



# **WELDING CONSUMABLES & AUXILIARIES**

**"WORLD CLASS PRODUCTS"**

# STANVAC INTERNATIONAL LTD

**Stanvac International Ltd.** was established in the year 1994. A full range of welding consumables - fabrication, stainless steel, low-heat input repair & reclamation welding electrodes, welding auxiliaries & Industrial chemicals.

- ★ Premium quality features.
- ★ World class performance, matching /exceeding best in the world.
- ★ Wide range of protect in one basket.
- ★ Customer base in over 80 countries.
- ★ Durability.



PLANT-I,  
MANESAR



PLANT-II,  
GURGAON



Electrode Production



Stainless Steel Wire  
Drawing Lines



Stainless Steel MIG Wire Lines



Stainless Steel Fine Wire



Stainless Steel Fine Wire



Multi-Alloy Spectro



FCAW Line



Cladded Wear Plates Line



## WIDE RANGE OF APPROVALS

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### INTERNATIONAL



### NATIONAL



...And many more

# STAVINOX RANGE OF WELDING ELECTRODE

## A) E 6010, E 6013, E 7018, E7018-1... Series

- ★ Full range. Multiple variants in E 6013 & E 7018 /E 7018-1, so as to suit different customer needs.
- ★ Excellent re-strike & other welding characteristics.
- ★ E 7018 /E 7018-1 : Ultra low diffusible hydrogen limits,<4ml /100gms of weld deposit.
- ★ Best in class mechanical properties
- ★ Best in class packaging for minimum transit flux damage /breakage.



Product Name	Classification	Mechanical Properties of Weld Metal (Typical)					Unique Feature
	AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J)	Welding Conditions	
1 STAVINOX 6010	E 6010	≥380	450-550	≥24	≥47 at -30°C	DC(+)	Excellent all position electrode. Best suitable for pipes and pipelines welding. Excellent mechanical properties in class.
2 STAVINOX 6011	E 6011	≥380	450-550	≥24	≥47 at -30°C	AC;DC+	Excellent all position electrode. Best suitable for pipes and pipelines welding. Excellent mechanical properties in class.
3 STAVINOX 6013	E 6013	≥380	470-540	≥24	≥70 at 0°C	AC;DC±	Very soft arc, minimum spatter, smooth fine rippled radiographic weld bead. Superior slag detachability. Excellent impact notch toughness at 0°C.
4 STAVINOX 6013 VD	E 6013	≥380	470-540	≥24	≥60 at 0°C	AC;DC±	Rutile-Cellulosic exceptionally suitable for vertical down welding. Excellent gap bridging.
5 STAVINOX 6013 S	E 6013	≥420	480-540	≥24	≥60 at 0°C	AC;DC-	Ultra smooth weldability. Especially suited for thick section fillet joints. Excellent arc stability even at low currents.
6 STAVINOX 6013 SF	E 6013	≥450	480-540	≥24	≥60 at 0°C	AC;DC-	Ultra smooth weldability. Very smooth fusion with excellent slag detachability. Especially suited for thick section fillet joints. Excellent arc stability even at low currents.
7 STAVINOX 6013 M	E 6013	≥400	470-540	≥24	≥70 at 0°C	AC;DC±	Rutile medium coated, finely rippled smooth weld bead. Superior slag detachability. Excellent arc striking and restriking.
8 STAVINOX 6013 E	E 6013	≥350	450-510	≥24	≥55 at 0°C	AC;DC-	Rutile type suitable for all positions. Good arc striking and restriking. Radiographic quality weld deposit.
9 STAVINOX 7016	E 7016-H4	≥410	510-640	≥26	≥90 at -30°C	DC+;AC	Excellent weldability. Self peeling slag. Excellent mechanical properties.
10 STAVINOX 7016 S	E 7016-1-H4	≥450	550-640	≥30	≥70 at -45°C	DC+;AC	Ultra smooth finely rippled weld bead. Less than 4.0 ml diffusible hydrogen. Excellent impact notch toughness in class.
11 STAVINOX 7016-A1	E 7016-A1-H4	≥420	510-640	≥24	≥47 at -20°C	DC+;AC	Ultra smooth finely rippled weld bead. Less than 4.0 ml diffusible hydrogen. Excellent for C - 0.50% Mo Steels.
12 STAVINOX 7018*	E 7018-H4	≥450	550-620	≥28	≥80 at -30°C	AC;DC+	Excellent weldability. Best in class mechanical properties. Less than 4.0 ml diffusible hydrogen level.
13 STAVINOX 7018-G	E 7018 G-H4	≥400	510-650	≥24	≥70J at -60°C	AC;DC+	Excellent weldability. Tough and crack free joints.
14 STAVINOX 7018 S*	E 7018-1-H4	≥450	550-620	≥30	80 at -45°C	AC;DC+	Ultra smooth finely rippled weld bead. Less than 4.0 ml diffusible hydrogen level.

Product Name		Classification	Mechanical Properties of Weld Metal (Typical)					Unique Feature
		AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J)	Welding Conditions	
15	STAVINOX 7018-A1	E 7018-A1-H4	≥450	520-620	≥26	120J at -20°C	AC;DC+	Excellent weldability. Best suited positional welding. Excellent creep resistant.
16	STAVINOX 8018-G	E 8018-G	≥460	560-680	≥30	>47 at -50°C	AC;DC+	Excellent toughness and formability. Highly crack resistant joint welding.
17	STAVINOX 8018-B2	E 8018-B2	≥460	550-650	≥20	>47 at +20°C	AC;DC+	Ultra smooth finely rippled bead. Best in class mechanical properties.
18	STAVINOX 9018-B3	E 9018-B3	≥550	620-750	≥20	>47 at +20°C	AC;DC+	Excellent weldability and mechanical properties.
19	STAVINOX 9018-G	E 9018-G	≥550	620-720	≥20	≥47J at -50°C	AC;DC+	Excellent weldability extra low hydrogen, self peeling slag, best in class mechanical properties.
20	STAVINOX 9018-M	E 9018-M H4	540-620	650-700	≥26	≥47J at -50°C	AC;DC+	Extra Low hydrogen. Tough and crack free welded joints. Excellent mechanical properties.
21	STAVINOX 10018-D2	E 10018-D2-H4	≥630	700-850	≥22	40 at -50°C	AC;DC+	Smooth finely rippled weld bead. Excellent impact notch toughness at -50°C. Recommended for critical security welding applications.
22	STAVINOX 10018-G	E 10018-G-H4	≥680	760-850	≥18	≥47 at -50°C	AC;DC+	Superior weldability, concentrated arc, smooth weld bead, self releasing slag.
23	STAVINOX 11018-G	E 11018-G-H4	≥720	≥780	≥16	≥27 at -51°C	AC;DC+	Superior weldability, concentrated smooth arc, all positions, crack free joints.
24	STAVINOX 11018-M	E 11018-M-H4	>730	775-850	≥20	≥47 at -50°C	AC;DC+	Excellent weldability. Best in class mechanical properties.

\* E 7018 Smooth Burning, E 7018 Excellent Positional, E 7018 125% Recovery, & 7018-1 with 125% Recovery are also available.

## B) STAINLESS STEEL WELDING ELECTRODES

### ELECTRODES

- ★ Perfect FULL LENGTH welding
- ★ Self releasing slag
- ★ Low moisture absorption
- ★ Perfect re-striking
- ★ Best in class welding & packaging

### MIG /TIG WIRES

- ★ Warrantied Chemistry
- ★ Superior Cast & Helix Control
- ★ Superior Feedability
- ★ Superior Cleanliness
- ★ Superior Packaging

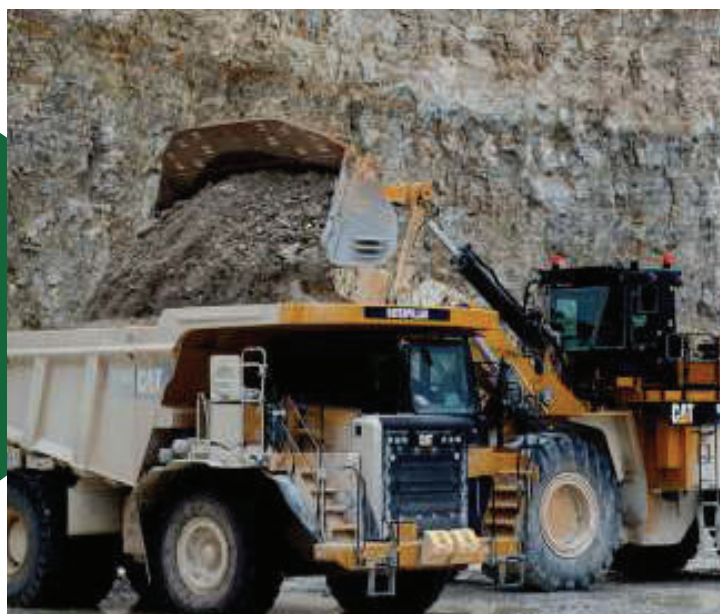
Product Name		Classification	Mechanical Properties of Weld Metal (Typical)					Unique Feature
		AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J)	Welding Conditions	
25	STAVINOX 307	E 307L-16	—	≥600	≥35	≥75 at RT	AC;DC+	Austenitic structure, rutile type, excellent weldability. Excellent machinability.
26	STAVINOX 308H	E 308H-16	—	600	37	≥55 at RT	AC;DC+	Smooth weldability. Suitable for high temperature applications.
27	STAVINOX 308L-15	E 308L-15	—	≥550	≥40	≥47 at -196°C	DC+	Superior weldability, self peeling slag best suitable for pipe welding. Impact passes at 196°C.
28	STAVINOX 308L*	E 308L-16	—	610	44	60 at RT	AC;DC+	LMA type coating, superior weldability without spatter, self peeling slag. Best in class mechanical properties.
29	STAVINOX 309Cb	E 309Cb-16	—	590	40	75 at RT	AC;DC+	Excellent resistance to chemical corrosion and heat. Weldability with spatter free arc, self -releasing slag.
30	STAVINOX 309L*	E 309L-16	—	600	≥35	60 at RT	AC;DC+	Excellent weldability, self peeling slag. Best in class mechanical properties. Best for joining dissimilar steels.
31	STAVINOX 309L-15	E 309L-15	—	≥550	≥30	60 at RT	DC+	Excellent weldability. Best in class mechanical properties.

Product Name	Classification	Mechanical Properties of Weld Metal (Typical)					Unique Feature
	AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J)	Welding Conditions	
32 STAVINOX 309LMo	E 309LMo-16	—	600	35	65 at RT	AC;DC+	Highly crack resistant. Soft fusion, nice aspect of the bead, slag lifts by itself
33 STAVINOX 310	E 310-16	—	620	35	75 at RT	AC;DC+	Austenitic structure, rutile type, excellent weldability.
34 STAVINOX 312*	E 312-16	>500	>800	>20	70 at RT	AC;DC+	Superior weldability. Excellent crack, heat and shock resistant, highest tensile strength with elongation in class.
35 STAVINOX 316L*	E 316L-16	—	>590	≥35	60 at RT	AC;DC+	Superior weldability, finely rippled bead, self peeling slag. Best in class corrosion resistant.
36 STAVINOX 316L-15	E 316L-15	—	570	40	≥50 at -60°C	DC+	Superior weldability, self peeling slag, controlled fluidity, best for all position welding. Impact passes at -196°C.
37 STAVINOX 317L	E 317L-16	>400	590	36	50 at RT	AC;DC+	Excellent weldability. Smooth arc, finely rippled weld bead, self releasing slag.
38 STAVINOX 318-16	E 318-16	450	590	35	65 at +20°C	AC;DC+	Excellent intergranular corrosion resistant, good weldability, self peeling slag.
39 STAVINOX 347	E 347-16	—	590	40	60 at RT	AC;DC+	Soft fusion, without spatters, very easy slag removal, exceptional weld bead appearance, easy restriking.
40 STAVINOX 347-15	E 347-15	—	590	40	≥47 at -60°C	DC+	Controlled fluidity, superior weldability, self peeling slag, superior intergranular corrosion resistant.
41 STAVINOX 385	E 385-16	>370	>570	>35	≥70 at +20°C	AC;DC+	Fully austenitic, highly corrosion resistant. Good weldability in all positions, except vertical down.
42 STAVINOX 2209-16*	E 2209-16	>500	>700	>25	≥47 at -40°C	AC;DC+	Corrosive resistant duplex-steels. Excellent resistant to intergranular corrosion, pitting and stress corrosion conditions.
43 STAVINOX 2594-16*	E 2594-16	>650	>800	>20	≥47 RT	AC;DC+	Super-duplex stainless steels. Excellent resistant to pitting and crevice corrosion. Excellent weldability, spatter free arc, very smooth bead appearance.
44 STAVINOX 410	E 410-15	≥250	≥520	≥22	—	AC;DC+	Heavy coated low hydrogen type. Excellent weldability.
45 STAVINOX 410NiMo	E 410NiMo-15	≥600	≥850	≥15	—	DC+	Basic coated. Superior weldability. Excellent resistance to abrasion.

\* -17 designation are also available.

\* E 308-16, E 309-16, E 316-16, E 309 Mo-16 are also available.

## C) HARDFACING, CAST IRON & NICKEL ALLOYS





46	STAVINOX 35RC	DIN 8555: E1-UM-350	—	—	—	—	AC;DC+	Hardness : 37-40 HRc Rutile type.
47	STAVINOX MN	DIN 8555: ~E7-UM-200KP	—	—	—	—	AC;DC+	Heavy basic coated austenitic manganese alloyed electrode. Hardness (as welded) : 180-220(BHN) Hardness (work condition) : 400-450(BHN)
48	STAVINOX 55RC	DIN 8555: E6-UM-60P	—	—	—	—	AC;DC+	Hardness : 57-60 HRc Rutile type.
49	STAVINOX 55LH	DIN 8555: E6-UM-60P	—	—	—	—	AC;DC+	Hardness : 57-60 HRc Basic coated.
50	STAVINOX 60RC	DIN 8555: E6-UM-60-S	—	—	—	—	AC;DC+	Hardness : 58-60 HRc Rutile type.
51	STAVINOX NiFe	E NiFe-C1	300-400	400-550	≥15	—	AC;DC+	Graphite basic coated. Ferro-Nickel alloy. Good bonding and flow of the weld metal. Good machinability.
52	STAVINOX ENIFE-C1	E Ni-CI	260-410	300-450	≥3	1	AC;DC+	Excellent machinability. Pure nickel electrode. Smooth and intensive arc. Easy slag removal.
53	STAVINOX NiCu7	E Ni-Cu-7	230	490	32	—	DC+	Universal monel repairing, joining, problem solver. Weld metal corrosion resistant to sea water, salts and reducing acids.
54	STAVINOX NiCrFe-2	E NiCr Fe-2	>400	>600	40	≥47 at -196°C	DC+	Excellent out of position welding. Excellent corrosion resistant even at elevated temperatures.
55	STAVINOX NiCrFe-3	E NiCr Fe-3	>420	>700	43	≥47 at -196°C	DC+	Excellent out of position welding. Excellent corrosion resistant at normal elevated temperatures.
56	STAVINOX NiCrMo-3	E NiCr Mo-3	>420	>760	>30	90 at -196°C	AC;DC+	Superior weldability. Fully austenitic, excellent resistance against corrosive media.

## D) ER 70(S) WELDING WIRES MIG & TIG



### Grade : ER 70S - 6 (MIG Wire)

Size in mm :	0.8, 0.9, 1, 1.2
Size in inch :	030, 035, 037, 045, 1/16
Spool Type :	Sd300, Sd200, Sd100
Pack Size in kg :	15, 12.5, 10, 05, 01
Pack Size in LBS :	33, 25, 10, 05

### Grade : ER 70S - 6 (TIG Wire)

Size in mm :	0.8, 0.9, 1, 1.2, 1.6, 2.4, 3.2, 4, 5
Size in inch :	030, 035, 037, 045, 1/16, 3/32, 5/16
Tube Type :	TIG Tube
Pack Size in kg :	05
Pack Size in LBS :	10
Length in Meter :	1
Length in Inch :	914

57	STAVINOX MIG 70(S)	ER 70 S-6	≥420	500-640	≥24	≥47 at -30°C	DC(+)
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## E) ALUMINIUM MIG / TIG WELDING WIRE



### MIG WIRE

Size in mm :	0.8, 1.00, 1.20, 1.60
Size in Inch :	030, 035, 037, 045, 1/16
Spool Type :	SD300
Pack Size in kg :	7
Pack Size in LBS :	15.43

### TIG WIRE

Size in mm :	0.8, 1.00, 1.20, 1.60, 2.4, 3.2, 4
Size in Inch :	030, 035, 037, 045, 1/16, 3/32, 5/16
Packing Type :	Plastic Tube
Pack Size in kg :	5
Pack Size in LBS :	10

# STAVI-CHEM SERIES

## AEROSOL SPRAY

- ★ Stavi-chem Anti Spatter 1001
- ★ Stavi-chem Developer 1002
- ★ Stavi-chem Penetrator 1003
- ★ Stavi-chem Gel 1004
- ★ Stavi-chem Multi Use Cleaner 1005
- ★ Stan-chem Bright Galva 1006

## INDUSTRIAL COATING LUBRICANT

- ★ Floor Coating
- ★ Electrical Insulation Coating
- ★ Ceramic Coating
- ★ Anti-Corrosion Coating

## ACTIVE AND PASSIVE FIRE COATING

- ★ Cable Coating EC 43

## PACKING & PEELING



For more information please visit our website [www.stanvacinternational.com](http://www.stanvacinternational.com)

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