schweisskraft
Schweißtechnik

PROFESSIONAL INVERTERS ELECTRODE WELDING MACHINES

Power Factor Correction

- **PFC** is an electrical or electronic circuit that increases the so-called power factor

Generator Friendly

- Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers

Multivoltage Einsatz weltweit

- Regulates the voltage from 110 V - 230 V

VRD safe Voltage Reduction Device

- Voltage reduction in no-load operation

easystick® 141 / 161

230 volt electrode inverter in standard design

- All appliances are built using modern inverter technology
- Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems

Info & Video

OPERATION

1. *Operation indicator light*
2. *Temperature control lamp*
3. *Rotary knob for welding current preselection*

TECHNICAL DATA:

Model		EASY-STICK 141	EASY-STICK 161
Art. no.		1073014	1073016
Technical data:			
Circuit board		unsealed	unsealed
Weldable electrode Ø	mm	1.6 – 3.2	1.6 – 4.0
Setting range	A	10 – 140	10 – 160
Sheet thicknesses	mm	1.0 – 4.0	1.0 – 6.0
Power consumption	A	36.6	36.5
Slow-blow fuse	A	16	16
No-load voltage	V	77.4	69.9
Electrode duty cycle at I_{max}	%	15	25
Electrode Welding current at ED = 100%	A	55	80
Protection class		IP21S	IP21S
Insulation class		H	H
Working temperature	°C	-10~40	-10~40
Electrode power consumption	kVA	4.5	5
Required generator output	kVA	›8.4	›8.4k
Overall performance	kVA	8.4	8.4
Mains plug	A	16	16
Electrical connection ~50 Hz AC	V	230	230
Dimensions (L x W x H) approx.	mm	320 x 135 x 255	320 x 135 x 255
Weight approx.	kg	4.3	4.4
Standard		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m with electrode holder
- Ground cable 16mm²/3m

See our capabilities for yourself and request a personal consultation!

Contact: +49 (0) 951 96 555-501
beratung@schweisskraft.de

ACCESSORIES

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ACCESSORIES	Art. no.
① Transport case	1174050
② Ground cable 4m complete with earth clamp 16 mm², KS 25/9 mm, clamp 200 A	1250215
② Ground cable 4m complete with earth clamp 25 mm², KS 25/9 mm, clamp 200 A	1250224
③ Welding cable 5 m assembled 25 mm²/10-25mm2/9 mm spigot/M8	1250227
④ Welding cable 4 m with electrode holder 16 mm² KS25/9 mm, electrode holder 260 A	1250353
⑤ Welding site equipment 25 mm²; KS 50/Pratica 1/earth clamp 200 A comprises: Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	1240445

craftstick® 161

230 volt electrode inverter in standard design with sealed circuit board

- Built using modern inverter technology
- Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- Suitable for use on generators, e.g. in workshops, harbours, chemical plants, schools, metal construction, on building sites, ships or for farmers
- **Sealed circuit board protects against moisture, salt spray and corrosion, making it also suitable for offshore use**
- **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- Longer duty cycle than the EASY-STICKseries

Generator Friendly

OPERATION

1. *Operation indicator light*
2. *Temperature control lamp*
3. *Rotary knob for welding current preselection*

TECHNICAL DATA:

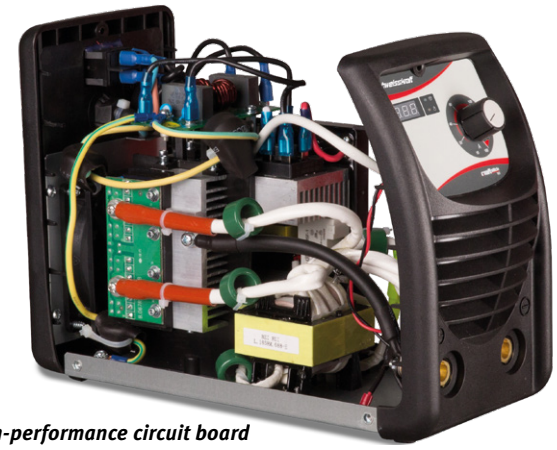
Model		CRAFT-STICK 161
Art. no.		1073161
Technical data:		
Circuit board		sealed
Weldable electrode Ø	mm	1.6 – 4.0
Setting range	A	10 – 160
Sheet thicknesses	mm	1.0 – 6.0
Power consumption	A	36.5
Slow-blow fuse	A	16
No-load voltage	V	75.3
Duty cycle at $I_{max.}$ [40°C] Electrode	%	40
Welding current at 100% duty cycle [40°C] Electrode	A	90
Protection class	IP	21S
Insulation class		H
Working temperature	°C	-10~40
Electrode power consumption	kVA	5.2
Required generator output	kVA	›8.7
Overall performance	kVA	8.7
Mains plug	A	16
Electrical connection ~50 Hz	V	230
Dimensions (L x W x H) approx.	mm	320 x 135 x 255
Weight approx.	kg	4.9
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

Welding force systems bear the **S mark** and comply with standard EN 60 974-1; -10.

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m with electrode holder
- Ground cable 16mm²/3m



Sealed high-performance circuit board

ACCESSORIES

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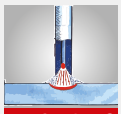
ACCESSORIES	Art. no.
① Transport case	1174050
② Ground cable 4m complete with earth clamp 16 mm², KS 25/9 mm, clamp 200 A	1250215
② Ground cable 4m complete with earth clamp 25 mm², KS 25/9 mm, clamp 200 A	1250224
③ Welding cable 5 m assembled 25 mm²/10-25mm2/9 mm spigot/M8	1250227
④ Welding cable 4 m with electrode holder 16 mm² KS25/9 mm, electrode holder 260 A	1250353
⑤ Welding site equipment 25 mm²; KS 50/Pratica 1/earth clamp 200 A comprises: Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	1240445

craftstick® 161 P / 201 P

Robust 230 V electrode inverter with sealed circuit board for professional use

- Built using modern inverter technology
- Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 23 also generally suitable for outdoor work
- Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- **Sealed circuit board protects against moisture, salt spray and corrosion, making it also suitable for offshore use**
- **Working with PFC:** this enables use on generators
- **VRD** (voltage reduction in no-load operation) equipped
- TIG welding with Lift-Arc ignition
- TIG DC function = enables simple TIG welding with contact ignition
- Precise setting of welding parameters via digital display
- Universally applicable for welding all common electrode types
- The quietly running fans dissipate the heat well from the devices and thus achieve a high duty cycle
- Consistent deposition rate is achieved through constant welding current
- At least 30% duty cycle for all devices
- **All CRAFT-STICKs have the following functions as standard:**
- **Hot Start:** The arc ignites safely and is immediately stable thanks to the automatic, brief increase in welding current
- **Anti-stick** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely.
- This stabilises the arc and the electrode can be processed without any problems



Power Factor Correction

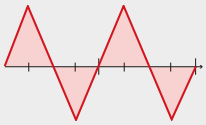
- **PFC** is an electrical or electronic circuit that increases the so-called power factor

Generator Friendly

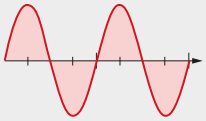
PROTEC 440V — 440V Tested in production 220V

VRD safe

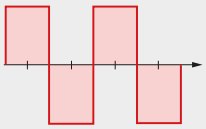
Always the right wave for your task:



AC triangle wave welding output:
- Reduced heat input for the same current setting. Particularly useful for welding thin metal



Alternating current sine wave welding output:
- Traditional AC TIG welding waveform. Quieter, "soft" arc characteristics



AC square wave:
- Focussed arc for maximum penetration, fast welding speed with optimum directional control

OPERATION

1. *Digital display*
2. *Operation indicator light (green)*
3. *Temperature indicator light (yellow)*
4. *E-hand*

5. *VRD = voltage reduction in no-load operation*
6. *TIG DC - function*
7. *Select button*
8. *Rotary knob for welding current preselection*

TECHNICAL DATA:

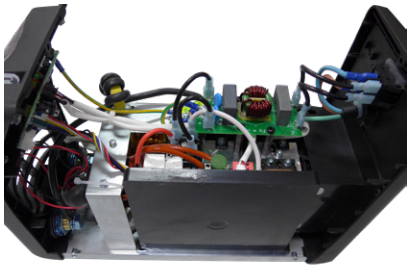
Model		CRAFT-STICK 161 P	CRAFT-STICK 201 P
Art. no.		1073162	1073201
Technical data:			
Circuit board		sealed	sealed
Weldable electrode Ø	mm	1.6 – 4.0	1.6 – 4.0
Setting range for electrode	A	10 – 160	10 – 200
Setting range for TIG DC	A	10 – 160	10 – 200
Sheet thicknesses	mm	1.0 – 8.0	1.0 – 10.0
Power consumption	A	MMA 22.1 / TIG 14.7	MMA 28.8 / TIG 19.5
Slow-blow fuse	A	16	16
No-load voltage	V	MMA 70.6 / TIG 65.6	MMA 68.7 / TIG 65.3
Duty cycle at $I_{max.}$ [40°C] TIG DC	%	30	40
Duty cycle at $I_{max.}$ [40°C] Electrode	%	30	40
Welding current at 100% duty cycle [40°C] TIG DC	A	90	130
Welding current at 100% duty cycle [40°C] Electrode	A	90	130
Protection class		IP21S	IP21S
Insulation class		H	H
Working temperature	°C	-10~40	-10~40
Power consumption TIG DC	kVA	3.4	4.5
Electrode power consumption	kVA	5.1	6.6
Required generator output	kVA	>5.1	>6.6
Overall performance	kVA	5.1 / 3.4	6.6 / 4.5
Mains plug	A	16	16
Electrical connection ~50 Hz	V	230	230
Dimensions (L x W x H) approx.	mm	365 x 150 x 280	365 x 150 x 280
Weight approx.	kg	6.7	6.7
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A	

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

Info & Video

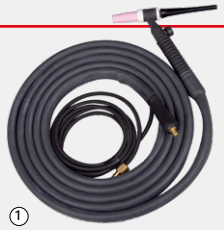
SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m
- Ground cable 16mm²/3m



Sealed high-performance circuit board

ACCESSORIES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ACCESSORY CRAFT-STICK 161 P	Art. no.
TIG torch	
①WP17V ED 4m with gas regulator	1461745
ACCESSORY CRAFT-STICK 201 P	
TIG torch	
WP 26 V/4 m with gas regulator	1462614
ACCESSORIES	
② Transport case	1174050
③ Pressure reducer Argon/CO_2	1700050
Ground cable 4m 25mm², KS50/13mm, clamp 200A	1250225
Ground cable 4m 35mm², KS50/13mm, clamp 400A	1250235
Welding cable 4 m 25 mm², KS50/13 mm, electrode holder 260 A	1250361
Welding cable 4 m 35 mm², KS50/13 mm, electrode holder 400 A	1250362
④ Welding site equipment 25 mm² comprises: Welding cable PVC 5 m with electrode holder and welding cable plug, ground cable PVC 3 m with earth clamp and welding cable plug, slag hammer, wire brush 2-row, hand protection shield polypropylene (CE), welding glass DIN 9, attachment glass 90 x 110 mm, gloves 5-finger	1240445
⑤ Wear parts set comprises: 1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	1100152

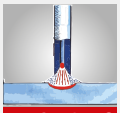
craftstick® 253

400 volt electrode inverter in standard version with sealed circuit board

- Built using modern inverter technology
- Ideally suited for assembly work (on a ladder, on scaffolding, etc.) and, thanks to protection class IP 21S also generally suitable for outdoor work
- Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- **The sealed circuit board provides protection against moisture, salt spray and corrosion, making it ideal for use offshore.**
- TIG welding with Lift-Arc ignition
- **Hot Start:** Increasing the welding current briefly causes the arc to ignite reliably and become stable immediately
- Adjustable hot start and arc force
- **Anti-stick:** if the electrode accidentally sticks, the welding current is automatically reduced, preventing the electrode from annealing
- With TIG DC Liftarc ignition
- **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- **VRD (Volt Reduction Device):** Voltage reduction in no-load operation

Generator Friendly

VRD safe



OPERATION

(1) *Digital display*

(2) *Operation indicator light*

(3) *Temperature control lamp*

(4) *MMA selection button, MMA VRD, Lift-Arc*

(5) *Rotary knob for welding current preselection*

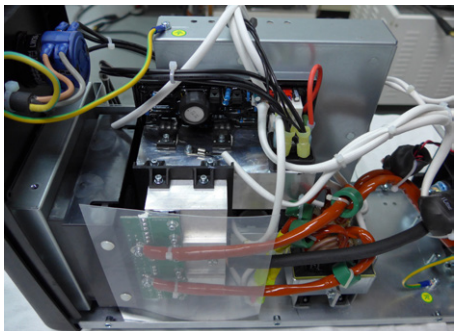
(6) *Rotary control for "Hot Start" setting*

(7) *Rotary control for "Arc Force" setting*

TECHNICAL DATA:

Model		CRAFT-STICK 253
Art. no.		1073253
Technical data:		
Circuit board		sealed
Weldable electrode Ø	mm	1.6 – 5.0
Setting range for electrode	A	20 – 250
Setting range for TIG DC	A	20 – 250
Sheet thicknesses	mm	1.0 – 10.0
Power consumption	A	MMA 17.7 / TIG 13.1
Slow-blow fuse	A	16
No-load voltage	V	MMA 70.1 / TIG 69.4
Duty cycle at $I_{max.}$ [40°C] TIG DC	%	60
Duty cycle at $I_{max.}$ [40°C] Electrode	%	60
Welding current at 100% duty cycle [40°C] TIG DC	A	200
Welding current at 100% duty cycle [40°C] Electrode	A	200
Protection class		IP21S
Insulation class		H
Working temperature	°C	-10~40
Power consumption TIG DC	kVA	6.3
Electrode power consumption	kVA	8.5
Required generator output	kVA	>10
Overall performance	kVA	10 / 7.4
Mains frequency	Hz	50/60
Electrical connection ~50 Hz	V	400 ±10%
Dimensions (L x W x H) approx.	mm	495 x 190 x 350
Weight approx.	kg	12
Standards		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.



Sealed high-performance circuit board

SCOPE OF DELIVERY:

- Welding cable 16 mm² /3m
- Ground cable 16mm²/3m

ACCESSORIES

ACCESSORIES	
① TIG welding torch, gas-cooled WP 26 V / 4 m	1462614
②Pressure reducer Argon/CO_2	1700050
③Welding cable 25 mm², KS50/13 mm, electrode holder 260 A	1250361
③Welding cable 35 mm², KS50/13 mm, electrode holder 400 A	1250362
④Ground cable 4m complete with earth clamp 25 mm², KS50/13 mm, clamp 200 A	1250225
④Ground cable 4m complete with earth clamp 35 mm², KS50/13 mm, clamp 400 A	1250235
⑤ Welding site equipment SPA 35 mm² comprises: 5 metres PVC welding cable with electrode holder and welding cable plug, 3 metres PVC ground cable with earth clamp and welding cable plug, slag hammer, wire brush, polypropylene hand shield (CE), welding glass DIN 9, attachment glass 90 x 110 mm, 5-finger gloves	1240450
⑥Wear parts set comprises: 1x short/medium/long torch cap, 1x gas nozzle size 5/8 mm, size 6/9.8 mm, size 7/11.2 mm, size 8/12.7 mm, size 10/15.7 mm, 1x clamping sleeve 1.6/3.2/4.0/2.4 mm, 1x clamping sleeve housing 1.6/2.4/3.2/4.0 mm, Teflon seal for nozzle	1100152

craftstick® 403 CEL

400 volt electrode inverter for industrial use, suitable for cellulose electrodes

- State-of-the-art inverter technology
- TIG welding with Lift-Arc ignition
- Suitable for use on generators, e.g. in workshops, schools, metal construction, on building sites or for farmers
- **Hot Start:** Increasing the welding current briefly causes the arc to ignite reliably and become stable immediately
- **Anti Stick:** If the electrode accidentally sticks, the welding current is automatically reduced to prevent the electrode from annealing
- Suitable for cellulose electrodes
- **Arc force control:** The internal monitoring of welding current and welding voltage means that short circuits are resolved quickly and safely. This stabilises the arc and the electrode can be processed without any problems
- **VRD (Volt Reduction Device):** Voltage reduction in no-load operation

Generator Friendly

VRD safe

Control cable plug for manual remote control

OPERATION

1. *Display for welding current and other parameters*
2. *Rotary knob for setting the welding current*
3. *Rotary knob for hot start control*
4. *Rotary knob for Arc Force control*
5. *Selection button for electrode, TIG or VRD with display*
6. *Warning light for overvoltage, overcurrent or overheating*
7. *Operating status display*

TECHNICAL DATA:

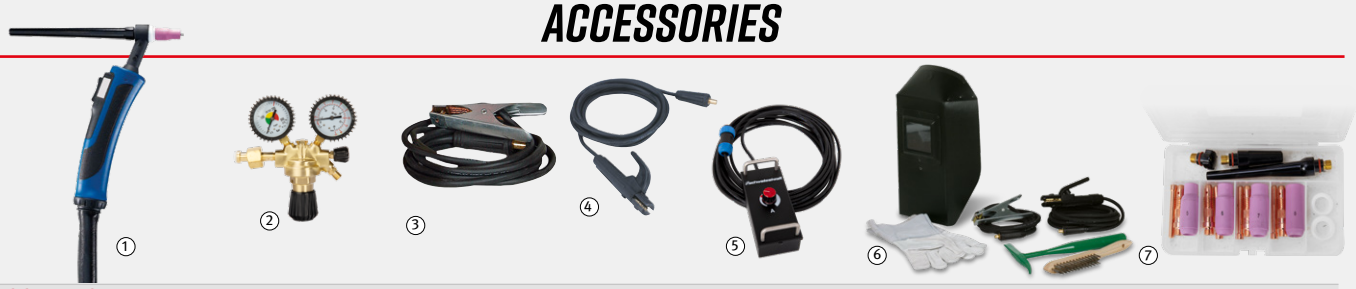
Model		CRAFT-STICK 403 CEL
Art. no.		1073403
Weldable electrode Ø	mm	1.6 – 8.0
Setting range for electrode	A	20 – 400
TIG setting range	A	20 – 400
Duty cycle at $I_{max.}$ [40°C] Electrode	%	60
Duty cycle at $I_{max.}$ [40°C] TIG	%	60
Welding current at 100% duty cycle [40°C] Electrode	A	310
Welding current at 100% duty cycle [40°C] TIG	A	310
Protection class		IP21S
Electrode power consumption	kVA	16.4
Power consumption TIG	kVA	12.4
Total power consumption	A	32.3 / 25.1
Required generator output	kVA	›22.4
Electrical connection ~50 Hz	V	400
Dimensions (L x W x H) approx.	mm	560 x 240 x 440
Weight approx.	kg	21.7
Standard		DIN EN 60974-10 / DIN EN IEC 60974-1, EMC class A

1) EMC class A: Welding equipment not intended for use in residential areas where the power supply is provided by a public low-voltage supply system.

SCOPE OF DELIVERY:

- Welding cable 50 mm² /3m with electrode holder 500 A
- Ground cable 50 mm²/3m with earth clamp 500 A

ACCESSORIES



ACCESSORIES	
① TIG welding torch, gas-cooled WP 26 V/4m	1462614
②Pressure reducer Argon/CO_2	1700050
③Welding cable 25 mm², KS50/13 mm, electrode holder 260 A	1250361
③Welding cable 35 mm², KS50/13 mm, electrode holder 400 A	1250362
④Ground cable 4m complete with earth clamp 25 mm², KS50/13 mm, clamp 200 A	1250225
④Ground cable 4m complete with earth clamp 35 mm², KS50/13 mm, clamp 400 A	1250235
⑤ Handheld remote control with 10m connection cable	1174011
⑥ Welding site equipment SPA 35 mm²	1240450
comprises: 5 metres PVC welding cable with electrode holder and welding cable plug, 3 metres PVC ground cable with earth clamp and welding cable plug, slag hammer, wire brush, polypropylene hand shield (CE), welding glass DIN 9, attachment glass 90 x 110 mm, 5-finger gloves	
⑦Wear parts set	1100152
comprises: 1 x torch cap each short / medium / long, 1 x gas nozzle each size 5 / 8 mm, size 6 / 9.8 mm, size 7 / 11.2 mm, size 8 / 12.7 mm, size 10 / 15.7 mm, 1x clamping sleeve each 1.6 / 3.2 / 4.0 / 2.4 mm, 1x clamping sleeve housing each 1.6 / 2.4 / 3.2 / 4.0 mm, Teflon seal for nozzle	

DVS PERSZERT

SCHWEISSER-PRÜFUNGSBESCHEINIGUNG
NACH DIN EN ISO 9606-1:2017-12

Beispiel einer Bezeichnung nach Norm

ISO 9606-1	141	T	BW	FM4	S	s3.6 D60	PH	ss nb
Norm	Schweißprozess	Produktform	Nahtart	Schweiß-zusatzgruppe	Schweißzusatzart	Abmessung des Prüfstücks	Prüfposition	Schweißnahteinzelheiten

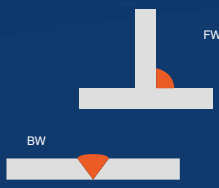
Schweißprozesse

Ordnungsnummern nach DIN EN ISO 4063

111	Lichtbogenhandschweißen
114	Metall-Lichtbogenschweißen mit Fülldrahtelektrode ohne Schutzgas
121	Unterpulverschweißen mit Massivdrahtelektrode
125	Unterpulverschweißen mit Fülldrahtelektrode
131	Metall-Inertgasschweißen mit Massivdrahtelektrode
135	Metall-Aktivgasschweißen mit Massivdrahtelektrode
136	Metall-Aktivgasschweißen mit schweißpulvergefüllter Drahtelektrode
138	Metall-Aktivgasschweißen mit metallpulvergefüllter Drahtelektrode
141	Wolfram-Inertgasschweißen mit Massivdraht- oder Massivstabzusatz
142	Wolfram-Inertgasschweißen ohne Schweißzusatz
143	Wolfram-Inertgasschweißen mit Fülldraht- oder Füllstabzusatz
145	Wolfram-Inertgasschweißen mit reduzierenden Gasanteilen im ansonsten inerten Schutzgas und Massivdraht- oder Massivstabzusatz
15	Plasmaschweißen
311	Gasschweißen mit Sauerstoff-Acetylen-Flamme

Nahtarten

BW	Stumpfnaht (butt weld)
FW	Kehlnaht (fillet weld)



Prüfposition

Gemäß DIN EN ISO 6947

PA	Wannenposition
PB	Horizontalposition
PC	Querposition
PD	Horizontal-Überkopfposition
PE	Überkopfposition
PF	Steigposition
PG	Fallposition
H-L045	Steigposition
J-L045	Fallposition
PH	Steigendschweißen
PJ	Fallendschweißen

Schweißnahteinzelheiten

Stumpfnähte

ss	einseitiges Schweißen
mb	Schweißen mit Schweißbadsicherung
nb	Schweißen ohne Schweißbadsicherung
gb	Gaswurzelschutz
fb	Schweißpulverabstützung
bs	beidseitiges Schweißen
ci	Schweißzusatz Einlegering

Kehlnähte

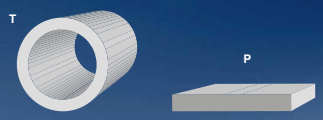
sl	einlagig
ml	mehrlagig

Gasschweißen mit Sauerstoff-Acetylen-Flamme

lw	nach links Schweißen
rw	nach rechts Schweißen

Produktformen

T	Rohr (tube)
P	Blech (plate)



Schweißzusatzart

Umhüllte Elektroden

Route A, Europa

A	sauer umhüllt
B	basisch umhüllt oder basische Fülldrahtelektrode
C	zelluloseumhüllt
R	rutilumhüllt oder rutile Fülldrahtelektrode – langsam erstarrende Schlacke
RA	rutilsauer umhüllt
RB	rutilbasisch umhüllt
RC	rutilzelluloseumhüllt
RR	dick rutilumhüllt

Route B, Pazifikraum

03	rutilbasisch umhüllt
10	zelluloseumhüllt
11	zelluloseumhüllt
12	rutilumhüllt
13	rutilumhüllt
14	rutil- und eisenpulverumhüllt
15	basisch umhüllt
16	basisch umhüllt
18	basisch und eisenpulverumhüllt
19	limenitumhüllt
20	eisenoxidumhüllt
24	rutil-und eisenpulverumhüllt
27	eisenoxid- und eisenpulverumhüllt
28	basisch und eisenpulverumhüllt
45	basisch umhüllt
48	basisch umhüllt

Fülldrähte

M	Metallpulver-Fülldrahtelektrode
P	rutile Fülldrahtelektrode – schnell erstarrende Schlacke
V	Fülldrahtelektrode – rutil oder basisch/fluorid
W	Fülldrahtelektrode – basisch/fluorid, langsam erstarrende Schlacke
Y	Fülldrahtelektrode – basisch/fluorid, schnell erstarrende Schlacke
Z	Fülldrahtelektrode – andere Arten

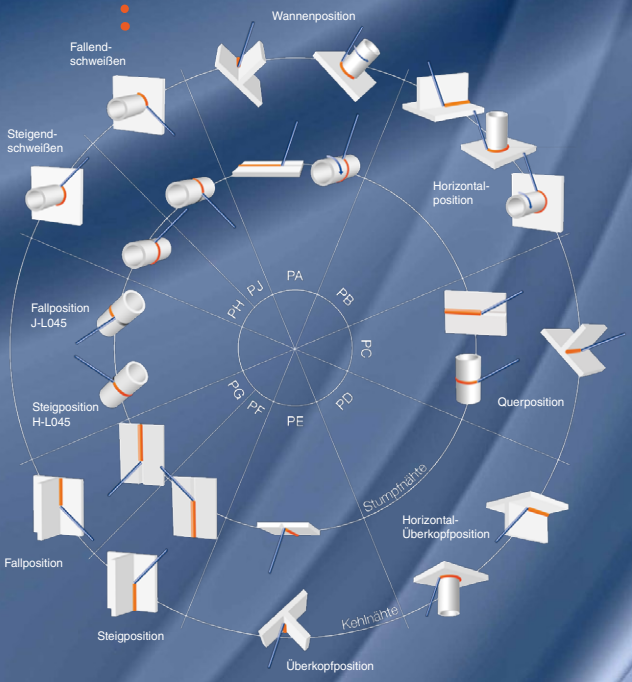
Alle weiteren

S	Massivdrahtelektrode/-stab
nm	kein Zusatzwerkstoff

Schweißzusatzgruppeneinteilung

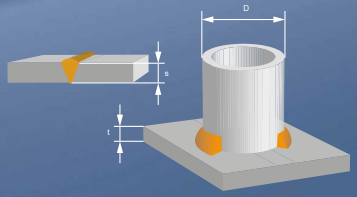
Gruppe	Schweißzusatz zum Schweißen von	Beispiele anwendbarer Normen*
FM1	unlegierte Stähle und Feinkornstähle	ISO 2560, ISO 14341, ISO 636, ISO 14171, ISO 17632, ISO 20378
FM2	hochfeste Stähle	ISO 18275, ISO 16834, ISO 26304, ISO 18276
FM3	warmfeste Stähle Cr < 3,75 %	ISO 3580, ISO 21952, ISO 24598, ISO 17634, ISO 20378
FM4	warmfeste Stähle 3,75 ≤ Cr ≤ 12 %	ISO 3580, ISO 21952, ISO 24598, ISO 17634
FM5	nichtrostende und hitzebeständige Stähle	ISO 3581, ISO 14343, ISO 17633
FM6	Nickel und Nickellegierungen	ISO 14172, ISO 18274

* In Deutschland sind die entsprechenden nationalen Normen zu verwenden, hierzu wird auf das Nationale Vorwort der Norm verwiesen.



Abmessungen des Prüfstücks

s	Beschreibt die Schweißgutdicke
t	Beschreibt die Werkstoffdicke
D	Beschreibt den äußeren Durchmesser



www.dvs-perszert.de

Benannte Prüfstellen für Schweißerprüfungen sind Stellen, die nach europäischen Richtlinien oder Rechtsvorschriften zur Personalzertifizierung zugelassen sind oder über eine Akkreditierung nach DIN EN ISO/IEC 17024 für die Durchführung von Schweißerprüfungen verfügen.