

**Gase vom Mittelstand
für den Mittelstand**

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SCHWEISSSCHUTZGASE
Produktinformation



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Verfahren	Werkstoffe	Gase			Eigenschaften							
		Produkt	Zusammensetzung	EN ISO 14175	Schweiß-/Schneidegeschwindigkeit	Spritzer	Einbrand	Mechanische Güterwerte	Schnitt-/Nahtaussehen Oxidation	Poren-Unempfindlichkeit	universelle Anwendung	Rauch- und Schadstoffreduzierung
MAG	Alle unlegierten und niedriglegierten Stähle, wie: Baustähle, Feinkornbaustähle, Schiffbaustähle, warmfeste Stähle, Einsatz- und Vergütungsstähle	Mix 18	Ar 82% + CO ₂ 18%	M21	●●	●●	●●●	●●	●●	●●●	●●●	●
		Mix K8	Ar 92% + CO ₂ 8%	M20	●●●	●●●	●●	●●●	●●●	●●	●●●	●●●
		Argon S 8	Ar 92% + O ₂ 8%	M22	●●●	●●●	●	●●	●●	●	●	●●
		Mix K5 05	Ar 90% + CO ₂ 5% + O ₂ 5%	M23	●●●	●●●	●●	●●●	●●●	●●	●●●	●●
		Argon He25 03	Ar 72% + He 25% + O ₂ 3,05%	M22	●●●	●●●	●●●	●●●	●●	●●●	●●	●●●
		Argon K13 04	Ar 83% + CO ₂ 13% + O ₂ 4%	M25	●●	●●●	●●●	●●	●●●	●●●	●●	●
	Hochlegierte Cr-, CrNi-Stähle, Sonderstähle, Duplex-Stähle, Nickel-Basislegierungen	Mix K2	Ar 98% + CO ₂ 2%	M12	●●	●●●	●●●	-	●●	●●●	●●●	●●●
		Argon S 1	Ar 99% + O ₂ 1%	M13	●●	●●●	●●	-	●	●●	●●	●●
		Argon S 2	Ar 98% + O ₂ 2%	M13	●●	●●	●●	-	●	●●	●●	●●
MIG	Aluminium, Kupfer, Nickel-Legierungen, dicke Nähte	Argon 4.6	Ar 99,996%	I1	●●	-	●●	-	●●	●●●	●	●●
		Argon/Helium 80/20	Ar 80% + He 20%	I3	●●	-	●●	-	●●●	●●●	●●	●●●
		Argon/Helium 70/30	Ar 70% + He 30%	I3	●●	-	●●	-	●●	●●●	●●	●●
		Argon/Helium 50/50	Ar 50% + He 50%	I3	●●●	-	●●	-	●●	●●●	●●●	●●●
		Argon/Helium 30/70	Ar 30% + He 70%	I3	●●●	-	●●●	-	●●	●●●	●●●	●●●
WIG	Alle schweißbaren Werkstoffe	Argon 4.6	Ar 99,996%	I1	●●	-	●●	●●	●●	●●●	●●●	●●
		Argon 4.8	Ar 99,998%	I1	●●	-	●●	●●●	●●●	●●●	●●●	●●●
	Hochlegierte austenitische CrNi-Stähle, Nickel, und Nickel-Legierungen.	Argon W2	Ar 98% + H ₂ 2%	R1	●●	-	●●	-	●●●	●●●	●●●	●●●
		Argon He3 W0,8	Ar 96,2% + He 3% + H ₂ 0,8%	R1	●●	-	●●	-	●●●	●●●	●●●	●●●
		Argon W6	Ar 94% + H ₂ 6%	R1	●●●	-	●●●	-	●●●	●●●	●●●	●●●
		Argon He15 W5	Ar 80% + He 15% + H ₂ 5%	R1	●●●	-	●●●	-	●●●	●●	●●	●●●
WP WIG	Aluminium, Kupfer, und Nickel-Legierungen	Argon 4.6	Ar 99,996%	I1	●	-	●	-	●	●	●●	●
		Helium 4.6	He 99,996%	I2	●●●	-	●●●	-	●●	●●●	●●	●●●
		Argon/Helium 80/20	Ar 80% + He 20%	I3	●●	-	●●	-	●●●	●●	●●●	●●
		Argon/Helium 70/30	Ar 70% + He 30%	I3	●●●	-	●●●	-	●●	●●●	●●●	●●
		Argon/Helium 50/50	Ar 50% + He 50%	I3	●●●	-	●●●	-	●●	●●●	●●●	●●●
		Argon/Helium 30/70	Ar 30% + He 70%	I3	●●●	-	●●●	-	●●	●●	●●●	●●●
Wurzelschutz	Vollaustenite, zur Vermeidung der wurzelseitigen Oxidation Gasempfindliche Werkstoffe Titan-stabilisierte Austenite	Formiergas 95/05	N ₂ 95% + H ₂ 5%	N5	-	-	-	●●	●●●	-	●●	-
		Formiergas 90/10	N ₂ 90% + H ₂ 10%	N5	-	-	-	●●	●●●	-	●●	-
		Formiergas 80/20	N ₂ 80% + H ₂ 20%	N5	-	-	-	●●	●●●	-	●●	-
		Argon 4.6	Ar 99,996%	I1	-	-	-	●●●	●●●	-	●●●	-
		Argon W6	Ar 94% + H ₂ 6%	R1	-	-	-	●●●	●●●	-	●●●	-
		Argon W10	Ar 90% + H ₂ 10%	R1	-	-	-	●●●	●●●	-	●●●	-
MSG-Löten	Beschichtete und unbeschichtete Feinbleche, nicht rostende ferritische Stähle	Argon 4.6	Ar 99,996%	I1	●●	-	-	-	●●	-	-	-
		Argon S1	Ar 99% + O ₂ 1%	M13	●●	-	-	-	●●●	-	-	-
		Argon S2	Ar 98% + O ₂ 2%	M13	●●	-	-	-	●●●	-	-	-
		Argon He15 K2	Ar 83% + He 15% + CO ₂ 2%	M12	●●●	-	-	-	●●●	-	-	-
Lichtbogenbolzenschweißen	Stahl Alu	Mix 18	Ar 82% + CO ₂ 18%	M21	-	-	●●●	-	●●	-	-	-
		Argon 4.6	Ar 99,996%	I1	-	-	●●	-	●●	-	-	-
		Argon/Helium 70/30	Ar 70% + He 30%	I3	-	-	●●●	-	●●●	-	-	-