

FILLER WELDING WIRES



Tracytec[™]

Smart solutions for welding and polishing of moulds



In the following pages you will find a list of the filler welding wires we carry. The welding wires have different characteristics that should be considered before initiating a welding task.

The wires are identified by the type of steel type they are suitable for, but it is possible to achieve other properties by using a different wire. E.g. a hard 1.3343 wire can prevent tearing when the steel meet on 1.2311, 2312 or 2738.

Our filler wire is suitable for welding with most welding methods such as TIG, MICRO TIG and LASER.

For more information and find the nearest retailer, visit www.tracytec.com.

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1.2083

This wire is suitable for welding 1.2083, STAVAX, S136H, 1.2316, M310, CORRAX-366, MIRRAX, PAK90, POLMAX, RAMAX2, RAMAX8 and ELMAX.

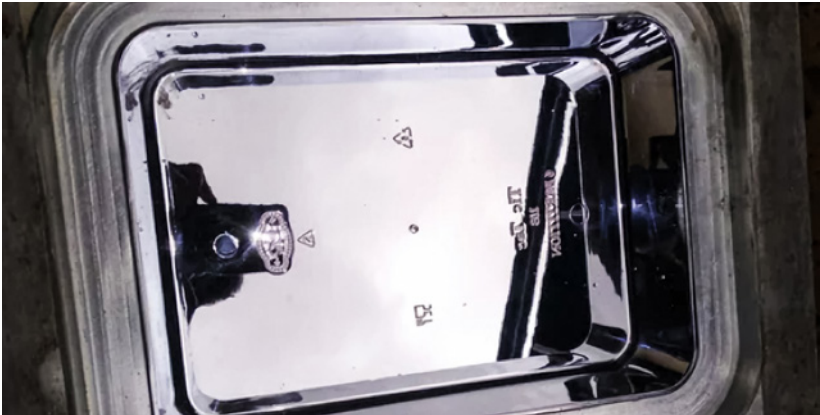
The wire is used when you want to perfect a surface in moulding tools.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 48 and 52 HRC. Tests are carried out in the metallurgy department of the University of Rzeszow, Poland.

C: 0.33	Cr: 12.5	Ni: 0.17	Mn: 0.43	Si: 0.45
S: 0.01	Mo: 0.7	Cu: 0.7	Co: 0.02	P: 0.19

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



420 Surface

This Japanese wire is developed to do surface welding with no color deviation. It is suitable for mirror polished surfaces and textured surfaces where it is possible to achieve finer result than with a standard wire. This wire is suitable for welding 1.2083, STAVAX, MIRRAX, S136H, 1.2316, M310, CORRAX-366, PAK90, POLMAX, RAMAX2, RAMAX8 and ELMAX.

The hardness after welding is dependent on the process and cannot be determined with accuracy.

C: 0.28-0.4	Mn: 0.6-1.0	Si: 0.2-0.8	Cr: 1.4-2.0
Mo: 0.3-0.55	P: 0.3	S: 0.3	

The wire comes in tubes of 10 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●			●						



1.2343

This wire is suitable for welding 1.2343, 1.2344, 8407, H13, DF2F, SKD-61, DIEVAR, UNIMAX and W302.

This wire that has many good qualities and is especially suitable for repairs and changes in aluminium pressure moulds. The wire is almost identical to our 1.2344 and they overlap.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 46 and 52 HRC. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.35	Si: 1.1	Mn: 0.4	Cr: 5.2
Mo: 1.4	V: 0.4	W1.3	

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



1.2344

This wire is suitable for welding 1.2344, 1.2343, 8407, H13, DF2F, SKD-61, DIEVAR, UNIMAX and W302.

This wire has many good qualities and is especially suitable and used for repairs and changes in aluminium pressure moulds. The wire is also almost identical to our 1.2343 and they overlap.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 46 and 52 HRC. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.35	Si: 1.1	Mn: 0.4	Cr: 5.2
Mo: 1.4	V: 0.4	W: 1.3	

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



959 Surface

This wire is suitable for welding 1.2344, 8407, H13, SKD-61, DIEVAR, UNIMAX, Orvar Supreme and W303.

This wire from USA is developed to do surface welding with no color deviation. It is suitable for mirror polished surfaces and textured surfaces where it is possible to achieve finer results than with a standard wire.

The hardness after welding is dependent on the process and cannot be determined with accuracy.

C: 0.32-0.45	Cr: 4.8-5.5	Mn: 0.2-0.5	Mo: 1.1-1.7
Si: 0.8-1.2	V: 0.8-1.2	P: 0.3	S: 0.3

The wire comes in tubes of 10 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●			●						



1.2379

This wire is also suitable for welding 1.2379, ASSAB88, SKD-11, DC53, VIKING, XW-5, K340, SLD-MAGIC, XW-42, GS-2379 and SLEIPNER.

A wire that has many good qualities and is often used for embossing tools and stamps.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 46 and 53 HRC. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.45	Si: 3.0	Mn: 0.4	Cr: 9.3
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The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



1.2738

This wire is also suitable for welding 1.2311, 1.2312, 718, 738, P20, GS2738, GS2311, SP300, MUP, PX88, HPM7, PDS-5, SKT-5, CORRAX-336, PX5 and CALMAX-635.

A widely used wire for repairs in molding tools of toughened steel.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 35 and 38 HRC. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.08	Si: 0.65	Mn: 1.0
Cr: 2.5	Mo: 1.0	Cu: 0.3

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



9210 Surface

This wire is suitable for welding 1.2311, 2711, P20, 718, 738, CALMAX and NIMAX.

This wire from USA is developed to do surface welding with no color deviation. It is suitable for mirror polished surfaces and textured surfaces where you can achieve finer result than with the standard wire.

The hardness after welding is dependent on the process and cannot be determined with accuracy.

C: 0.32-0.45	Cr: 4.8-5.5	Mn: 0.2-0.5	Mo: 1.1-1.7
Si: 0.8-1.2	V: 0.8-1.2	P: 0.3	S: 0.3

The wire comes in tubes of 10 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●			●						



1.3343

This wire is suitable for welding 1.3343 and HSS.

The wire is HSS and is used, among other things, to weld punching tools and other cutting tools where you want a sharp edge with long stand time. The wire is also used for welding of assaults exposed to wear.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 61 and 63 HRC. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.9	Si: 0.25	Mn: 0.3	Cr: 4.3
Mo: 4.9	V: 1.8	W: 6.3	

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock		●	●	●	●	●	●	●	●		●



CU/AL

This wire is suitable for welding heat conductive alloys such as AMPCO and MOLDMAX.

The wire is also good for replenishment tasks in brass and various other purposes. E.g. welding various metals such as brass and steel/stainless steel.

The hardness after welding is dependent on the process and cannot be determined with accuracy. After welding with a TracyTec welding machine, the hardness is between 95 and 98 HBW. Tests have been carried out in the department of metallurgy at the University of Rzeszow, Poland.

C: 0.9	Si: 0.25	Mn: 0.3	Cr: 4.3
Mo: 4.9	V: 1.8	W: 6.3	

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●		●	●	●		



308 Stainless Steel

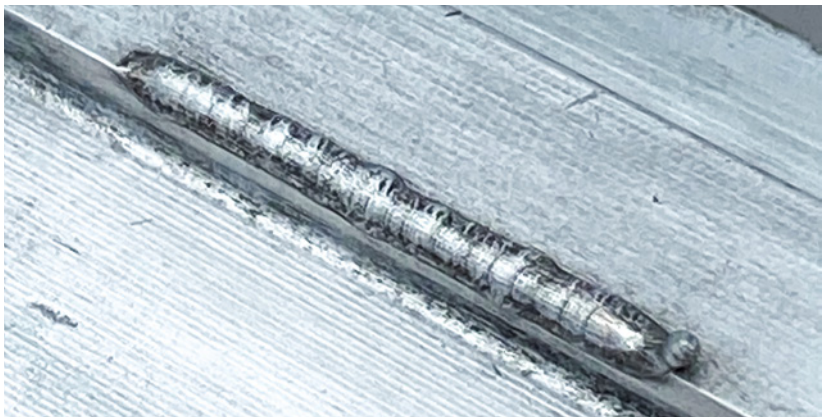
This wire is also suitable for welding similar materials such as 301, 302, 304, 304L, 308, 308L and 347.

A multipurpose wire that is able to solve many welding tasks.

C: 0.015	Cr: 19.6	Ni: 9.6	Mn: 1.7	Si: 0.47
P: 0.24	S: 0.01	Mo: 2.5	CU: 0.18	N: 0.36

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock	●	●	●	●	●	●	●	●	●	●	



4043 Aluminum

This wire is a 5% silicon aluminum wire used for welding 3003, 3004, 5052, 6061 and 6063.

After anodization, the surface becomes gray.

Si: 5	Fe: 0.3	Cu: 0.05	Mn :0.04	Cr: 0.05
Zn: 0.05	Be: 0.0002	Ti: 0.005	Al: Residue	

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock		●	●	●	●				●		



4047 Aluminum

This wire is a silicon alloy aluminum wire developed for aluminium with a lower melting point but a higher flow capacity than 4043. It leaves more silicon in the weld, minimizes heater and provides increased breaking strength in the weld.

Si: 11-13	Fe: 0.3	Cu: 0.05	Mg: 0.05	Zn: 0.1
Be: 0.0003	Ti: 0.005	Al: Residue	Cr: 0.05	Mn: 0.05

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock		●	●	●	●						



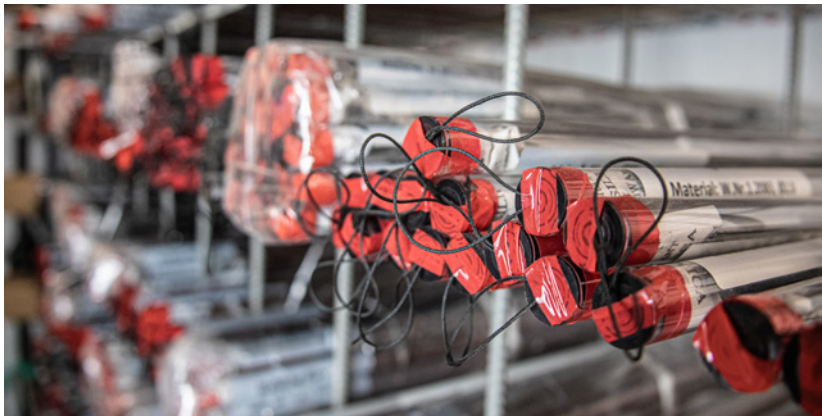
5356 Aluminum

This wire is a 5% magnesium aluminum wire which can be used to weld most aluminum alloys such as 5050, 5052, 5083 and 5454. It has good corrosion resistance for salt water. The surface after anodization is white.

Si: 0.1	Fe: 0.3	Cu: 0.05	Mg: 5	Mn: 0.05-0.2
Cr: 0.15	Zn: 0.09	Be: 0.0008	Ti: 0.1	Al: Residue

The wire comes in tubes of 100 grams, 500 mm length and in the following diameters:

Ø	0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.6	2.0	2.5
Stock		●	●	●	●						



Stock overview

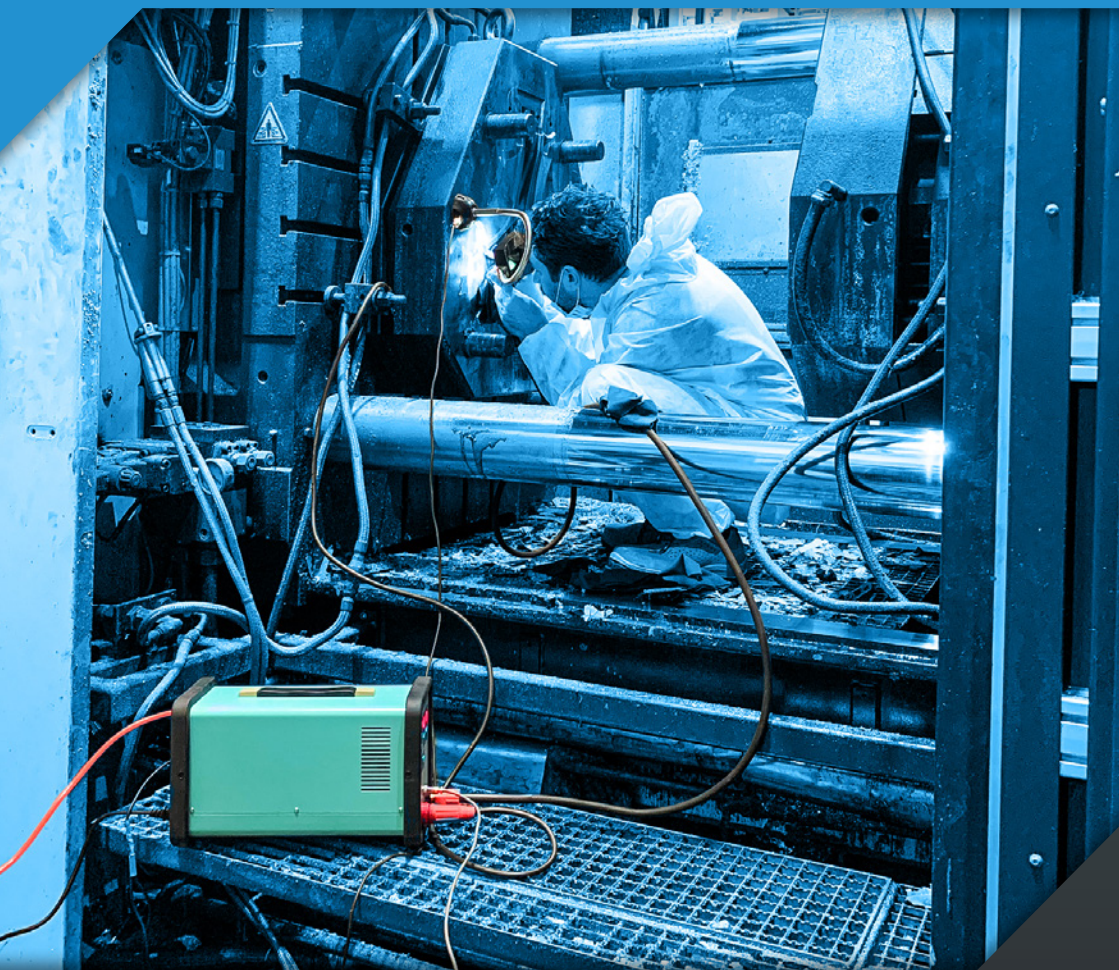
	1.2083	1.2343	1.2344	1.2379	1.2738	1.3343	420	959	9210	CU/AL	308	4043	4047	5356
							Surface				SS	Aluminum		
Ø 0.2	●	●	●	●	●		●	●	●	●	●			
Ø 0.3	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Ø 0.4	●	●	●	●	●	●				●	●	●	●	●
Ø 0.5	●	●	●	●	●	●				●	●	●	●	●
Ø 0.6	●	●	●	●	●	●	●	●	●	●	●	●	●	●
Ø 0.8	●	●	●	●	●	●					●			
Ø 1.0	●	●	●	●	●	●				●	●			
Ø 1.2	●	●	●	●	●	●				●	●			
Ø 1.6		●	●	●	●	●				●	●	●		
Ø 2.0	●	●	●	●	●						●			
Ø 2.5						●								

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