

Žice za zavarivanje
Welding wires



Žice za zavarivanje za Lampert-uređaje za zavarivanje

Welding wires for Lampert precision welding devices

NEU • NEW: WIRE PEN



Praktičan pomoćnik za ručno dovođenje žice za zavarivanje

The practical tool for manual feeding of welding wire

Art. 100 812

Legure i dimenzije žica za zavarivanje optimalno su prilagođene zavarivanju s našim strojevima za fino zavarivanje.

The alloys and dimensions of the welding wires have been specially selected for welding with our precision welding devices.

Žice za zavarivanje legura zlata / Welding wires for gold alloys

Sve žice za zavarivanje legura zlata i platine izrađene su od standardnih legura za nakit odgovarajuće finoće. Za tipične primjene u proizvodnji i popravku nakita, žice za zavarivanje trebale bi biti obrađene vrlo tanke kako bi se mogle nanositi dozirano i s malom snagom.

All welding wires for gold and platinum alloys consist of standard jewellery alloys with an accordant standard. For typical applications in jewellery production and repair, the welding wires should be processed in thinner sizes so that the wires can be applied controlled and with lower power settings.

Au 750 Y	Žuto zlato / Yellow gold	Au 750/000 - 18 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 340
Au 585 Y	Žuto zlato / Yellow gold	Au 585/000 - 14 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 341
Au 750 Pd	Bojelo zlato / White gold	Au 750/000 - 18 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 342
Au 750 Red	Crveno zlato / Red gold	Au 750/000 - 18 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 351
Au 750 Red	Crveno zlato / Red gold	Au 750/000 - 18 kt - 300 mm x 0,45 mm (11.8" x 0.018")	304 352
Au 585 Red	Crveno zlato / Red gold	Au 585/000 - 14 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 353
Au 585 Red	Crveno zlato / Red gold	Au 585/000 - 14 kt - 300 mm x 0,45 mm (11.8" x 0.018")	304 354
Au 750 Rose	Roza zlato / Rose gold	Au 750/000 - 18 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 355
Au 750 Rose	Roza zlato / Rose gold	Au 750/000 - 18 kt - 300 mm x 0,45 mm (11.8" x 0.018")	304 356
Au 585 Rose	Roza zlato / Rose gold	Au 585/000 - 14 kt - 500 mm x 0,25 mm (19.7" x 0.01")	304 357
Au 585 Rose	Roza zlato / Rose gold	Au 585/000 - 14 kt - 300 mm x 0,45 mm (11.8" x 0.018")	304 358

Žice za zavarivanje platine / Welding wire for platinum

Kod zavarivanja Pt legura, posebno odljevaka od platine, mogu se pojaviti male pore i/ili krtoš ako se ponovljeno zavarivanje izvodi na istom mjestu. To se može izbjeći općenito nanošenjem svježeg metala pomoću žice za zavarivanje. Kod zavarivanja na platinu vrlo je važno čisto područje zavarivanja i optimalna pokrivenost zaštitnim plinom.

When welding Pt alloys, in particular with cast platinum, small pores and/or brittleness can arise if welding repeatedly takes place in the same place. This can be avoided in general terms through the application of fresh metal with welding wire. When welding on platinum, a clean welding area and optimum shielding gas coverage are very important.

Pt 960	Patina / Platinum	Pt 960/000 - 500 mm x 0,25 mm (19.7" x 0.01")	304 343
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Žice za zavarivanje legura srebra / Special welding wire for silver alloys

Vrlo dobra boja za rad na srebrnim predmetima. Izvrsna svojstva tečenja. Rezultati zavarivanja bez pora. Visoka duktilnost zavarenih područja.

Excellent coloring for working on (sterling) silver. Excellent flow properties. Welding results free of pores. Excellent ductility of the welded area.

Silver JSS	Srebro 935 - 2000 mm x 0,25 mm (78.7" x 0.01")	304 348
Silver JSS	Srebro 935 - 2000 mm x 0,35 mm (78.7" x 0.014")	304 349
Silver JSS	Srebro 935 - 2000 mm x 0,45 mm (78.7" x 0.018")	304 350

Žice za zavarivanje legura srebra / Welding wire for silver alloys

Žica za zavarivanje srebrnih legura je legirana s višim sadržajem finog srebra kako bi pozitivno utjecala na svojstva tečenja i duktilnost žice za zavarivanje. Unatoč tome, žica je iste boje kao srebro (925/000). Finoća žice za zavarivanje je 970/000.

The welding wire for silver alloys is alloyed with a high content of fine silver, in order to positively influence the flowing characteristics and the ductility of the welding wire. However, the wire is the same colour as sterling silver (925/000). The fineness of the welding wire is 970/000.

Ag 970	Srebror / Silver	Ag 970/000 - 2000 mm x 0,25 mm (78.7" x 0.01")	304 346
Ag 970	Srebror / Silver	Ag 970/000 - 1000 mm x 0,35 mm (39.4" x 0.014")	304 344

Žice za zavarivanje titana / Welding wire for titanium

Žica od nelegiranog titana (kvalitet 2) za identične zavare na kvaliteti titana za zavarivanje. Žicu karakterizira visoka otpornost na pucanje. Kod zavarivanja na titanu vrlo je važno čisto područje zavarivanja i optimalna pokrivenost zaštitnim plinom (s argonom 4,6 ili višim).

Unalloyed titanium wire (grade 2) for homogeneous welding on weldable titanium qualities. The wire is characterised by a high crack resistance. When welding on titanium, a clean welding area and optimum shielding gas coverage (with argon 4.6 or higher) are very important.

Fini titan / Titanium	1000 mm x 0,30 mm (39.4" x 0.012")	304 310
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Žica za zavarivanje bakrenih materijala / Welding wire for copper materials

Dobro protočna legura bakra (C45) za glatke, guste zavare bez pora na legurama bakra, bakra i cinka i bakra i silicija te za obloge na legurama bakra i materijalima od nelegiranog željeza. Oporan na koroziju, vrlo jak i hladno žilav metal za zavarivanje, gotovo iste boje kao čisti bakar.

Free-flowing copper alloy (C45) for smooth, dense and non-porous welding on copper, copper-zinc and copper-silicon alloys and for build-up welding on copper alloys and unalloyed ferrous materials. Corrosion resistant, very strong and low-temperature weld metal, virtually identical in colour to pure copper.

Kupfer / Copper	Cu-Si3-Mn1 - 2000 mm x 0,35 mm (78.7" x 0.014")	304 312
Kupfer / Copper	Cu-Si3-Mn1 - 2000 mm x 0,50 mm (78.7" x 0.020")	304 313
Kupfer / Copper	Cu-Si3-Mn1 - 2000 mm x 0,70 mm (78.7" x 0.028")	304 314

Žica za zavarivanje kositra / Welding wire for tin

Žica za zavarivanje od 99,9% finog kositra pogodna je za popravke na predmetima od kositra i legura kositra. Visoka čistoća žice osigurava vrlo duktilan, stoga stabilan i čist zavar. Preporuča se obrada žice za zavarivanje s povećanim protokom plina i većom plinskom mlaznicom (artikl br. 100 150-4).

The welding wire from 99.9 % fine tin is suitable for repairs on objects made from tin and tin alloys. The high purity of the wire guarantees a very ductile and therefore stable and clean weld. It is advisable to process the welding wire with an increased gas flow and a larger gas nozzle (item no. 100 150-4).

Kositar / Tin	Fini kositar / Fine tin 99,9 % - 100 g x 0,75 mm (3.52 oz x	304 328
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Žica za zavarivanje za popravke i legura koje se teško zavaruju / Welding wire for repairs and difficult to weld alloys

Ova Pd/Ag/Cu žica za zavarivanje, koja ima visok sadržaj paladija, vrlo je prikladna za popravak zavarivanja na legurama koje imaju ograničenu zavarljivost same sa sobom ili međusobno. Žica za zavarivanje odlikuje se vrlo dobrim adhezivnim svojstvima i velikom žilavošću. Tadi toga se često koristi kao metalni most između problematičnih legura (siva boja).

This Pd/Ag/Cu welding wire with a high content of palladium is particularly well-suited for repair welds on alloys that are only weldable to a limited degree with themselves or with each other. The welding wire is characterised by excellent adhesion properties and exceptional toughness. It is therefore frequently used as a bridging metal between alloys that are difficult to weld (colour grey).

PdAg 500	Paladij-srebro / Palladium-silver PdAg 500/000 - 500 mm x 0,25 mm (19.7" x 0.01")	304 331
PdAg 500	Paladij-srebro / Palladium-silver PdAg 500/000 - 500 mm x 0,40 mm (19.7" x 0.016")	304 330

Žica za zavarivanje legura na bazi nikla / Welding wire nickel-based alloy

Za spojeve i primjene na identičnim ili sličnim materijalima, npr. Hastelloy, Alloy 600, Inconel, itd. Kod zavarivanja na legurama na bazi nikla vrlo je važno čisto područje zavarivanja i optimalna pokrivenost zaštitnim plinom (s argonom 4,6 ili višim).

For joints and deposition welding on identical or similar materials e.g. Hastelloy, Alloy 600, Inconel, etc. When welding on nickel-based alloys, a clean welding area and optimum shielding gas coverage (with argon 4.6 or higher) are very important.

NiCrMo15

Legure na bazi nikla / Nickel-based alloy - 1000 mm x 0,40 mm (39.4" x 0.016")

304 329

Žice za zavarivanje čelika / Welding wires for steels

Vrlo stabilna, austenitna žica za zavarivanje CMS prikladna je za zavarivanje CrNi čelika kao što su 1.4301, 1.4401, 1.4453 ili 1.4571.

The welding wire CMS is a highly stable, austenitic welding metal. It is suitable for welding CrNi steels such as 1.4301, 1.4401, 1.4453 and 1.4571.

Čelik CMS / Steel CMS

Nehrđajući čelik / stainless steel 1000 mm x 0,40 mm (39.4" x

304 320

Žica za zavarivanje GS2 prikladna je za primjenu veće tvrdoće na alatima izloženim visokoj abraziji i pritisku. Također dobra za oklop na nelegiranim i niskolegiranim čelicima. Tvrdoća do 58HR.

The welding wire GS2 is suitable for applications with a higher hardness on tools subject to heavy wear and pressure. It is also good for platings on unalloyed and low-alloyed steels. Hardness up to 58HRC.

Čelik GS2 / Steel GS2

1000 mm x 0,20 mm (39.4" x 0.008")

304 321

Žica za zavarivanje GS55 je martenzitni krom čelik dobre izdržljivosti i otpornosti na trošenje. Pogodan je za udarce i stres te se može toplinski obraditi. Za visokootporno zavarivanje alata. Tvrdoća do 61HRC.

The welding wire GS55 is a martensitic chromium steel with good stability and wear resistance. It is suitable with shock and impact stress and is heat treatable. For highly wear-resistant application welding on tools. Hardness up to 61HRC.

Celik GS5 / Steel

1000 mm x 0,20 mm (39.4" x 0.008")

304 322

Žice za zavarivanje aluminija / Welding wires for aluminum

Žica za zavarivanje AlMg3 za taloženje na Al-Mg legurama do 3% magnezija, npr. AlMg3. Zavareni metal se može eloksirati.

Welding wire AlMg3 for applications on Al-Mg alloys up to 3% magnesium e.g. AlMg3. The welding metal can be anodised.

AlMg3

2000 mm x 0,5 mm (78.70" x 0.02")

304 325

AlSi žica za zavarivanje za spajanje i primjenu na legurama aluminija i silicija do 12% Si kao i za različite vrste legura aluminija.

Welding wire AlSi for connections and application on aluminium-silicon alloys up to 12% Si, and for different types of aluminium alloys together.

AlSi

2000 mm x 0,5 mm (78.70" x 0.02")

304 326

PAŽNJA – Čistoća je najvažnija priprema za zavarivanje ATTENTION – Cleanliness is the most important weld preparation

Za uspješan zavar vrlo je važno da se područje zavarivanja prethodno pažljivo očisti. Prljavština, oksidi, slojevi ulja ili voska onemogućuju dobar rezultat zavarivanja. Varovi moraju biti metalno čisti. Ovisno o razini onečišćenja, kemijska sredstva za čišćenje ili postupci rezanja metala vrlo su prikladni za čišćenje zavara. Laki zaprljanja ili nakupina, također se preporučuje čišćenje ultrazvučnim uređajem.

For successful welding it is very important that the welding area is carefully cleaned beforehand. Dirt, oxides, oil or wax layers make good welding results impossible. The welding spots must be metallically clean. Depending on the contamination, chemical cleaning products or machining processes are highly suited for cleaning the welding areas. With minor soiling and adhesions it is also advisable to clean with an ultrasonic device.