduced and with them the requirement for new, high quality materials. At this point Sifbronze introduced the consumable electrode wire SIF-Mig, a shaved aluminium wire to ensure consistent, high-quality welds. When the QE2 was built, the aluminium welding of her superstructure was carried out using SIF-Mig. At the same time the traditional methods of supply, direct to the end-user, promoted through the magazine Siftips, began to change. This meant creating a whole new supply structure based on welding distributors and engineering merchants.



*'Will The Welder.' A company magazine, Siftips, was produced in the early 1930's. The aim was to provide users with ideas and tips as to how to get the most out of their welding equipment. Will The Welder, a character in the magazine, was the vehicle for this and became one of the most readily identifiable personalities in welding.*

## TODAY

In recent years, the company has taken positive steps to focus on its SIF brand and heritage in the welding industry. The product range of consumables continues to expand to meet the anticipated demands of our market place.



This is an extract from a Siftips magazine circa 1967 where the QEII super structure was welded with SIFMIG 5356



## BRAZING PRODUCTIVITY

SIF has a comprehensive background in Brazing technology and has over many years developed a group of wires and fluxes for brazing of a wide variety of metals. Manual flame brazing is not typically a highly productive process, with the constant need to mix and apply flux for every joint prior to brazing. The manual process often over-fluxes, using excessive flux for the required application, this in turn adding cost to the workpiece and increased cleaning time.

### WHAT IF WE COULD ADD BRAZING FLUX AUTOMATICALLY?

Automatic adding of flux to the fuel gas within the fuel supply pipeline can

significantly improve productivity and reduce costs if you are production brazing. A GASFLUXER unit added into the fuel gas supply line allows for the automatic adding of vaporised flux into the brazing flame and can feed multiple torches so as to allow multiple operator use in a production environment.

This process can be used on a wide range of brazing applications including

Silver brazing and Bronze Brazing of various materials and will operate on automated brazing stations as well as for manual operation.

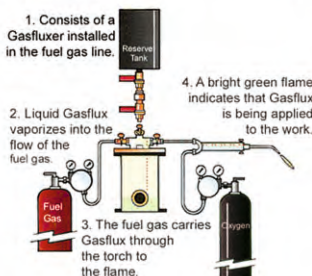
### BENEFITS OF USING THE GASFLUXER

Adding the flux into the fuel gas supply system provides a constant process variable that ensures consistently good outcomes. The control over the continuous amount of flux being added allows for optimisation of the process and reduced consumable use, delivering cost savings.

#### Additional benefits include:

- Optimum joint strength
- Improved joint appearance
- Lower fume levels
- Reduced post-braze cleaning
- Improved productivity

For further information on GASFLUXERS visit [www.weldability-SIF.com](http://www.weldability-SIF.com) and search for GAS FLUXER.



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# BRONZE WELDING BRAZING AND SILVER SOLDERING



## SIFBRONZING

For successful 'bronze welding' or 'sifbronzing', parts must be clean and for optimum strength a 60 – 90 vee preparation is required. Using leftward welding technique, the parts should be heated with an oxidising flame to a dull red, before introducing the Sifbronze rod and flux. Overheating must be avoided, as this will lead to porosity and inferior work.

It is essential that the joint faces be tinned. A drop of Sifbronze appears to collapse and spread across the metal face. If the drop stays as a globule, the metal is either too hot, too cold or dirty. The gap between the tinned faces is now filled with a weave action. It may be necessary to carry out further 'weld runs', building up the joint.

Sifbronze flux plays an important role not just cleaning the metal, but it covers the weld pool surface, preventing further oxidation of the molten bronze.

## Bronze welding cast iron

Prior to welded fabrications, engineers would use cast iron to produce a whole range of products from small domestic items (mangles, mincers, mowers) to large industrial parts (agricultural equipment, civil engineering brackets and fixings, cylinder blocks, machine tool frames etc).

Cast iron is a very hard, but brittle material, which can be easily machined. Since it is brittle, there is a tendency for it to fracture, especially if a part is subjected to a sudden impact, such as a casting being dropped on a protruding fixing lug or bracket. A repair of this nature does not require a colour match, so oxy-acetylene sifbronzing (or bronze welding) will be considered. The joint must be prepared by grinding back the surface and producing a 'vee' preparation if the material is thick.

The first task is to seal the carbon into the cast iron, by 'buttering' both faces of the joint. This is done by using brazing rod (Sifbronze No 1) and standard Sifbronze flux, to cover each face with a layer of brazing material. Next, the two parts are positioned so that the joint can be completed by bronze welding between the two 'buttered' faces.

This produces a strong joint, which is very visible, unless dressed and painted. The process does not require the parts to be pre-heated, as necessary when full fusion welding cast iron.

## Brazing copper to copper

Copper to copper joints produced with SIFCUPRON, do not require the addition of flux, as the phosphorus provides a self-fluxing action. It is necessary for the parts to overlap with a joint gap of 0.05 to 0.12mm. The gap should not exceed 0.4mm

As copper is a very good thermal conductor, the heat must be applied quickly, taking great care not to overheat and cause embrittlement. If joint strength and ductility are important, Sifcupron No 17-2Ag or 17-5Ag should be used in preference to No 17. Sifcupron No 17-15Ag is more tolerant if joints are not close fitting.

On occasions, there is the need to braze copper to brass (perhaps a brass flange to a copper pipe). Provided it is a suitably designed joint, a copper/ phosphor alloy with an inclusion of silver (such as Sifcupron No 17-2Ag) will be ideal. However in order to get the alloy to bond with the brass, it is necessary to use a flux, such as Sifsilcopper or Sifbronze.

Sifcupron is not suitable for brazing nickel alloys, ferrous metals or where the joint is subject to hot sulphurous gases or oxidising atmosphere above 200 C.

## Silver soldering

As with all brazed joints, preparation and cleaning of the workpiece is essential to produce a successful joint. When silver soldering, lap type joints (rather than butt) are preferred and the recommended clearance is 0.04 to 0.15mm.

Apply SIF Silver Solder flux to both joint faces before assembling the parts. Using a neutral flame, heat assembly quickly and evenly, avoiding overheating the silver solder (wipe rod on joint rather than melting it directly in the flame). Use in a well ventilated area and be aware of health and safety procedures.

To silver solder stainless, a high silver content alloy is required (such as SIF Silver Solder No 43 – 55% Ag Cd free) and a suitable flux (SIF Flux – Silver Solder). Alternatively, a 'nickel bronze' brazing rod such as Sifbronze No 2 together with 'Tool Tipping/Brazing Stainless' flux (note: do NOT use Stainless flux as it is for gas welding of stainless)

# sif tips



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## Weldability.sif

PHONE: (+44) 0845 136 7757 FAX: (+44) 01462 482292  
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# COPPER & BRASS: A GUIDE TO SUCCESSFUL WELDING

## COPPER

Pure copper has characteristics of high thermal and electrical conductivity and, because the metal requires about six times more heat (melting point is 1,083°C) for fusion welding than steel, particular care must be taken during welding and brazing.

Tough pitch copper, which includes most varieties of high conductivity copper, contains up to 0.5% oxygen (cuprous oxide) and is not suitable for fusion welding since it has a tendency to embrittlement and cracking, though it can be brazed.

Deoxidised copper, where the oxygen has been removed during manufacture by the use of deoxidising agents, can be fusion welded.

For MIG and TIG welding, it will be necessary to preheat workpiece if it is over 6mm thick. The usual shielding gas is argon, but with thicker material an argon/helium mixture can beneficially increase the arc temperature.

Consumables to be used are SIFMIG 985 and Sifsilcopper No 985, although Sifsilcopper No 7 can be used for TIG welding sheet up to 3mm thick.

Gas welding of copper, such as whiskey stills, tanks etc, requires the parts to be preheated to 600°C and slowly cooled on

completion of the joint. Sifsilcopper No 7 together with Sifsilcopper flux will produce a joint with excellent colour match.

Copper is not generally joined using arc welding electrodes. But in circumstances where there is no other welding equipment

causes porosity and fume problems with gas shielded arc welding, Phosphor Bronze, copper/tin alloys such as PB2, can be readily brazed or welded.

Gas welding of brass is not recommended as the zinc will tend to vaporise causing fumes (zinc oxide) and porosity. However, PB2 phosphor bronze can be joined with oxy-acetylene and Sifphosphor Bronze No 8, as sometimes used by sculptors.

For MIG and TIG welding a shielding gas of argon or argon/carbon dioxide mixture is used.

If it is felt necessary to use preheat, this must be limited to less than 80°C, otherwise the structure of the brass may become altered. The choice of filler wire or rod will depend on the composition of the alloy being joined.

As a general comment, SIFMIG 8 or Sifphosphor Bronze No 8 is recommended as first consideration.

However, SIFMIG 328 and 968 or Sifalbronz No 32 and Sifsilcopper No 968 may also be suitable.

If colour match with brass is important, Sifphosphor Bronze No 82 is recommended. •

other than a transformer, Hilco Bronsil proves ideal.

## BRASS

Brass is a generic term covering a wide range of copper alloys containing additions of zinc. All brasses, which includes Gilding Metal, can be silver soldered, MIG and TIG welded successfully.

However, the addition of lead for free cutting brass and in gunmetal (LG1 & LG2)



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# MIG BRAZING

## COATED STEEL FOR THE AUTOMOTIVE INDUSTRY

### Why 'Manganese Boron Steel'

In the automotive industry the need to save weight, while at the same time meeting increasingly severe crash test standards, has led to the use of high strength steels that conserve good ductility and formability.

The high yield strength makes this material particularly suited for anti-intrusion functions i.e. fender beams, door reinforcements, middle posts etc.

This sheet steel is pre-aluminised to protect the metal from oxidation and decarburisation, during heat treatment; this also enhances the corrosion resistance after painting, avoiding the need for any subsequent corrosion protection treatment.

### MIG Brazing of pre-aluminised (galvanised) sheet

Zinc, in the galvanised coating, melts at temperatures of around 420 C and vaporises at 906 C. This causes unfavourable effects on the welding process as unalloyed SG2 MIG welding wire melts around 1450 C. The zinc starts to vaporise as soon as the arc is struck; zinc vapours and oxides can lead to pores and inadequate fusion.

An alternative is to use MIG Braze process, using a copper silicon alloy wire SIFMIG 968 (CuSi3). SIFMIG 968 has a relatively low melting point approx 980 C.

The reduced heat input results in the following advantages:

- Low coating burn off
- No corrosion to the joint seam
- Low distortion



- Dissimilar joints (any combination of material, except aluminium)
- Easy after joint machining
- Fast deposition saving labour costs
- Minimal spatter

Since there is no fusion of the base metal, it therefore has more in common with a brazed joint than a welded one.

### The Product - SIFMIG 968

SIFMIG 968 is produced to conform to BS2901 C9 and also Din CuSi3, having a typical composition of 3% Silicon, 1% Manganese and balance Copper. Diameters available: 0.8mm, 1.0mm and 1.2mm

Spool sizes:

- D100 - 0.7kg (in 0.8 and 1.0mm)
- D200 - 4.0kg (50mm bore as 15kg spool)
- D300 - 12.5kg

### General Hints

Copper alloy MIG wires require 'soft' or formed wire feed drive rollers and a soft or Teflon type wire liner in the torch cable. If the welding machine has been used with

steel MIG wire, ensure any steel particles are removed from the wire feed system. This is to avoid carbon contamination on the copper alloy wire.

### Procedure Tips

On thin sheet steel and galvanised sheet use 0.8mm / 1.0mm SIFMIG 968, keeping heat input to a minimum (approx 45-65 amps).

Select a shielding gas, which will maintain a stable arc, such as pure Argon or Argon 2% CO2 mix.

Pushing MIG torch (as conventional MIG welding) will ensure not too deep penetration, avoiding burn through on thin sheet. If galvanised coating is thick, use dip transfer with a short arc.

For best results, use a programmable synergic MIG machine. This type of system will produce a neat, clean brazed joint, requiring a minimal amount of joint dressing and preparation prior to painting.

# sif tips



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# STAINLESS STEEL: AN INTRODUCTION & GUIDE TO WELDING

## WHAT IS STAINLESS STEEL?

Stainless steel is a generic term for a range of steels that contain a minimum of 12% chromium, although other elements such as nickel and molybdenum are added to improve corrosion resistance, which is their primary feature and use. Stainless Steels are grouped primarily into four classes depending on their crystal structure; austenitic (302, 304, 308, 316, etc.), martensitic (410, and 416), ferritic (409, and 430), and duplex (2304, 2205, 2507 etc). The groups of stainless steel most commonly welded are austenitic and duplex.

## AUSTENITIC STAINLESS STEELS

Austenitic steels have austenite as their primary phase (face centered cubic) structure. Austenite steels make up over 70% of total stainless steel production. They contain a maximum of 0.15% carbon, a minimum of 16% chromium and sufficient nickel and/or manganese to retain an austenitic structure at all temperatures from the cryogenic region to the melting point of the alloy.

## DUPLEX STAINLESS STEELS

Duplex Stainless Steels have a mixed microstructure of austenite and ferrite and have roughly twice the strength compared to austenitic stainless steels and also improved resistance to localized corrosion, particularly pitting, crevice corrosion and stress corrosion cracking. They are characterized by high chromium (19–32%) and molybdenum (up to 5%) and lower nickel contents.



## JOINING STAINLESS STEEL

When welding stainless steel it is imperative that the weld and root face are protected from the atmosphere to eliminate the creation of chromium carbides. TIG welding is the most popular process for high quality applications or root runs, prior to filling with an alternative process. TIG Consumables are available in the SifSteel Stainless range covering 308L, 309L, 310, 312, 316LSi, 347 & Duplex. MIG welding can also be used with increased speed being the main advantage. Recent technological advances in welding equipment have enabled more appealing results. MIG consumables are available in the SifMig range covering 308LSi, 309LSi, 312, 316LSi & 347. Plus flux cored wires covering 308L, 309L & 316L. MMA (Manual Metal Arc) can also be used successfully in applications or locations which make it difficult to adopt other process. MMA consumables are available in the SifChrome range covering 307, 308L, 312 & 316L. TIG or MIG brazing can be used and is especially useful if the material is required to be joined to copper or steel. The most suitable consumable in this case would be Sifphosphor Bronze No 8 or SIFMIG 8.

## GAS PROCESSES

It is possible to gas weld the common grades of stainless, but it is important to use Stainless flux and also apply the flux in paste form (mix powder with water) to the reverse side of the joint. Stainless Steel can also be silver soldered or brazed, which is again a benefit for dissimilar metal applications. To silver solder stainless, a high silver content alloy is required (such as Sif Silver Solder No 43 55% Ag Cd free) and a suitable flux (Sif Flux Silver Solder). Alternatively, a 'nickel bronze' brazing rod such as Sifbronze No 2 together with 'Tool Tipping/Brazing Stainless' flux (note: do NOT use Stainless flux as it is for gas welding of stainless).

## PROCESS TIPS

Cleanliness of the workpiece is most important. Only use stainless wire brushes for cleaning. Avoid striking the arc outside the joint, as this can lead to pitting and cracks. With TIG, use a thoriated tungsten and do not allow it to contact the workpiece, which can lead to contamination. After welding, clean thoroughly using a stainless brush. Use Sif Pickling Paste to clean discoloration from surface and restore chrome oxide layer on the stainless. The weld can become contaminated and 'rust' spots appear on the stainless if ferrous particles have inadvertently been allowed to enter the weld area. This can be caused by poor housekeeping (stainless brush being used on steel) or other operations in the welding area which produce air borne metal particles, such as grinding. ■

# sif tips



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# ALUMINIUM SOLDERING AND BRAZING

## SOLDERING ALUMINIUM

Historically, engineers have considered that welding aluminium presents a range of problems, due to its surface oxide and that it does not change colour when heated. With the advent of MIG and TIG welding, it is now regularly welded with great success.

Certain alloys can be gas welded or brazed, but the removal of flux residue is most important, as its corrosive action will continue after the joint has been completed.

There is another 'low temperature' process, which is called soldering, although the workpiece is melted. The parts to be joined are heated (even by a small propane burner) and the rod rubbed on the work surface. At the correct temperature (370 C), the rod is seen to melt and creates an exothermic reaction generating sufficient heat to locally melt the aluminium. An advantage of this process is that flux is NOT required. We refer to the material as SIF 555 Aluminium Solder. The product gives high strength deposits that do not have the problem of galvanic corrosion between base metal and solder. The low working temperature keeps distortion and discoloration of the work to a minimum.

This process is commonly used by manufacturers of aluminium windows and doors. It is ideal for repairing and sealing defects in aluminium boats, gutters, engine parts, castings and sheets, being especially recommended for applications where flux residue removal is a problem.

The correct procedure is as follows; cracks and joints should be bevelled to a 60 to 90 Vee. Remove all dirt, grease and foreign material from the surface to be bonded. For a higher strength bond, roughen the surface before applying the alloy. Using a carburizing flame, heat the part broadly. As the temperature approaches 370 C, rub the rod on the surface to be soldered. Continue heating base metal until enough heat is present to cause the rod to melt off when it is rubbed on the joint. Do not overheat, but

be sure the entire joint surface is tinned before adding additional alloy to make a build-up. Tinning action may be improved by using a clean, stainless steel wire brush to brush through the molten metal to the base metal surface. Allow part to cool slowly.

## BRAZING ALUMINIUM

Traditionally Sifbronze referred to the technique as 'Process 36', but recently Sifalumin No 36 and Aluminium No 36 flux have been replaced by Sifalumin No 16 which melts approx. 80 C lower than pure aluminium and Aluminium Flux.

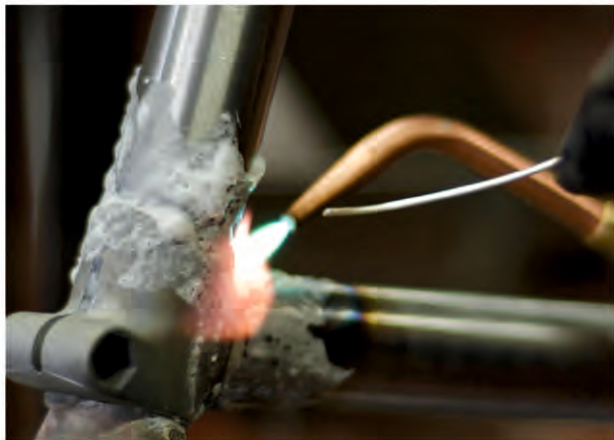
The process is applicable to pure aluminium and alloys with up to 2% magnesium. Other alloys will prove difficult, especially if containing high % of silicon. The joint design should be lap type with a good mechanical fit. Parts must be thoroughly cleaned and if magnesium bearing wire brushing is essential. The brazing operation should be carried out as soon as possible after cleaning.

The SIF Aluminium flux is used as a temperature indicator and can be applied via the rod or applied direct to the workpiece as a paste, made by mixing the flux with water. The whole workpiece should be pre-heated with the blowpipe moving backwards and forwards along the joint line. As the flux melts, the rod is applied to flow freely along and trough the joint. It is important to avoid overheating which can destroy the properties of Sifalumin No 16.

Aluminium flux is highly corrosive and the residue must be removed within 30 minutes of the brazing operation. Where joints are accessible, wire brush with very hot water or even a steam jet, alternatively treatment with 5% nitric acid solution may be required.

## Preparation Is Key

All brazing and soldering applications require components to be clean and oil free to facilitate capillary action. Thorough degrease and clean all component before attending to start the process.



# sif tips



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# STEEL: AN INTRODUCTION & GUIDE TO WELDING

As a general statement, steel is readily weldable by the majority of welding processes. With alloy steels, it is necessary to select an appropriate filler metal for the material and application. For Mild Steels the carbon content is generally the first consideration, followed by silicon and manganese. For other alloyed-steels other elements such as chromium or molybdenum would usually take priority over carbon.

## MIG WELDING

MIG Welding is the most popular process with the major part of fabrication work requiring the use of SifMig SG2 wire. Other applications requiring a higher UTS would usually use SifMig SG3. Applications requiring a high deposition rate should consider flux cored wires with the most popular being Sifcored E71T-1. Steel may also be successfully MIG brazed, as in the automotive industry on manganese boron steel with SIFMIG 968. Our other copper alloy wires SIFMIG 8, 328 and 967 are also suitable for MIG brazing.

## TIG WELDING

TIG Welding filler rods are available for a range of mild and alloy steels. A frequently asked question is 'what do we use on 4130 (0.3C, 0.3Si, 0.5Mn, 1.0Cr, 0.2Mo)'; the answer is Sifsteel A32. (See Sif Tips No 15) Spring and high carbon steels can be successfully welding using SifSteel Stainless 312 and for dissimilar joints (steel to stainless) Sifsteel Stainless 309LSI would be a suitable consumable. TIG brazing with Sifphosphor Bronze No 8, Sifalbronze No 32 or Sifsilcopper No 968 can be very useful



with difficult steel applications, dissimilar joints or where heat must be kept to a minimum.

## MMA WELDING

MMA Welding electrodes come with three different types of coating. For the most common applications the most popular electrode have a 'rutile' coating, which is predominantly titanium oxide to decrease spatter and improve slag removal. Sif consumables for this are SifTrode 6013, Hilco Red Extra, Velveta and Velora. Cracking in steels is often due to the formation of minute quantities of steam from hydrogen in the electrode combining with oxygen from the air. This can be overcome by using 'basic' coated electrodes, also known as 'low hydrogen'. Sif consumables for this are SifTrode

7018, Hilco Basic Super and Basic S5. Finally, for high deposition rates, iron powder is added to the coating to substantially increase the amount of material deposited compared with a rutile type electrode. They are referred to as 'high recovery', such as Hilco Regina 160.

## GAS WELDING

From a gas welding point of view, the filler rod is Sifsteel No 11, which is also referred to as CCMS. The Sifbronze business developed due the ability of Sifbronze No 1, No 101 and No 2 to 'bronze weld' and braze steel, with minimum of distortion and producing a neat fillet joint, especially on tubular structures. For joining steel to copper or copper alloys a silver solder should be selected. ■

**sif tips**

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Email: [info@weldability-sif.com](mailto:info@weldability-sif.com) Website: [www.weldability-sif.com](http://www.weldability-sif.com)



# TIG BRAZING

## PROCESS BASICS AND A FEW APPLICATIONS

TIG Brazing can cover a wide range of applications, from the point of view of materials to be joined, joint design, one off special repair job to quantity production. Perhaps the title is a confusion of terms.

Initial reaction is that TIG is a fusion welding process and brazing gets obscured with the thought of oxy-acetylene torches, flux powder etc. In practice, the heat source is the TIG arc but run on a low current so as not to melt the material with a suitable filler rod fed into the arc.

This filler rod is quite different from conventional oxy-acetylene/silicon bronze brazing rod. As the TIG torch provides a protective gas shroud, there is no need for the addition of flux, as with the long established brazing process.

### TIG BRAZING ALLOYS

#### Sifscopper No 968

Composition: 96% Cu, 3% Si, 1% Mn  
Diameters: 1.2, 1.6, 2.4 & 3.2mm  
Pack sizes: 1.0, 2.5 & 7.5 kgs  
Conforms to: BS2901 C9, Din CuSi3

**Application Example:** One customer was using Sifsteel A15 to complete TIG welds on sheet steel ducting, which was being joined to a square section frame. The initial problem was distortion due to heat build up and subsequent costs for heat treatment to remove stresses and dress the weld. TIG brazing with Sifscopper No 968 was suggested. The speed of operation is nearly twice as fast as welding, as the TIG arc has a temperature of approx 1400 oC and Sifscopper No 968 melting point is around 1000 oC, some 450 oC lower than Sifsteel A15. The speed of operation is very rapid.

Not only did the customer nearly halve his 'joining' time, but found there was only minimal 'after brazing' work to bring the components into an acceptable final condition for painting.

#### Sifphosphor Bronze No 8

Composition: 93% Cu, 7% Sn  
Diameters: 1.2, 1.6, 2.4 & 3.2mm  
Pack sizes: 1.0, 2.5 & 7.5 kgs  
Conforms to: BS2901 C11, Din CuSn6

Particularly useful where copper alloys are involved, if the joint is between dissimilar metals (e.g. copper/stainless), if the metal can't be completely identified or if it is known to be difficult to weld but can be brazed.

**Application Example:** A welder was required to repair an old exhaust manifold, which had been previously welded on a number of occasions where cracks had developed in and around the heat affected zone. Further efforts to TIG weld the material only led to burn through and further cracks. The exact composition of the metal was not known. The solution was for the welder to try Sifphosphor Bronze No 8, working on ground out cracks and suitably reducing the current.

#### Sifalbronze No 32

Composition: 89% Cu, 10% Al, 1% Fe  
Diameters: 1.6, 2.4 & 3.2mm  
Pack sizes: 1.0, 2.5 & 7.5 kgs  
Conforms to: BS 2901 C13, Din CuAl9Fe

This filler rod alloy has free flowing characteristics making it ideal for close fitting joints which one would expect to find in brazing operations. Application example: A fabricator of specialist bicycle frames, manufactured from T45 (0.2%

C, 0.2% Si, 1.5% Mn) steel with socketed tubular joints and lug location.

**Sifalbronze No 32** was selected because of its excellent 'wetting out' characteristics compared with the other alloys.

### GENERAL HINTS

Irrespective of the filler rod used, argon is the recommended shielding gas. Always remember that cleanliness of the work piece is a priority for first class results: remove any oxide or grease from the joint area.

### PROCESS TIPS

TIG brazing is relatively straightforward. The TIG torch needs a thoriated tungsten and dc current (torch +). Whereas TIG welding with say 1.6mm Sifsteel A15 would require 80-95 amps, TIG brazing will only require less than half that current, more in the order of 35-45 amps.

As you can imagine, it is important for the welder to be comfortably positioned with regards to the parts being joined, so that the whole procedure can flow at a relatively fast rate. Maintaining torch and filler rod angles with respect to the workpiece is key, to prevent breakdown of the inert gas envelope to avoid atmospheric contamination of the joint.



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## MANUAL METAL ARC BASIC ELECTRODES

When welding takes place hydrogen diffuses out of the weld metal to escape to atmosphere, this hydrogen when collected and measured tells us how much diffusible hydrogen weld metal contains. Hydrogen content within weld metal is measured in millilitres per 100 grams of weld metal or 'ml/100g'.



**FIGURE 1. HYDROGEN ESCAPING FROM A WELDMENT.**

Basic coated electrodes are designed to deposit low levels of hydrogen content within the weld metal, if they are handled correctly. This will typically involve baking the electrodes in an oven to remove as much moisture as possible. Baking should take place in line with the electrode manufacturer's instructions but will typically involve temperatures between 350 and 450 degrees for between 1 and 4 hours.

**FIGURE 2. SIFDRY PORTABLE OVEN**

Electrodes exposed to the atmosphere will very quickly start to absorb moisture again

so as a welder you should only remove electrodes from the portable oven as and when you need them. Hydrogen can cause welds and parent metals to crack so always ensure you follow the correct procedures for handling and storing welding electrodes.



As an alternative to baking electrodes manufacturers are producing electrodes pre-baked and stored in vacuum packs that protect them from the atmosphere. These hermetically sealed packs are ideal for managing electrode waste with differing sized packs available from 1kg to 3 Kgs ensuring the welder only takes what they need. When these special packs are opened they should typically be used within 4-6 hours although this will be specified by the manufacturer.

**FIGURE 3. SIFDRY ELECTRODE BAKING OVEN**

Once electrodes have been baked they should then be stored in a portable electrode oven (often called a 'quiver') for transportation to



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the work place. The portable oven is then plugged in to ensure the electrodes remain heated whilst work continues.

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