Aluminium

MIG Page 110	TIG Page 114	GAS Page 114+120	Brazing Page 114+120	ARC Page 124
SIFMIG 1050	SIFALUMIN No 14	SIFALUMIN No 14	SIFALUMIN No 16	HILCO ALUMINIL SI5
SIFMIG 4043	SIFALUMIN No 15	SIFALUMIN No 15	SIF 555 AL SOLDER	HILCO ALUMINIL SI12
SIFMIG 4047	SIFALUMIN No 16	SIF FLUXCORE ALUMINIUM		
SIFMIG 5356	SIFALUMIN No 27			
SIFMIG 5183	SIFALUMIN No 28			
SIFMIG 5556	SIFALUMIN No 37			

Brass/Bronze

MIG Page 111	TIG Page 115		Brazing Page 118	ARC Page 124
SIFMIG 8	SIFPHOSPHOR BRONZE No 8		SIFCUPRON No 17-2Ag	HILCO BRONSIL
SIFMIG 328	SIFPHOSPHOR BRONZE No 82		SIFCUPRON No 17-15Ag	
SIFMIG 968	SIFSILCOPPER No 968		SIF SILVER SOLDER No 38/39/43	

Cast Iron

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SIFMIG 8	SIFPHOSPHOR BRONZE No 8	SUPER SILICON No 9	SIFBRONZE No 1	HILCO PURE NICKEL
SIGMIG 328		SUPER SG CAST IRON		HILCO NICKEL IRON
				SIFTRODE CAST IRON

Copper

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SIFMIG 985	SIFSILCOPPER No 985	SIFSILCOPPER No 7	SIFCUPRON No 17	HILCO BRONSIL
SIFMIG 968	SIFSILCOPPER No 968		SIFCUPRON No 17-2Ag	
SIFMIG 8	SIFPHOSPHOR BRONZE No 8		SIFCUPRON No 17-5Ag	
SIFMIG 328	SIFPHOSPHOR BRONZE No 82		SIFCUPRON No 17-15Ag	
SIFMIG 44	SIFALBRONZE No 32		SIF SILVER SOLDER No 38/39/43	
	SIFALBRONZE No 44		SIFSILVERCOTE No 43	

Magnesium

	TIG Page 114		Brazing Page 114+120	
	SIF MAGNESIUM No 23			

Stainless

MIG Page 113	TIG Page 116	GAS Page 116	Brazing Page 118-119	ARC Page 122+125
SIFMIG 308LSI	SIFSTEEL STAINLESS 308L	SIFSTEEL STAINLESS 308L	SIFBRONZE No 2	HILCHROME 308 R
SIFMIG 316LSI	SIFSTEEL STAINLESS 316LSI	SIFSTEEL STAINLESS 316LSI	SIF SILVER SOLDER No 43	HILCHROME 316 R
SIFMIG 347	SIFSTEEL STAINLESS 347	SIFSTEEL STAINLESS 347	SIFSILVERCOTE No 43	HILCHROME 309 R
SIFMIG 309LSI	SIFSTEEL STAINLESS 309L			HILCHROME 309Mo R
SIFMIG 312	SIFSTEEL STAINLESS 312			HILCHROME 312 R
				SIFTRODE STAINLESS 316
				SIFTRODE STAINLESS 312

Steel

MIG Page 112-113	TIG Page 117	GAS Page 121	Brazing Page 114+120	ARC Page 122-123
SIFMIG SG2	SIFSTEEL A15	SIFSTEEL No 11	SIFBRONZE No 1	HILCO RED EXTRA
SIFMIG SG3	SIFSTEEL A17	SIFSTEEL No 22	SIFBRONZE No 2	HILCO VELVETA
SIFMIG A15	SIFSTEEL A18		SIF AUTOBRONZE	HILCO VELORA
SIFMIG A32	SIFSTEEL A31		SIFBRONZE No 101	HILCO REGINA 160
SIFMIG HF600	SIFSTEEL A32		SIFREDICOTE No 1	HILCO BASIC SUPER
FLUX CORED WIRES	SIFSTEEL A33		SIFREDICOTE No 2	HILCO BASIC 55
SIFMIG GASLESS	SIFSTEEL HF6			HILCO HARDMELT 600
SIFCORED E71T-1				SIFTRODE 6013
HILCORD 600				SIFTRODE 7018

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)

Dia mm	Art #	6.5kg Spl
0.8	WO140865	109.20
1.0	WO141065	91.20
1.2	WO141265	89.15
1.6	WO141665	86.85

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	90	15	126

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 ★	9.85	WO150820	50.20	WO150865 ★	79.45
1.0	WO151005 ★	9.50	WO151020	44.65	WO151065 ★	71.40
1.2	WO151205 ★	9.25	WO151220	42.50	WO151265 ★	67.25
1.6					WO151665 ★	64.90

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
5 Si Bal Al	635	120	40	126

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	48.05	WO161065 ★	87.25
1.2			WO161265 ★	80.95
1.6			WO161665 ★	78.90

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
12 Si, Bal Al	585	130	50	126

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 ★	10.05	WO270820	51.05	WO270865 ★	80.75
1.0	WO271005 ★	9.60	WO271020	45.70	WO271065 ★	72.70
1.2	WO271205 ★	9.40	WO271220	43.20	WO271265 ★	68.25
1.6					WO271665 ★	66.70

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
5 Mg Bal Al	640	250	60	126

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	104.15
1.2	WO281265	96.65

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
5 Mg, 0.75 Mn, Bal Al	640	275	65	126

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 ★	91.05
1.2	WO371205	12.25	WO371220	45.80	WO371265 ★	85.45
1.6					WO371665 ★	84.40

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
5.3 Mg, 0.8 Mn,0.1Cr, 0.1Ti, Bal Al	640	300	70	126

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.

EN 14640 Cu 5180 (CuSn6P), BS: 2901 C11

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO080807	44.75	WO080840	212.05	WO080812	491.45
1.0	WO081007	42.20	WO081040	197.05	WO081012	457.35
1.2	WO081207	40.15	WO081240	191.10	WO081212	442.50

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640: Cu 6100 (CuAl8), BS: 2901 C28

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO320840A	235.65	WO320812A	536.25
1.0	WO321040A	229.30	WO321012A	522.25
1.2	WO321240A	218.30	WO321212A	496.65

% Metal Composition	Melting°C	U.T.S. N/mm²	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 14640 Cu 6328 (CuAl9Ni5), BS: 2901 C20/C26

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8			WO440812	1,260.85
1.2	WO441240	467.50	WO441212	1,145.85

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
83 Cu, 9 Al, 3 Fe, 4 Ni, 1 Mn	1050	700	290	

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.

EN 14640 Cu 6560 (CuSi3Mn1), BS: 2901 C9

Dia mm	Art #	0.7kg Spl	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO960807	38.60	WO960840	163.55	WO960812	★ 368.50
1.0	WO961007	36.55	WO961040	155.65	WO961012	★ 345.95
1.2			WO961240	151.75	WO961212	★ 341.00

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu1898 (CuSn1) BS: 2901 C7

Dia mm	Art #	4.0kg Spl	Art #	12.5kg Spl
0.8	WO980840	217.90	WO980812	468.30
1.0	WO981040	193.95	WO981012	454.50
1.2	WO981240	188.20	WO981212	439.05

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.25 Mn, 0.25 Si, Bal Cu	1025	220	70	132

Surcharge Info

Due to metal market volatility, it may be necessary to add a surcharge to the detailed prices from time to time. Please note that we have indicated appropriate icons for each product sector i.e.

- AL - aluminium
- CU - brazing and copper alloys
- NI - nickel bearing
- SS - stainless steel, by grade
- STL - steel

Test Certificates

All Sif and Hilco consumables are manufactured to controlled specifications.

Test Certificates are available for each product, and can be supplied - on request - with your orders. Test Certificates can also be re-produced for up to 3 months following your order. Test Certificate requests beyond 3 months will incur a charge of £25.00 to cover administration costs.

Steels, Flux cored wire & Anti Spatter STL

SIFMIG SG2

Copper coated mild steel MIG wire for welding mild and medium tensile steels, for impact toughness down to -20C

EN 440 G3Si1, (BS 2901: A18) (Din SG2)

Dia mm	Art #	0.7kg Spl	Art #	5.0kg Spl	Art #	15kg Spl
0.6	WA180607	4.75	WA180650	20.30	WA180615	66.80
0.8	WA180807	4.03	WA180850	19.00	WA180815	44.30
1.0			WA181050	16.70	WA181015	41.60
1.2					WA181215	40.90

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.1 C, 0.8 Si, 1.3 Mn	1450	400	120	134

SIFMIG SG3

Copper coated steel MIG wire with increased silicon and manganese for improved UTS.

EN 440: G4Si1, (Din SG3)

Dia mm	Art #	15kg Spl
0.8	WG030815	49.70
1.0	WG031015	47.30
1.2	WG031215	45.55

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.1C, 1.0Si, 1.75Mn	1450	600	120	134

SIFMIG A15

Triple deoxidised mild steel MIG wire.

BS: 2901 A15

Dia mm	Art #	15kg Spl
0.8	WA150815	105.60
1.0	WA151015	100.60
1.2	WA151215	94.20

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.1 C, 0.6 Si, 1.3 Mn, 0.2 Al	1450	440	120	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.

BS: 2901 A32

Dia mm	Art #	15kg Spl
0.8	WA320815	154.95
1.0	WA321015	140.10
1.2	WA321215	129.75

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 1.3 Cr, 0.5 Mo	1450	500	180	134

SIFCORED E71T-1

Rutile flux cored wire for welding thin sheet steels or low alloyed structural steels in all positions. Argon/CO2 shielding gas.

AWS: E71T-1

Dia mm	Art #	15kg Spl
1.0	WO711015 ★	82.30
1.2	WO711215 ★	65.55

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.05C, 0.6Si, 1.3Mn	1450	520	120	

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 ★	9.65	WG180809	17.10	WG180845	93.00

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.25 C, 0.4 Si, 0.7Mn, 2.4 Al	1450	400	120	

SIF TIP DIP

Anti-spatter paste to protect MIG welding torches, jigs and fixtures. It is odourless, non-toxic, non flammable and does not contain silicones.

Art #	225g		Art #	500g	
FXTIPDIP22	6.05	(20 tins per carton)	FXTIPDIP50 ★	8.65	(10 tins per carton)

Hardfacing & Stainless STL SS

HILCORD 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.

Din 8555: MSG 6-60

Dia mm	Art #	16kg Spl
1.2	H08600312	359.95

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.5C, 0.6Si, 1.5Mn, 5.5Cr, 0.6Mo	n/a	n/a	600	

SIFMIG HF600

Solid hard facing MIG wire, for high wear resistance.

Din 8555: MSG6-GZ-60

Dia mm	Art #	5.0kg Spl	Art #	15kg Spl
1.0	WF601050	207.85	WF601015	479.55
1.2	WF601250	150.65	WF601215	347.80

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.45 C, 3 Si, 0.4 Mn, 9 Cr	1450	n/a	570-650	

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 400ºC.

EN ISO 14343: 19 9 NbSi,
BS: 2901 347 S96

Dia mm	Art #	12.5/15kg Spl
0.8	WO200815	184.95
1.0	WO201015	165.40
1.2	WO201215	154.55

% Metal Composition	Melting°C	U.T.S. N/mm²	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	18.80	WO210640	88.40	WO210612	198.20
0.8	WO210807	15.60	WO210840	68.75	WO210815 ★	139.55
1.0	WO211007	14.40	WO211040	62.25	WO211015 ★	133.25
1.2	WO211207	14.30	WO211240	58.55	WO211215 ★	132.00

% Metal Composition	Melting°C	U.T.S. N/mm²	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	15.10	WO330840	59.85	WO330815 ★	122.85
1.0	WO331007	14.10	WO331040	58.45	WO331015 ★	115.00
1.2	WO331207	14.00	WO331240	61.00	WO331215 ★	113.40

% Metal Composition	Melting°C	U.T.S. N/mm²	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 #	15kg Spl
0.8	WO340840	102.20	WO340815	221.15
1.0	WO341040	92.55	WO341015	207.60
1.2	WO341240	88.60	WO341215	205.10

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1 C, 0.4 Si, 1.5 Mn, 13 Ni, 26 Cr	1440	650	180	133

SIFMIG 312

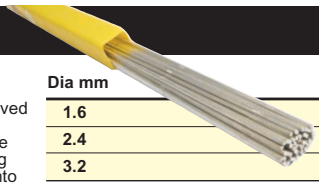
This is a 29.9 stainless MIG wire, suitable for difficult-to-weld steels (Mn steels, tool and spring steels), also dissimilar materials. High resistance to weld metal cracking.

EN ISO 14343: 29 9, BS: 2901 312S94

Dia mm	Art #	3.75kg Spl	Art #	15kg Spl
0.8	WO350840	93.40	WO350815	293.45
1.0	WO351040	88.45	WO351015	275.85

% Metal Composition	Melting°C	U.T.S. N/mm²	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

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)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO141601	21.50	RO141625	35.85
2.4	RO142401	18.10	RO142425	30.15
3.2	RO143201	17.35	RO143225	28.90

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
99.5 Min Al	650	90	15	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 (AlSi5), BS: 2901 4043A, (NG21)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO151601	16.20	RO151625 ★	26.30
2.4	RO152401	15.20	RO152425 ★	23.85
3.2	RO153201	14.35	RO153225 ★	23.45
5.0			RO155025	29.25

% Metal Composition	Melting°C	U.T.S. N/mm²	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 (AlSi12), BS: 2901 4047A, (NG2)

Dia mm	Art #	1kg Pkt	Art #	2.5kg Carton
1.6	RO161601	26.45	RO161625 ★	44.05
2.4	RO162401	22.50	RO162425 ★	37.45
3.2	RO163201	21.55	RO163225 ★	35.90
5.0			RO165025	41.70

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
12 Si, Bal Al	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	16.80	RO271625 ★	27.20
2.4	RO272401	14.90	RO272425 ★	24.20
3.2	RO273201	13.90	RO273225 ★	23.80

% Metal Composition	Melting°C	U.T.S. N/mm²	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	25.75	RO281625	42.85
2.4	RO282401	21.75	RO282425	36.25
3.2	RO283201	20.80	RO283225	34.65

% Metal Composition	Melting°C	U.T.S. N/mm²	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	25.75	RO371625 ★	42.85
2.4	RO372401	21.75	RO372425 ★	36.25
3.2	RO373201	20.80	RO373225 ★	34.65

% Metal Composition	Melting°C	U.T.S. N/mm²	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/packet	Art #	1kg Pkt
3.0	RO233212	66.40	RO233201	261.90

% Metal Composition	Melting°C	U.T.S. N/mm²	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

An easy flowing, high quality copper rod for full fusion welding of deoxidised copper sheet. The finished weld is free from porosity and copper oxide inclusions. Suitable for fabrication and repairs to copper pipes, tanks etc.

EN 14640 Cu 1897 (CuAg1),
BS: 1453 C1

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO071601	74.85	RO071625	134.30	RO071650	249.10
2.4	RO072401	67.55	RO072425	121.00	RO072450	225.15
3.2	RO073201	62.95	RO073225	113.95	RO073250	209.85

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu 5180 (CuSn6P),
BS: 2901 C11

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO081201	71.00	RO081225	130.80	RO081250	236.50
1.6	RO081601	67.50	RO081625	120.95	RO081650	225.00
2.4	RO082401	57.15	RO082425	102.35	RO082450	190.35
3.2	RO083201	55.45	RO083225	99.20	RO083250	184.75

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu 5410 (CuSn12P),
BS: 2901 C27

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO821601	103.20	RO821625	185.15	RO821650	343.95
2.4	RO822401	82.50	RO822425	145.35	RO822450	274.95

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu 6180 (CuAl10),
BS: 2901 C.13

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO321601	81.20	RO321625	145.80	RO321650	270.60
2.4	RO322401	74.70	RO322425	133.75	RO322450	249.00
3.2	RO323201	70.50	RO323225	126.65	RO323250	235.05

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu 6328 (CuAl9Ni5),
BS: 2901 C20/C26

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RO442401	105.45	RO442425	189.45	RO442450	351.45

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu 6560 (CuSi3Mn1),
BS: 2901 C9

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO961201	54.75	RO961225	98.70	RO961250	182.40
1.6	RO961601	50.90	RO961625	94.45	RO961650 ★	170.75
2.4	RO962401	44.40	RO962425	79.75	RO962450 ★	144.65
3.2	RO963201	41.60	RO963225	74.50	RO963250 ★	135.55

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 14640 Cu1898 (CuSn1)
BS: 2901 C7

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.2	RO981201	70.10	RO981225	120.90	RO981250	233.55
1.6	RO981601	67.30	RO981625	117.55	RO981650	224.25
2.4	RO982401	57.30	RO982425	102.95	RO982450	190.80
3.2	RO983201	88.00	RO983225	99.00	RO983250	184.05

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.25 Mn, 0.25 Si, Bal Cu	1025	220	70	132

Stainless & Pickling Paste 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 400ºC

EN ISO 14343: 19 9 Nb,
BS: 2901 347S96

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn
1.0	RO201001	27.25	RO201025	48.40
1.2	RO201201	23.90	RO201225	42.85
1.6	RO201601	21.10	RO201625	34.60
2.4	RO202401	20.75	RO202425	32.05

% Metal Composition	Melting°C	U.T.S. N/mm²	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 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 #	5.0kg Ctn
0.8	RO210801	35.05	RO210825	62.35		
1.0	RO211001	29.85	RO211025	52.80	RO211050 ★	93.20
1.2	RO211201	27.70	RO211225	46.35	RO211250 ★	81.80
1.6	RO211601	20.90	RO211625	33.90	RO211650 ★	59.85
2.4	RO212401	20.55	RO212425	33.30	RO212450 ★	58.80
3.2	RO213201	19.90	RO213225	32.05	RO213250 ★	56.70

% Metal Composition	Melting°C	U.T.S. N/mm²	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 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 #	5.0kg Ctn
1.6	RO331601	19.60	RO331625	31.75	RO331650 ★	56.00
2.4	RO332401	19.05	RO332425	30.90	RO332450 ★	54.60
3.2	RO333201	18.30	RO333225	29.50	RO333250 ★	52.10

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.02 C, 0.4 Si, 1.5 Mn, 10 Ni, 21 Cr	1440	650	180	133

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 #	5.0kg Ctn
1.6	RO341601	22.65	RO341625	39.70	RO341650 ★	72.60
2.4	RO342401	20.35	RO342425	35.60	RO342450 ★	65.75

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1 C, 0.4 Si, 1.5 Mn, 13 Ni, 26 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
1.0	RO351001	35.45	RO351025	72.75
1.2	RO351201	32.85	RO351225	67.35
1.6	RO351601	27.20	RO351625	55.10
2.4	RO352401	26.30	RO352425	53.15

% Metal Composition	Melting°C	U.T.S. N/mm²	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

SIF PICKLING PASTE & BRUSH

Pickling Paste is used to clean discoloration of the surface in the weld area and restore chrome oxide layer on the stainless.

Art #	2kg Jar
FXPICK20	49.45 (6 jars per carton)

£25.00 hazardous goods freight surcharge applies to all shipments.

NEUTRALISING PASTE

Used to neutralise any residual substance after using pickling paste.

Art #	2kg Jar
FXPICKNP	43.30

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.

BS: 2901 A15, AWS ER70S-2, EN 1668: W2Ti

Dia mm	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.0	RA151025	41.35	RA151050	66.15
1.2	RA151225	32.95	RA151250	52.60
1.6	RA151625	24.05	RA151650	★ 37.90
2.4	RA152425	22.15	RA152450	★ 34.60
3.2	RA153225	20.60	RA153250	★ 33.55

% Metal Composition	Melting°C	U.T.S. N/mm²	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	63.15
2.4	RA172450	59.25

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

BS: 2901 A18, AWS ER70S-6

Dia mm	Art #	5.0kg Ctn
1.0	RA181050	60.15
1.2	RA181250	53.05
1.6	RA181650	48.45
2.4	RA182450	44.55
3.2	RA183250	41.40

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

BS: 2901 A31, AWS: ER 80S-D2

Dia mm	Art #	5.0kg Ctn
1.6	RA311650	64.60
2.4	RA312450	55.55

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

BS: 2901 A32, AWS ER80S-B2

Dia mm	Art #	5.0kg Ctn
1.0	RA321050	119.55
1.2	RA321250	99.15
1.6	RA321650	93.70
2.4	RA322450	87.10

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

BS: 2901 A33, AWS ER90S-B3

Dia mm	Art #	5.0kg Ctn
1.6	RA331650	116.85
2.4	RA332450	107.15

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1 C, 0.5 Si, 1 Mn, 2.4 Cr, 1 Mo	1450	525	200	134

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	48.15	ROHF61601	176.50
2.4	ROHF62412	90.35	ROHF62401	156.55

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
1 C, 0.5 Si, 0.3Mn, 4Cr, 8Mo, 2V, 1.5W	n/a	n/a	60 HRC	

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 1044: CP201, BS: 1845 CP3

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.5	RO171501	46.00	RO171525 ★	81.75	RO171550 ★	153.25
2.4	RO172401	44.50	RO172425 ★	79.70	RO172450 ★	148.20
3.2	RO173201	43.25	RO173225 ★	78.95	RO173250 ★	144.10

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: CP105, BS: 1845 CP2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO181601	85.10	RO181625 ★	164.05	RO181650 ★	303.95
2.4	RO182401	79.15	RO182425 ★	152.00	RO182450 ★	282.70
3.2	RO183201	76.55	RO183225 ★	147.65	RO183250 ★	273.35

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: CP104, BS: 1845 CP4

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.5	RO1815015Ag	141.35	RO1815255Ag	268.30	RO1815505Ag	504.70
2.5	RO1825015Ag	140.05	RO1825255Ag	266.65	RO1825505Ag	500.10

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: CP102, BS: 1845 CP1

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt
1.5			RO181506	33.25

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
15 Ag, 5 P, Bal Cu	645-700	640	185	130

SIF SILVER SOLDER No 38

Suitable for all ferrous and non-ferrous metals except aluminium. It can be used with a range of heat sources. This alloy contains cadmium and care should be taken when using this rod. Use with SIF SILVER SOLDER flux.

EN 1044: AG 305, BS: 1845 AG11

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt
1.5			RO381506	42.25
2.5	RO382504	72.90		

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
34 Ag, 25 Cu, 20 Zn, 21 Cd	610-670	440	130	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.

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt
1.5			RO391506	48.15
2.5	RO392504	73.35		

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
38 Ag, 32 Cu, 28 Zn, 2 Sn	650-725	460	140	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 1044: AG 103, BS: 1845 AG14

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt
1.5			RO431506	63.80

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: AG 103, BS: 1845 AG14

Dia mm	Art #	4 rod/Pkt	Art #	6 rod/Pkt
1.5			RR431506	81.20

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
55 Ag, 21 Cu, 22 Zn, 2Sn	630-660	415	145	130

For SIF Silver Solder bulk 1kg; nett 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.

EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO011601	30.40	RO011625	★ 58.20	RO011650	★ 108.60
2.4	RO012401	27.35	RO012425	★ 52.55	RO012450	★ 97.60
3.2	RO013201	25.15	RO013225	★ 48.30	RO013250	★ 89.80
4.8					RO014850	89.80

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RR011601	53.25	RR011625	★ 100.80		
2.4	RR012401	36.80	RR012425	★ 69.95	RR012450	★ 130.30
3.2	RR013201	30.45	RR013225	★ 59.15	RR013250	★ 109.50

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

EN 1044: CU 302,
BS: 1845 CZ6A, 1453 C2

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RS412401	40.80	RS412425	78.90	RS412450	153.35
3.2	RS413201	37.90	RS413225	74.50	RS413250	142.35

% Metal Composition	Melting°C	U.T.S. N/mm²	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 #	5.0kg Ctn
1.5	RO101501	34.40	RO101525	66.70	RO101550	124.45
2.0	RO102001	31.75	RO102025	61.40	RO102050	113.35
2.5	RO102501	30.00	RO102525	57.55	RO102550	107.10
3.0	RO103001	28.40	RO103025	54.00	RO103050	101.50

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: CU305,
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO021601	74.10	RO021625	142.15	RO021650	264.50
2.4	RO022401	64.50	RO022425	123.70	RO022450	230.20
3.2	RO023201	59.65	RO023225	114.25	RO023250	213.00
4.8					RO024850	213.00

% Metal Composition	Melting°C	U.T.S. N/mm²	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 1044: CU305,
BS: 1845 CZ8, 1453 C5

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
2.4	RR022401	80.80	RR022425	155.20	RR022450	288.60
3.2	RR023201	67.45	RR023225	129.10	RR023250	240.30

% Metal Composition	Melting°C	U.T.S. N/mm²	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 SS

SIF FLUXCORE ALUMINIUM

Flux cored 5% Silicon Aluminium rod: ideal for oxy/acetylene general repair work.

Dia mm	Art #	1kg Pkt
3.0	RO153001F	72.05

% Metal Composition	Melting°C	U.T.S. N/mm²	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 #	1kg Pkt	Art #	2.5kgCtn
3.0	RO553212	21.00	RO553201	61.05	RO553225	125.35

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
93 Zn, 4 Al, 3 Cu	380	200	100	127

SIFALUMIN No 16

A rod for brazing aluminium that enables strong, neat joints to be easily produced. Difficulties can occur on alloys containing magnesium in excess of 2% and high silicon alloys. Use SIF ALUMINIUM flux.

EN ISO 18273 S Al 4047A (AlSi12), BS: 2901 4047A, (NG2)

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn
1.6	RO161601	26.45	RO161625 ★	44.05
2.4	RO162401	22.50	RO162425 ★	37.45
3.2	RO163201	21.55	RO163225 ★	35.90
5.0			RO165025	41.70

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
12 Si, Bal Al	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 #	5.0kg Ctn
1.6	RO071601	74.85	RO071625	134.30	RO071650	249.10
2.4	RO072401	67.55	RO072425	121.00	RO072450	225.15
3.2	RO073201	62.95	RO073225	113.95	RO073250	209.85

% Metal Composition	Melting°C	U.T.S. N/mm²	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 #	5.0kg Ctn
4.0	RO094001	30.00	RO094050	121.05
6.0			RO096050	94.90
10.0			RO091050	73.85

% Metal Composition	Melting°C	U.T.S. N/mm²	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

This rod is sutable 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 #	2.5kgCtn	Art #	5.0kg Ctn
6.0					RO296050	106.65
10.0					RO291050	81.00

% Metal Composition	Melting°C	U.T.S. N/mm²	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 steels. 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 #	5.0kg Ctn
1.6	RO331601	19.60	RO331625	31.75	RO331650 ★	56.00
2.4	RO332401	19.05	RO332425	30.90	RO332450 ★	54.60
3.2	RO333201	18.30	RO333225	29.50	RO333250 ★	52.10

% Metal Composition	Melting°C	U.T.S. N/mm²	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.

BS: 1453 A1, EN 12536: 01

Dia mm	Art #	1kg Pkt	Art #	2.5kgCtn	Art #	5.0kg Ctn
1.6	RO111601	6.75	RO111625	14.70	RO111650 ★	23.65
2.4	RO112401	6.25	RO112425	13.80	RO112450 ★	21.70
3.2	RO113201	5.90	RO113225	12.80	RO113250 ★	20.70
4.8					RO114850	23.35

% Metal Composition	Melting°C	U.T.S. N/mm^2	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	46.70
2.5	RO222550	44.20
3.0	RO223050	42.90

% Metal Composition	Melting°C	U.T.S. N/mm^2	Hardness BHN	SIF TIPS Page
0.1 C, 0.1 Si, 1.1 Mn	1450	450	140	134

Flux powder & GasFlux

ALUMINIUM

Powder flux for gas welding and brazing aluminium and its alloys

Art #	225g Jar	Art #	500g Jar
FO140022 ★	13.40	FO140050 ★	20.95

CAST IRON

Powder flux for fusion welding cast iron

Art #	500g Jar
FO090050	14.70

SIFBRONZE

Powder flux for general brazing work

Art #	225g Jar	Art #	500g Jar
FO010022 ★	8.65	FO010050 ★	13.25

SIFSILCOPPER

Powder flux for brazing and welding copper alloys.

Art #	500g Jar
FO070050	17.25

SILVER SOLDER

Powder flux for silver solder operations

Art #	225g Jar	Art #	500g Jar
FO380022 ★	22.70	FO380050 ★	38.40

STAINLESS

Powder flux for fusion welding of stainless

Art #	500g Jar
FO200050	23.35

TOOL TIP/BRAZE STAINLESS

Powder flux for Tool Tipping or brazing stainless with Sifbronze No 1 or No 2

Art #	500g Jar
FO020050	21.85

SIF GASFLUX LIQUID

Specially formulated liquid of Methanol and trimethylborate, which allows fuel gas (acetylene) to absorb flux into the torch flame. It is a flammable liquid UN No 1993 and is supplied in 3 litre plastic containers.

Art #	3L container	Qty	SIF TIPS page
FXGF3L	53.25	4 containers per ctn	131

GASFLUXER - MODEL 69-D

Gas fluxer unit with removeable filling tank.

Art #		SIF TIPS page
FXGF69D	1,138.10	131

SIFLITE Helmet

SIFLITE

SIFlite is a variable-shade, auto darkening welding helmet, with adjustable sensitivity and delay, for MIG, Arc and TIG >50amps. It is comfortable to wear with a large viewing ares.

CE: EN379, EN175, ANSI Z87.1

Art #	4 Helmets per Carton
FXADF913	87.10

Spare lens

5 x Inner Protection Lens for SIFlite

Art #	Pkt
FXADF10347	9.60

Spare lens

10 x Outer Protection Lens for SIFlite

Art #	Pkt
FXADF11090	8.64

Guide for number of rods per kilo

ROD LENGTH 1000mm

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

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 STL

SIFTRODE 6013

General purpose mild steel electrode.

CE EN13479

AWS A5.1: E 6013

Dia mm	Art #	2.0kg Pkt	Art #	5.0kg Ctn	Pcs/Pkt
1.6	RE601602 ★	30.95			285
2.5			RE602550 ★	17.25	265
3.2			RE603250 ★	16.30	170
4.0			RE604050 ★	16.30	115

SIFTRODE 7018

Basic coated low hydrogen electrode.

CE EN13479

AWS A5.1: E 7018

Dia mm	Art #	5.0kg Ctn	Pcs/Pkt
2.5	RE702550 ★	24.00	220
3.2	RE703250 ★	22.70	140
4.0	RE704050 ★	22.70	90

SIFTRODE STAINLESS 316

316 stainless electrode for general work

AWS A5.4: E 316L-16

Dia mm	Art #	2.0kg Pkt	Pcs/Pkt
2.5	RE3162525 ★	63.25	120
3.2	RE3163225 ★	61.50	65

SIFTRODE STAINLESS 312

High Cr/Ni electrode for welding of difficult-to-weld steels.

AWS A5.4: E 312-16

Dia mm	Art #	2.0kg Pkt	Pcs/Pkt
2.5	RE3122525 ★	81.50	125
3.2	RE3123225 ★	79.25	65

SIFTRODE CAST IRON NI

Pure Nickel electrode for repair work on cast iron.

AWS A5.15: E NI-CL

Dia mm	Art #	1kg Pkt	Pcs/Pkt
2.5	RENI2501 ★	104.65	50
3.2	RENI3201 ★	101.45	30

Hilco - Steel STL

HILCO RED EXTRA

Universal electrode for welding in all positions, including vertical downwards. Especially suitable for construction work where the use of one single type of electrode is permissible. Very attractive weld appearance. Suitable for both AC and DC current and will operate with low OCV, min 42v.

AWS: E6013,
EN ISO 2560: E 42 0 RC 11

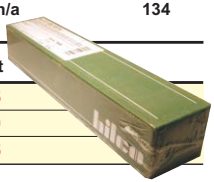
Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.0	H01013020H	4.1kg	390 ★	42.25
2.5	H01013525H	5.0kg	275 ★	24.65
3.2	H01013532H	5.0kg	173 ★	22.85
4.0	H01013540H	5.0kg	112 ★	23.85
5.0	H01013550H	5.0kg	71 ★	29.60

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.12C, 0.4Si, 0.6Mn	n/a	>500	n/a	134

HILCO VELVETA

Electrode for welding in all positions, especially vertical upwards. The quiet and easily controllable molten pool makes it suitable for pipe welding. Easy striking and restriking. Suitable for AC and DC current; will operate on low OCV, min 42V.

AWS: E6013,
EN ISO 2560: E 42 0 RR 32



Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H01033525P	4.8kg	250 ★	43.65
3.2	H01033532P	5.0kg	160 ★	42.40
4.0	H01033540P	4.6kg	100 ★	35.55

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1C, 0.4Si, 0.6Mn	n/a	>510	n/a	134

HILCO VELORA

Slow freezing' electrode for welding in all positions, except vertical down. The quiet and easily controllable molten pool makes it suitable for thin sheet or pipe welding. Easy striking and restriking. Suitable for AC and DC current; will operate on low OCV, min 42V.

AWS: E6013,
EN ISO 2560: E 42 0 RR 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H01053525P	4.1kg	200 ★	36.80
3.2	H01053532P	4.3kg	125 ★	36.55
4.0	H01054540P	5.6kg	80 ★	45.10

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.08C, 0.4Si, 0.6Mn	n/a	>500	n/a	134

HILCO BASIC SUPER

Universal basic coated low hydrogen electrode suitable where high demands on impact value (even at low temperatures) are required. Excellent welding characteristics in all positions (except vertically downwards) on both AC/DC current. Suitable for pipe welding. Excellent X-ray quality. Smooth welding characteristics and an easy slag release.

AWS: E7018-1,
EN ISO 2560: E 46 4 B 32 H5

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H01193525P	4.1kg	200 ★	37.25
3.2	H01193532P	4.1kg	110 ★	32.00
4.0	H01194540P	5.8kg	90 ★	43.70
5.0	H01194550P	5.9kg	60 ★	43.60

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.05C, 0.5Si, 1.0Mn	n/a	> 550	n/a	134

HILCO BASIC 55

Double coated basic electrode for welding in all positions (except vertically downwards) of unalloyed steels. Electrode has excellent weldability, good slag release and smooth weld appearance.

AWS: E7016,
EN ISO 2560: E42 2 RB 12 H10

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H01353525P	3.9kg	200 ★	51.90
3.2	H01354532P	5.3kg	125 ★	58.05
4.0	H01354540P	5.2kg	80 ★	52.70

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.06C, 0.7Si, 0.9Mn	n/a	>510	n/a	134

HILCO REGINA 160

Rutile electrode with a recovery of 160%. Especially suitable for fillet welding and the filling of V-butts. Excellent welding characteristics, self releasing slag. Due to the high recovery and excellent weldability Regina 160 is very economical in usage.

AWS: E7024,
EN ISO 2560: E 42 0 RR 53

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
3.2	H01124532P	5.9kg	90 ★	56.40
4.0	H01124540P	5.7kg	55 ★	50.15
5.0	H01124550P	5.4kg	35 ★	50.95

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1C, 0.4Si, 0.6Mn	n/a	>510	n/a	134

Hilco - Hard Face, Cast Iron, Copper. Aluminium STL NI CU AL

HILCO HARDMELT 600

Basic coated electrode for wear resistant surfacing of steel, cast steel, and high Mn-steel, which are subjected to abrasion, metal to metal wear, impact and/or compression stresses.

DIN 8555: E6-UM-60-GP

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
3.2	H01423532P	4.5kg	130	54.15
4.0	H01424540P	53.9kg	90	69.75

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.5C, 2.3Si, 0.4Mn, 9Cr	n/a	n/a	600	

HILCO HARDMELT 620

Rutile coated electrode for wear resistant surfacing tool steels, subject to metal-to-metal wear up to 550C. Weld metal deposit is a 'high speed steel' (like a tool steel) and can only be machined by grinding.

AWS: E Fe5 B, DIN: E4-UM-60-ST

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
3.2	H01426203532P	4.2kg	92	257.20

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
1.1C, 1 0.1Mn,4.7Cr, 9.8Mo, 2.1W,2.2V	n/a	n/a	n/a	

HILCO PURE NICKEL

Electrode with a pure nickel core for welding grey cast iron, for joining cast irons to other ferrous or non-ferrous metals. Heat affected zone and weld metal easily machinable. Especially suitable for welding contaminated cast iron and repair work.

AWS: E Ni C1, DIN: E Ni BG 22

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H02903525P	2.0kg	116	270.40
3.2	H02903532P	2.0kg	62	268.90

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.5C, 0.1Si, 0.2Mn, 2.3Fe, bal Ni	n/a	n/a		

HILCO NICKEL IRON

Electrode with a nickel iron core for repair welding and joining all types of cast iron. Weld metal and heat affected zone are both easily machinable. Especially recommended for joints in which severe demands are made on the strength of the weld.

AWS: E NiFeC1, DIN: E NiFe BG 22

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H02913525P	2.0kg	108	129.95
3.2	H02913532P	2.0kg	64	125.35

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.9C, 0.7Si, 0.8Mn, 53Ni, bal Fe	n/a	n/a	n/a	

HILCO BRONSIL

Tin-bronze electrode for use on copper, copper alloy, phosphor and tin-bronzes. Also, minor repair work on cast iron and C/Mn steels. Preheat workpiece to approx. 250ºC. Maintain workpiece temperature during welding.

AWS: E CuSn-C, DIN 1733: EL -CuSn7

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
3.2	H02013532P	2.0kg	58	196.00

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
1.5Mn, 0.5Si, 7.5Sn, 0.2Fe, 0.1P, bal Cu	n/a	>280	n/a	132

HILCO ALUMINIL SI5

Aluminium electrode (5% Silicon) for welding, repairing and surfacing forged and cast Al-Si alloys and joining dissimilar aluminium alloys with max. 7% Si content.

AWS: E 4043, DIN 1732: EL AlSi 5

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
3.2	H02033532T	2.0kg	152	92.45

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
5Si, 0.05Mn, 0.05Cu, bal Al	n/a	>160	n/a	126

HILCO ALUMINIL SI12

Silicon alloyed aluminium electrode for welding of all types of aluminium castings and applications, where good colour matching with base materials is important.

AWS: E 4047, DIN 1732: EL-AlSi 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H02023525T	2.0kg	227	118.30
3.2	H02023532T	2.0kg	152	112.65

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
12Si, 0.1Mn, bal Al	n/a	>180	n/a	126

Hilchrome - Stainless SS

HILCHROME 308 R

Rutile coated electrode for welding austentic stainless steel (304). Suitable for dairy and cold storage applications. Self-releasing slag and an excellent weld appearance.

AWS: E308L-17, EN 1600: E 19 9 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt		£/ Pkt
2.0	H023083020T	3.6kg	320	★	144.65
2.5	H023083525T	3.5kg	200	★	107.75
3.2	H023083532T	4.0kg	120	★	115.30
4.0	H023083540T	4.3kg	85	★	120.95

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.03C, 0.8 Si, 0.8Mn, 19.8 Cr, 10.2 Ni	n/a	>550	n/a	133

HILCHROME 316 R

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.

AWS: E316L-17, EN 1600: E 19 12 3 LR 12

Dia mm	Art #	Pkt Wt	Pcs/Pkt		£/ Pkt
1.5	H023162515	1.7kg	300	★	117.10
2.0	H023163020T	3.6kg	320	★	160.10
2.5	H023163525T	3.5kg	200	★	108.70
3.2	H023163532T	4.1kg	120	★	118.30
4.0	H023163540T	4.3kg	85	★	135.70

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.03C, 0.8Si, 0.8Mn, 18.8Cr, 11.7Ni, 2.7Mo	n/a	>550	n/a	133

HILCHROME 309 R

Rutile coated electrode for welding corrosion resistant and heat resistant Cr/Ni steels, joining dissimilar metals and buffering. Self-releasing slag and an excellent weld appearance.

AWS: E309L-17, EN 1600: E 23 12 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H023093025T	3.6kg	200	136.85
3.2	H023093532T	4.4kg	130	156.90
4.0	H023093540T	4.6kg	90	162.65

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.02C, 0.7Si, 0.7Mn, 22.7Cr, 12.5Ni	n/a	>550	n/a	133

HILCHROME 309Mo R

Rutile coated electrode for joining similar and dissimilar stainless steels, buffering, joining hardenable and difficult -to-weld steels.Self-releasing slag and an excellent weld appearance.

AWS: E309 MoL-17, EN 1600: E 23 12 2 LR 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H023093025MT	3.7kg	200	161.90
3.2	H023093532MT	4.6kg	125	188.90
4.0	H023093540MT	4.7kg	90	187.95

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.02C, 0.7Si, 0.8Mn, 23Cr, 12.5Ni, 2.7Mo	n/a	>750	n/a	133

HILCHROME 312 R

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.

AWS: E312-17, EN 1600:E 29 9 R 32

Dia mm	Art #	Pkt Wt	Pcs/Pkt	£/ Pkt
2.5	H023123025T	3.5kg	200	159.40
3.2	H023123532T	4.2kg	130	178.40
4.0	H023123540T	4.3kg	90	173.80

% Metal Composition	Melting°C	U.T.S. N/mm²	Hardness BHN	SIF TIPS Page
0.1C, 1.2Si, 0.7Mn, 28.5Cr, 9.5Ni	n/a	>800	n/a	133

Over 90 years, Hilco has grown to be both an experienced and modern supplier of high quality welding consumables, covering the needs of welders in over 100 countries worldwide.

Their range of specialist arc electrodes are specified by many fabrication, marine and petrochemical welders for their consistent reliable performance.