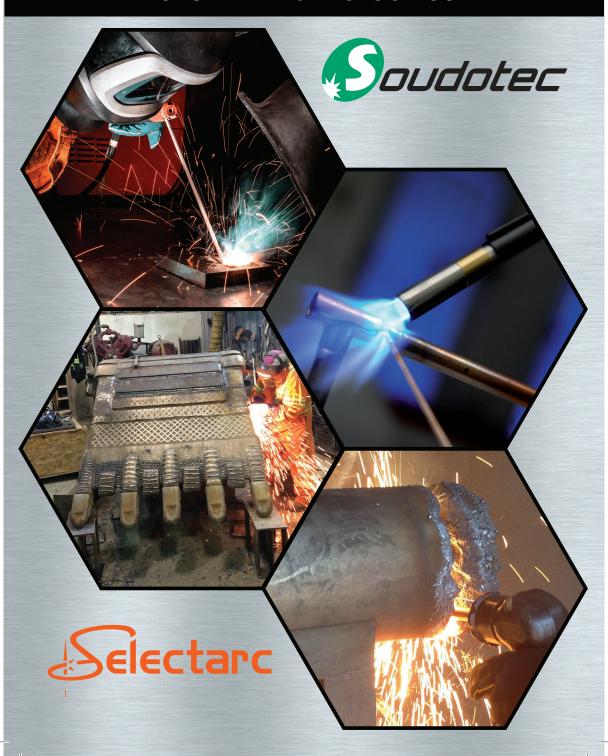


\$11,95 2022 EDITION 1-800-361-9097

www.fsh-welding.ca

SPECIALIZED WELDING AND BRAZING ALLOYS AND TECHNOLOGY GUIDE





Specialized welding and brazing alloys and technology guide 2022 edition

WELDING CAST IRON & NICKEL ALLOYS	Section 1
WELDING MILD STEEL & ALLOY STEEL	Section 2
REBUILDING & HARDFACING	Section 3
WELDING STAINLESS STEEL	Section 4
WELDING COPPER ALLOYS	Section 5
BRAZING/SOLDERING WITH SILVER ALLOYS	Section 6
WELDING LIGHT METAL (AI, Zn, Mg) AND TITANIUM ALLOYS	Section 7
CUTTING, CHAMFERING & PIERCING	Section 8
HOT METALLIZING (Fusetec) & COLD METALLIZING (Bondtec)	Section 9
BRAZING/SOLDERING FLUXES AND MISCELLANEOUS PRODUCTS	Section 10
RODS AND ELECTRODES SELECTION GUIDE, WELDING TERMS AND DEFINITIONS AND MISCELLANEOUS APPENDED	Section 11

For technical assistance or for ordering : FSH Welding Canada Inc.

2204, 46th avenue Lachine (Mtl) Québec Canada H8T 2P3 Tel.: (514) 631-7670 1-800-361-9097 Fax: (514) 636-3339 info@fsh-welding.ca www.fsh-welding.ca © 2022 FSH Welding Canada Inc.



Membre de / Member of SELECTARC GROUP - FRANCE

ISBN 978-2-9806912-7-0

Legal deposit - Bibliothèque et Archives nationales du Québec, 2022 Legal deposit - Library and Archives Canada, 2022

Printed in Canada

Edited by:

FSH Welding Canada Inc.

2204, 46th avenue Tel.: (514) 631-7670 info@fsh-welding.ca Lachine (Mtl) Québec 1-800-361-9097 www.fsh-welding.ca

Canada H8T 2P3 Fax: (514) 636-3339 © 2022 FSH Welding Canada Inc.



Membre de / Member of SELECTARC GROUP - FRANCE

History of Technology in Maintenance and Repair

Founded in **1979**, under the name **Soudotec**, by specialists in welding maintenance and repair, the company today occupies a privileged position in its field.

Over the years, **Soudotec** has adapted to an ever changing market while keeping up with state of the art technology and more and more specific situations. The company has built a vast clientele throughout Canada. The company's reputation has provided global solutions reaching as far as Europe!

In 2003, the company became **Selectarc Canada** in association with the French group, in expansion, FSH Welding Group has three welding product manufacturing plants and are present in more than 80 countries. **Selectarc Canada** has seen a strong growth across Canada.

In 2007, in cooperation with the group, the company reinforces its corporate image and becomes **FSH Welding Canada**. The global objective of our group is to unify in each country the synergies of our research, development and manufacturing capabilities. This is being done to provide to our customers up to date developments of new products and diversified applications. This new global organization of our group is to be more present and communicative with our partners for a greater service of quality.

Today, **FSH Welding Canada** always continues to grow and answer the needs of their growing customer base, in helping them use their existing equipment to the maximum. Thanks to the superiority of its products, its rigorous quality policy, its management quality and its service with highly qualified personnel, **FSH Welding Canada** establishes new norms in production welding and maintenance and repair for your highest requirements.



TABLE OF CONTENTS

SOUDOTEC / SELECTARC'S PRODUCT NUMERICAL INDEX	00-03
FSH Welding Canada QUALITY.	00-06
FSH Welding Canada PRODUCTS AND SERVICES	00-06
SECTION 1: WELDING CAST IRON & NICKEL ALLOYS Technical information and selection guides	. 01-01 . 01-07
SECTION 2: WELDING MILD STEEL & ALLOY STEEL Technical information and selection guide	
SECTION 3: REBUILDING & HARDFACING Technical information and selection guide	
SECTION 4: WELDING STAINLESS STEEL Technical information and selection guide. Electrodes and flux-cored wire for stainless steel.	04-01 04-05
SECTION 5: WELDING COPPER ALLOYS Technical information and selection guide	
SECTION 6: BRAZING/SOLDERING WITH SILVER ALLOYS Technical information and selection guide	
SECTION 7: WELDING LIGHT METAL (AI, Mg, Zn) AND TITANIUM ALLOYS Technical information and selection guide	07-01 07-05
SECTION 8 : CUTTING, CHAMFERING & PIERCING Technical information and selection guide	
SECTION 9: HOT METALLIZING (Fusetec) & COLD METALLIZING (Bondtec) Technical information and selection guide	
SECTION 10: BRAZING/SOLDERING FLUXES & MISCELLANEOUS PRODUCTS Technical information. Fluxes and miscellaneous products	
SECTION 11: RODS AND ELECTRODES SELECTION GUIDE	

INDEX

SOUDOTEC / SELECTARC'S PRODUCT NUMERICAL INDEX					
SECTION	PRODUCT PAGE	SECTION	PRODUCT PAGE		
3	Co1 - 1G	1	165		
3	Co6 - 6G	1	168 01-12		
8	G12	1	169 BF 01-13		
7	TBM 12 NCs 07-07	1	179 01-14		
4	13/4 / TIG/MIG 410NiMo 04-12	1	189 SP / 189 BF 01-15		
3	H1303-09	1	Ni 182 01-22		
3	HB 14Mn 03-50	1	Ni 190 / TIG/MIG Ni 190 01-21		
3	FC 14Mn 03-51	2	206		
3	P20	8	212 SP		
4	24/12 Mo / TIG/MIG 24/12M 04-12	2	214		
4	25/20 R / TIG/MIG 25/2004-12	2	220		
3	HB 25 03-52	2	222		
3	FC 25 03-53	2	222 SP 02-13		
3	HB 40 03-54	2	225		
3	FC 40 03-55	2	225 XP02-15		
3	HB 50 03-40	2	230		
3	FC 50 03-41	4	253 MA-AC/TIG/MIG 20/10MA 04-13		
2	FCW 56 R 02-35	2	265 02-17		
5	56 FC	2	267 02-18		
5	57 FC	2	271 02-19		
1	Ni 59 / TIG/MIG Ni 59 01-22	2	275		
1	60	1	Ni 276 / TIG/MIG Ni 276 01-21		
3	HB 60	2	277		
3	FC 60	4	29/9 / TIG/MIG 29/9 04-12		
3	HRT 60 03-44	2	298 02-22		
3	HB 63 03-45	3	M300 03-59		
3	FC 63 03-46	3	HB 300B03-58		
3	FC 63 Ti 03-47	4	FC 308L04-09		
3	HB 65 03-48	4	308L-1604-05		
3	FC 6503-49	4	308L-1704-06		
2	B 68 02-36	4	308HB / TIG/MIG 20/10C 04-13		
2	B 69 02-36	4	MIG 308LSi 04-10		
7	70 07-06	4	TIG 308LSi 04-11		
7	75 07-08	4	FC 309L04-09		
2	B 75Cu 02-36	4	309L-1604-05		
7	B 76 07-09	4	309L-1704-06		
2	B 77 02-36	4	MIG 309LSi 04-10		
7	78 07-09	4	TIG 309LSi		
1	Ni 82 01-22	4	310H		
2	B 84 02-36	4	FC 316L04-09		
1	B 90 / TIG/MIG B9001-21	4	316L-1604-05		
1	B 91 / TIG/MIG B9101-21	4	316L-1704-06		
1	B 94 / TIG/MIG B94 01-21	4	316L-VD		
1	B9601-21	4	MIG 316LSi 04-10		
1	99 / 99 BF	4	TIG 316LSi		
1	155 B01-09	4	317L-17 / TIG/MIG 18/15 04-12		
1	160 01-10	3	329		

INDEX

SOL	JDOTEC / SELECTARC'S I	PRODUC	T NUMERICAL INDEX
SECTION	PRODUCT PAGE	SECTION	PRODUCT PAGE
3	330	2	FC 8206G 02-26
3	333	2	FC 8220G 02-27
3	333 SP	2	M8221 02-28
3	336	2	MC 8225G 02-29
3	340	2	FC 8225 XP02-30
3	342	2	FC 8226G 02-31
3	344	2	FC 8265G
3	345	2	FC 8271G 02-33
3	346	2	FC 8277G
4	347-17/TIG 20/10 NB/MIG 20/10NBS . 04-12	3	MC 8306G
3	359	3	FC 833003-28
Δ	385 / TIG/MIG 20/25CU 04-13	3	FC 8330 SP
3	390	3	FC 833203-30
3	397	3	FC 8332W
3	398	3	FC 8332WSH 03-31
2	399	3	FC 833303-31
J	416	3	FC 834003-34
1 2		3	FC 834203-35
2 5	M500	3	FC 8342W03-36
ე 	516	3	
) F	536))	MC 8345G 03-37
5	561 / 563))	MC 8398G 03-38
3	M600	3	MC 8399G
1	Ni 617 / TIG/MIG Ni 617 01-22	10	BlueClean
1	Ni 625 / Ni 625BF 01-22	10	Brazing Fluxes 10-02
1	780 07-10	7	EasyMIGAlu
1	T792 07-11	10	EcoPassiv 10-05
1	1690	10	EZWeld 10-10
1	1690 SP 01-19	3	HB MnCr
1	FC 1690 G 01-20	3	FC MnCr
4	2209 / TIG/MIG 220904-12	5	MIG CUuSi305-09
4	2509MoWB 04-13	1	Ni A
6	TBW 5034 06-05	1	NiTi3 / TIG/MIG NiTi3 01-21
6	TBW 5045 06-06	10	Neutralizing Paste Neutra 10-09
6	TBW 5056 06-07	10	Pickling Paste Pick 10-07
6	6020 FC	10	Pickling Paste Pick LF 10-08
6	6030 FC	9	Powder Bondtec 09-04
6	6045 FC	9	Powder Fusetec 09-03
6	6157	8	Prime Cut 08-05
6	6800	10	Soldering Fluxes 10-03
6	6804	10	Soudostick Steel 10-11
6	6805	2	Special
6	6806	2	Stud-Xtract02-08
3	8105 - 8108 - 8112 03-26	7	TBW Zinal 4 07-05
1	M8169 SP 01-16	10	Thermagel
2	MC 8189 G	8	Welding and Cutting Underwater 08-08
2	MC 8204G 02-24		5 6
2	FC 8205G		
-	. 0 02000		



FSH Welding Canada Quality

FSH Welding Canada's fixed objective is to constantly improve quality in keeping up with new technology and the needs of today's developing markets. All of Soudotec and Selectarc products are carefully selected and tested to meet specific applications.

In 1998, **FSH Welding Canada** obtained the ISO certification 9002, which proves the efficiency of its quality management service. Still today, **FSH Welding Canada** continues to apply its strict ISO procedures and quality policies with constant development. The two manufacturing plants of FSH Welding group are certified under ISO 9001: 2000.

FSH Welding Canada also assures, continuous training to its engineers and technicians, in the function of technology development and new market requirements. The company provides a team of dynamic technical representatives, qualified and experienced, who work in strict collaboration with a network of specialized distributors.

Our Mission:

To offer first-rate, state-of-the-art welding and brazing products for production and maintenance-repair purposes, along with efficient service from our highly qualified personnel, to ensure the complete satisfaction of our customers.





FSH Welding Canada Products and Services

Every day, dozens of companies like yours, are faced with many problems related to the production or maintenance and repair. It is you then, who address **FSH Welding Canada** for solutions and products adapted for each situation, even the more complex.

Whatever your field of operation, whatever problems you have, **FSH Welding Canada** will advise you precisely so you can act quickly with the best products and results! Every day hundreds of satisfied customers use the prestigiously marked products of **Soudotec** and **Selectarc** for all sorts of applications, even the most complex.

With the two manufacturing plants of the Group, **FSH Welding Canada** has access to hundreds of products in all different categories to answer the needs and requirements of the highest diversity in the welding trade. The group's world-wide objective in manufacturing is to unify in each country all our activities to seek synergies of service and profit our partners.

Endowed with a solid reputation, **FSH Welding Canada** puts at your disposal a renowned technical support and an adapted emergency service. Whatever your problem or questions, **FSH Welding Canada** offers you all the technical attention you need, in person, by telephone, by fax or by electronic mail.

Our first priority is to maintain a large inventory of items to meet the immediate needs of our diversified customers. **FSH Welding Canada** also ensures that all the orders it receives are handled quickly and efficiently.

FSH Welding Canada also offers on-site theoretical and practical training suited to your specific needs in terms of welding maintenance and repair.

This specialized 2015 edition guide of welding products and techniques was designed to help you choose the best welding consumables and the appropriate welding techniques, based on your specific application. You can count on this valuable and reliable reference at all times, and you can also view our Web site at:

www.fsh-welding.ca



For the complete version, please contact us:

- info@fsh-welding.ca
- **+1.800.361.9097**

