



Materiały do spawania stali niestopowych i niskostopowych (Re \leq 485 MPa)

		MMA															
		E6013															
		E6010															
		E6010-2															
Typ		E6010-2															
Material dodatkowy		Filarc 27P	E464 B 4.1 H5														
Material rodzimy		Filarc 48	E420 RC 1-1														
		Filarc 36S	E425 B 12 H5														
		Filarc 76S	E466 Mn1N B 3.2 H5														
		Filarc 78	E422 B 1-2														
		Filarc C6HH	E384 B 74-H10														
		OK-Femax 33.60	E420 RR-S3														
		OK-Femax 33.80	E420 RR-T3														
		OK-Femax 38.65	E424 B 73-H5														
		OK-Femax 39.50	E422 RA-S3														
		Pipeweld 6010	E382 C2 1														
		OK-46.00	E380 RC 1-1														
		OK-46.44	E380 RC 1-1														
		OK-46.64	E380 RC 1-1														
		OK-46.16	E380 RC 1-1														
		OK-43.32	E420 RR-T2														
		OK-50.40	E422 RB 1/2														
		OK-48.00	E424 B 4.2 H5														
		OK-48.08	E465 MnB 2 H5														
		OK-48.30	E424 B 4.2 H10														
		OK-48.65	E382 B 4/2														
		OK-53.05	E424 B 2/2														
		OK-53.16 Spaziba	E382 B 3/2														
		OK-53.70	E425 B 12 H5														
		OK-55.00	E46 B 3/2 H5														

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



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		MMA									
		Typ					Material dodatkowy				
		Material rodzimy									
1.0142	S275J2C	●	●	●	●	●	E 46 4 B 41 H5	Filarc 2TP			
1.0138	S275J2H	●	●	●	●	●	E 42 0 RC11	Filarc 48			
1.0044	S275JR	●	●	●	●	●	E 42 5 B 12 H5	Filarc 56S			
1.0128	S275JRC	●	●	●	●	●	E 46 6 Mn1NiB32 H5	Filarc 76S			
1.8818	S275M	●	●	●	●	●	E 42 2 R 12	Filarc 78			
1.8843	S275MH	●	●	●	●	●		Filarc C9BH	E 38 4 B 14 H10		
1.8819	S275ML	○	●	●	●	●		OK Femax 3360	E 42 0 RR53		
1.8844	S275MLH	○	●	●	●	●		OK Femax 3380	E 42 0 RR73		
1.0490	S275N	●	●	●	●	●		OK Femax 3865	E 42 4 B 73 H5		
1.0493	S275NH	●	●	●	●	●		OK Femax 3950	E 42 2 RA53		
1.0491	S275NL	○	●	●	●	●		Pipeweld 8010	E 38 2 C 21		
1.0497	S275NLH	○	●	●	●	●		OK 46 00	E 38 0 RC11		
1.0426	P280GH	●	●	●	●	●		OK 46 44	E 38 0 RC11		
1.0477	P285NH	●	●	●	●	●		OK 46 64	E 38 0 RC11		
1.0478	P285QH	●	●	●	●	●		OK 46 16	E 38 0 RC11		
1.0483	L290GA (API 5L: X42)	●	●	●	●	●		OK 49 32	E 42 0 RR12		
1.0429	L290MB (API 5L: X42)	●	●	●	●	●		OK 50 40	E 42 2 RB12		
1.0484	L290NB (API 5L: X42)	●	●	●	●	●		OK 48 00	E 42 4 B 12 H5		
1.0050	E295 (Si50-2)	●	●	●	●	●		OK 48 08	E 46 5 INB32 H5		
1.0481	P295GH (17Mn4)	●	●	●	●	●		OK 48 30	E 42 4 B 12 H10		
1.0436	P305GH	●	●	●	●	●		OK 48 55	E 38 2 B 12		
1.0482	P310GH (19Mn5)	●	●	●	●	●		OK 53 05	E 42 4 B 12		
1.0437	P310NB	●	●	●	●	●		OK 53 16	E 38 2 B 12		
1.0972	S315MC	●	●	●	●	●		OK 53 70	E 42 5 B 12 H5		
1.0973	S315NC	●	●	●	●	●		OK 55 00	E 46 5 B 12 H5		
1.0046	S320GP	●	●	●	●	●					
1.0060	E335 (Si60-2)	●	●	●	●	●					
1.0473	P355GH	●	●	●	●	●					
1.8821	P355M	●	●	●	●	●					
1.8832	P355ML1	○	●	●	●	●					
1.8833	P355ML2	○	●	●	●	●					
1.0562	P355N	●	●	●	●	●					
1.0557	P355NB	●	●	●	●	●					
1.0565	P355NH	●	●	●	●	●					
1.0566	P355NL1	○	●	●	●	●					
1.1106	P355NL2	○	●	●	●	●					
1.8866	P355Q	●	●	●	●	●					
1.8867	P355QH	●	●	●	●	●					
1.0571	P355QH1	●	●	●	●	●					
1.8868	P355QI 1	●	●	●	●	●					

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- = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		MMA									
		MMA									
		MMA									
		MMA									
Typ		MMA									
Material dodatkowy		Filarc 27P	E 46 4 B 4 1 H5	E 42 0 RC 1 1	E 42 5 B 12 H5	E 46 6 MnNiB 3 2 H4	E 42 R 12	E 38 4 B 7 4 H10	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 B 7 3 H6
Material rodzimy		Filarc 48	E 42 0 RC 1 1	Filarc 56S	E 42 5 B 12 H5	Filarc 76S	E 42 R 12	Filarc C6HH	E 42 0 RR 5 3	E 42 0 RR 7 3	E 42 B 7 3 H6
1.8869	P355QL2	○	●	○	●	●	●	●	●	●	●
1.8814	S355G1 (+N)	●	●	●	●	●	●	●	●	●	●
1.8801	S355G2+N	●	●	●	●	●	●	●	●	●	●
1.8802	S355G3+N	●	●	●	●	●	●	●	●	●	●
1.8803	S355G4 (+M)	●	●	●	●	●	●	●	●	●	●
1.8804	S355G5+M	●	●	●	●	●	●	●	●	●	●
1.8805	S355G6+M	●	●	●	●	●	●	●	●	●	●
1.8808	S355G7+M (+N)	●	●	●	●	●	●	●	●	●	●
1.8810	S355G8+M (+N)	●	●	●	●	●	●	●	●	●	●
1.8811	S355G9+M (+N)	●	●	●	●	●	●	●	●	●	●
1.8813	S355G10+M (+N)	●	●	●	●	●	●	●	●	●	●
1.8806	S355G11 (+M) (+N)	●	●	●	●	●	●	●	●	●	●
1.8809	S355G12 (+M) (+N)	●	●	●	●	●	●	●	●	●	●
1.1182	S355G13+N (+Q)	●	●	●	●	●	●	●	●	●	●
1.1184	S355G14+N (+Q)	●	●	●	●	●	●	●	●	●	●
1.1190	S355G15+N (+Q)	●	●	●	●	●	●	●	●	●	●
1.0083	S355GP	●	●	●	●	●	●	●	●	●	●
1.0554	S355J0C	●	●	●	●	●	●	●	●	●	●
1.0547	S355J0H	●	●	●	●	●	●	●	●	●	●
1.0577	S355J2	●	○	●	●	●	●	●	●	●	●
1.0579	S355J2C	●	○	●	●	●	●	●	●	●	●
1.0570	S355J2G3	●	○	●	●	●	●	●	●	●	●
1.0576	S355J2H	●	○	●	●	●	●	●	●	●	●
1.0045	S355JR	●	●	●	●	●	●	●	●	●	●
1.0551	S355JRC	●	●	●	●	●	●	●	●	●	●
1.0596	S355K2	●	●	●	●	●	●	●	●	●	●
1.0594	S355K2C	●	●	●	●	●	●	●	●	●	●
1.0512	S355K2H	●	●	●	●	●	●	●	●	●	●
1.8823	S355M	●	●	●	●	●	●	●	●	●	●
1.0976	S355MC	●	●	●	●	●	●	●	●	●	●
1.8845	S355MH	●	●	●	●	●	●	●	●	●	●
1.8834	S355ML	○	●	●	○	○	○	○	○	○	●
1.8846	S355MLH	○	●	●	○	○	○	○	○	○	●
1.0545	S355N	●	●	●	●	●	●	●	●	●	●
1.0977	S355NC	●	●	●	●	●	●	●	●	●	●
1.0539	S355NH	●	●	●	●	●	●	●	●	●	●
1.0546	S355NL	○	●	●	○	○	○	○	○	○	●
1.0549	S355NLH	○	●	●	○	○	○	○	○	○	●
1.0070	E360 (S170-2)	○	●	●	●	●	●	●	●	●	●
1.0499	L360GA (API 5L: X52)	●	○	●	●	●	○	○	○	●	●

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		MMA									
		MMA									
		MMA									
		MMA									
Typ		MMA									
Materiał dodatkowy		MMA									
Materiał rodzimy		MMA									
1.8871	P460QH	○									
1.8872	P460QL1	○ ○									
1.8864	P460QL2	○ ○	●								
1.8878	S460G1+M (+Q)			●							
1.8887	S460G2+M (+Q)			●							
1.8883	S460G3 (+M)			●							
1.8889	S460G4 (+M)			●							
1.8885	S460G5+Q			●							
1.8884	S460G6+Q			●							
1.8827	S460M	○		●							
1.0982	S460MC	○		●							
1.8849	S460MH	○		●							
1.8838	S460ML	○		●							
1.4850	S460MLH	○		●							
1.8901	S460N	○		●							
1.8953	S460NH	○		●							
1.8903	S460NL	○		●							
1.8956	S460NLH	○		●							
1.8908	S460Q	○		●							
1.8906	S460QL	○		●							
1.8916	S460QL1	○		●							
1.8977	L485MB (API 5L: X70)	○									
1.8955	L485QB (API 5L: X70)	○			○						
1.0438	BSt 500 S / B500N	● ● ● ○ ○ ○ ○ ○ ○			● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○
1.0466	BSt 500 M / B500G3	● ● ● ○ ○ ○ ○ ○ ○			● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○		● ● ● ○ ○ ○ ○ ○ ○
1.0420	GE200 (GS-38)	●	● ●			●			● ● ●	● ● ●	● ● ●
1.0449	GS200	●	● ●			●			● ● ●	● ● ●	● ● ●
1.0445	GE240 (GS-45)	●	● ●			●			● ● ●	● ● ●	● ● ●
1.0455	GS240	●	● ●			●			● ● ●	● ● ●	● ● ●
1.0558	GE300 (GS-60)	●	● ●			●			● ● ●	● ● ●	● ● ●
1.1131	G17Mn5	●	● ●			●			● ● ●	● ● ●	● ● ●
1.0521	R200 (StSch 700)								●		
1.0524	R220 (StSch 800)								●		
1.0623	R260 (StSch 900A)								●		
1.0624	R260Mn (StSch 900B)								●		

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

Typ	Materiał dodatkowy	MAG										TIG			
		G 42.4 M G3Si1 / G 38.2 C G3Si	G 42.3 M G3Si1 / G 38.2 C G3Si	G 38.3 M G2Si / G 35.2 C G2Si	G 38.3 M G2Si / G 35.2 C G2Si	G 46.4 M G2Ti / G 42.3 C G2Ti	G 46.4 M G4Si1 / G 42.2 C G4Si	G 46.3 M G4Si1 / G 42.2 C G4Si	G 46.2 M G2Mo / G 38.0 C G2M	W 38.3 W2Si	W 42.3 W0Si1	W 46.3 W4Si1	W 46.2 W2Mo		
1.0252 L235	OK Aristofod 12.50	●	●	●	●	●	●	●	●	●	●	●	●		
1.0458 L235GA	OK Autrod 12.51	●	●	●	●	●	●	●	●	●	●	●	●		
1.0345 P235GH	OK Aristofod 12.51	●	●	●	●	●	●	●	●	●	●	●	●		
1.0112 P235S	OK Autrod 12.58	●	●	●	●	●	●	●	●	●	●	●	●		
1.0253 P235TR1	OK Aristofod 12.63	●	●	●	●	●	●	●	●	●	●	●	●		
1.0254 P235TR2	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0114 S235J0	OK Aristofod 12.62	●	●	●	●	●	●	●	●	●	●	●	●		
1.0115 S235J0C	OK Aristofod 12.62	●	●	●	●	●	●	●	●	●	●	●	●		
1.0117 S235J2	OK Aristofod 12.63	●	●	●	●	●	●	●	●	●	●	●	●		
1.0119 S235J2C	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0116 S235J2G3	OK Aristofod 13.09	●	●	●	●	●	●	●	●	●	●	●	●		
1.0120 S235JRC	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	●	●	●		
1.0122 S235JRC	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0039 S235JRH	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0038 S235JR	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●		
1.0021 S240GP	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	●	●	●		
1.0459 L245GA	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0418 L245MB	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0457 L245NB	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●		
1.0352 P245GH	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	●	●	●		
1.0111 P245NB	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0460 P250GH (C22.8)	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0452 P255QL	OK Autrod 13.09	●	○	○	○	○	○	○	○	○	○	○	○		
1.0971 S260NC	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	●	●	●		
1.0425 P265GH	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0130 P265S	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0423 P265NB	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●		
1.0453 P265NL	OK Autrod 12.60	●	○	○	○	○	○	○	○	○	○	○	○		
1.0258 P265TR1	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0259 P265TR2	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	●	●	●		
1.0023 S270GP	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●		
1.0260 L275	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	●	●	●		
1.0487 P275NH	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	●	●	●		
1.0488 P275NL1	OK Autrod 12.64	●	●	●	●	●	●	●	●	●	○	○	○		
1.1104 P275NL2	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	○	○	○		
1.1100 P275SL	OK Autrod 12.60	●	●	●	●	●	●	●	●	●	○	○	○		
1.0143 S275J0	OK Autrod 12.61	●	●	●	●	●	●	●	●	●	○	○	○		

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		MAG								TIG			
Typ		G3Si				G35				G3Si		G35	
Material dodatkowy	Material rodzimy	OK	AristoRod	12.50	G 42.4 M G3Si / G 38.2 C G3Si	OK	Autrod	12.51	G 42.3 M G3Si / G 38.2 C G3Si	OK	AristoRod	12.57	G 38.3 M G2Si / G 35.2 C G2Si
		OK	AristoRod	12.57	G 38.3 M G2Si / G 35.2 C G2Si	OK	Autrod	12.58	G 38.3 M G2Si / G 35.2 C G2Si	OK	AristoRod	12.62	G 46.4 M G2Ti / G 42.3 C G2Ti
1.0140	S275J0C	●	●	●	●	●	●	●	●	●	●	●	●
1.0149	S275J0H	●	●	●	●	●	●	●	●	●	●	●	●
1.0145	S275J2	●	●	●	●	●	●	●	●	●	●	●	●
1.0142	S275J2C	●	●	●	●	●	●	●	●	●	●	●	●
1.0138	S275J2H	●	●	●	●	●	●	●	●	●	●	●	●
1.0044	S275JR	●	●	●	●	●	●	●	●	●	●	●	●
1.0128	S275JRC	●	●	●	●	●	●	●	●	●	●	●	●
1.8818	S275M	●	●	●	●	●	●	●	●	●	●	●	●
1.8843	S275MH	●	●	●	●	●	●	●	●	●	●	●	●
1.8819	S275ML	●	●	○	○	○	○	○	●	○	○	○	○
1.8844	S275MLH	●	●	○	○	○	○	○	●	○	○	○	○
1.0490	S275N	●	●	●	●	●	●	●	●	●	●	●	●
1.0493	S275NH	●	●	●	●	●	●	●	●	●	●	●	●
1.0491	S275NL	●	●	○	○	○	○	○	●	○	○	○	○
1.0497	S275NLH	●	●	○	○	○	○	●	●	○	○	○	○
1.0426	P280GH	●	●	●	●	●	●	●	●	●	●	●	●
1.0477	P285NH	●	●	●	●	●	●	●	●	●	●	●	●
1.0478	P2850H	●	●	●	●	●	●	●	●	●	●	●	●
1.0483	L290GA (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●
1.0429	L290MB (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●
1.0484	L290NB (API 5L: X42)	●	●	●	●	●	●	●	●	●	●	●	●
1.0050	E295 (S150-2)	○	○	○	○	○	○	○	●	○	○	○	○
1.0481	P295GH (17Mn4)	●	●	●	●	●	●	●	●	●	●	●	●
1.0436	P305GH	●	●	●	●	●	●	●	●	●	●	●	●
1.0482	P310GH (19Mn5)	●	●	●	●	●	●	●	●	●	●	●	●
1.0437	P310NB	●	●	●	●	●	●	●	●	●	●	●	●
1.0972	S315MC	●	●	●	●	●	●	●	●	●	●	●	●
1.0973	S315NC	●	●	●	●	●	●	●	●	●	●	●	●
1.0046	S320GP	●	●	●	●	●	●	●	●	●	●	●	●
1.0060	E335 (S160-2)	●	●	●	●	●	●	●	●	●	●	●	●
1.0473	P355GH	●	●	●	●	●	●	●	●	●	●	●	●
1.8821	P355M	●	●	●	●	●	●	●	●	●	●	●	●
1.8832	P355ML1	●	●	●	●	●	●	●	●	○	○	○	○
1.8833	P355ML2	●	●	●	●	●	●	●	●	○	○	○	○
1.0562	P355N	●	●	●	●	●	●	●	●	●	●	●	●
1.0557	P355NB	●	●	●	●	●	●	●	●	●	●	●	●
1.0565	P355NH	●	●	●	●	●	●	●	●	●	●	●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

Typ	MAG										TIG			
	G 42.4 M G3Si1/G 38.2 C G3Si	G 42.3 M G3Si1/G 38.2 C G3Si	G 38.3 M G2Si/G 35.2 C G2Si	G 38.3 M G2Si/G 35.2 C G2Si	G 46.4 M G2Ti/G 42.3 C G2Ti	G 46.4 M G4Si1/G 42.2 C G4Si	G 46.3 M G4Si1/G 42.2 C G4Si	G 46.2 M G2Mo/G 38.0 C G2M						
Material dodatkowy	OK Aristibrod 12.50	OK Aristibrod 12.51	OK Autrod 12.51	OK Aristibrod 12.57	OK Autrod 12.58	OK Aristibrod 12.62	OK Autrod 12.63	OK Aristibrod 12.64	OK Aristibrod 13.09	W 38.3 W2Si	W 42.3 W0Si1	W 46.3 W4Si1	W 46.2 W2Mo	
Material rodzimy														
1.0566 P355NL1	● ●			● ● ○						○ ● ○ ○ ○				
1.1106 P355NL2	● ●			● ● ○						○ ● ○ ○ ○				
1.8866 P355Q	● ● ○ ● ○			● ● ○ ● ○						● ● ○ ● ○				
1.8867 P355QH	● ● ○ ○ ○			● ● ○ ○ ○						● ● ○ ○ ○				
1.0571 P355QH1	● ● ○ ○ ○			● ● ○ ○ ○						● ● ○ ○ ○				
1.8868 P355QL1	● ● ○ ○ ○			● ● ○ ○ ○						○ ○ ○ ○ ○				
1.8869 P355QL2	● ● ○ ○ ○			● ● ○ ○ ○						○ ○ ○ ○ ○				
1.8814 S355G1 (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.8801 S355G2+N	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8802 S355G3+N	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8803 S355G4 (+M)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8804 S355G5+M	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8805 S355G6+M	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8808 S355G7+M (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8810 S355G8+M (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8811 S355G9+M (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8813 S355G10+M (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8806 S355G11 (+M) (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.8809 S355G12 (+M) (+N)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.1182 S355G13+N (+Q)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.1184 S355G14+N (+Q)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.1190 S355G15+N (+Q)	● ○ ○ ○ ○			● ○ ○ ○ ○						○ ○ ○ ○ ○				
1.0083 S355GP	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0554 S355J0C	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0547 S355J0H	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0577 S355J2	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0579 S355J2C	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0570 S355J2G3	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0576 S355J2H	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0045 S355JR	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0551 S355JRC	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0596 S355K2	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0594 S355K2C	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0512 S355K2H	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.8823 S355M	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.0976 S355MC	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				
1.8845 S355MH	● ○ ○ ○ ○			● ○ ○ ○ ○						● ○ ○ ○ ○				

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

Typ	Materiał dodatkowy	MAG										TIG									
		G 42.4 M G3Si / G 38.2 C G3Si	G 42.3 M G3Si / G 38.2 C G3Si	G 38.3 M G2Si / G 35.2 C G2Si	G 38.3 M G2Si / G 35.2 C G2Si	G 46.4 M G2Ti / G 42.3 C G2Ti	G 46.4 M G4Si / G 42.2 C G4Si	G 46.3 M G4Si / G 42.2 C G4Si	G 46.3 M G4Si / G 42.2 C G4Si	G 46.2 M G2Mo / G 38.0 C G2M	G 46.2 M G2Mo / G 38.0 C G2M	G 38.3 W2Si	W 42.3 W0Si	W 46.3 W4Si	W 46.2 W2Mo						
1.8834 S355ML	OK Aristofod 12.50	●	○	○	○	●	●	●	●	●	●	○	●	●	●						
1.8846 S355MLH	OK Autrod 12.51	●	○	○	○	●	●	●	●	●	●	○	●	●	●						
1.0545 S355N	OK Aristofod 12.57	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0977 S355NC	OK Autrod 12.58	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0539 S355NH	OK Aristofod 12.62	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0546 S355NL	OK Aristofod 12.64	●	●	○	○	○	●	●	●	●	●	●	●	●	●						
1.0549 S355NLH	OK Autrod 12.64	●	●	○	○	●	●	●	●	●	●	●	●	●	●						
1.0070 E360 (St70-2)	OK Aristofod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0499 L360GA (API 5L: X52)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0578 L360MB (API 5L: X52)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0582 L360NB (API 5L: X52)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8948 L360QB (API 5L: X52)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0522 S390GP	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8973 L415MB (API 5L: X60)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8972 L415NB (API 5L: X60)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8947 L415QB (API 5L: X60)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0428 BST 420 S / B420N	OK Autrod 13.09	●	●	●	●	○	●	●	●	●	●	●	●	●	●						
1.8824 P420M	OK Autrod 13.09	●	●	●	●	○	●	●	●	●	●	●	●	●	●						
1.8835 P420ML1	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8828 P420ML2	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8932 P420NH	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8936 P420OH	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8830 S420G1+M (+Q)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8857 S420G2+M (+Q)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8851 S420G3 (+M)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8859 S420G4 (+M)	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8853 S420G5+Q	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8852 S420G6+Q	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8825 S420M	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0980 S420MC	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8847 S420MH	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8836 S420ML	OK Autrod 13.09	●	●	●	●	○	●	●	●	●	●	●	●	●	●						
1.8848 S420MLH	OK Autrod 13.09	●	●	●	●	○	●	●	●	●	●	●	●	●	●						
1.8902 S420N	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.0981 S420NC	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8750 S420NH	OK Autrod 13.09	●	●	●	●	●	●	●	●	●	●	●	●	●	●						
1.8912 S420NL	OK Autrod 13.09	●	●	●	●	○	●	●	●	●	●	●	●	●	●						

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

Typ	MAG										TIG			
	G 42.4 M G3Si1 / G 38.2 C G3Si	G 42.3 M G3Si1 / G 38.2 C G3Si	G 38.3 M G2Si / G 35.2 C G2Si	G 38.3 M G2Si / G 35.2 C G2Si	G 46.4 M G2Ti / G 42 C G2Ti	G 46.4 M G4Si1 / G 42.2 C G4Si	G 46.3 M G4Si1 / G 42.2 C G4Si	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W	G 46.2 M G2Mo / G 38.0 C G2W
Material dodatkowy	OK Aristofod 12.50	OK Aristofod 12.51	OK Autrod 12.57	OK Autrod 12.57	OK Autrod 12.58	OK Autrod 12.62	OK Autrod 12.63	OK Autrod 12.64	OK Autrod 12.64	OK Autrod 12.64	W/38.3/W2Si	W/42.3/W2Si1	W/46.3/W4Si1	W/46.2/W2Mo
Material rodzimy														
1.8751 S420NLH	● ●	○ ○ ○ ○ ○									● ● ○			
1.0523 S430GP	● ●	● ● ○ ○ ○									● ● ○			
1.8975 L450MB (API 5L: X65)		● ● ○ ○ ○									● ● ○			
1.8952 L450OB (API 5L: X65)		● ● ○ ○ ○									● ● ○			
1.8826 P460M		● ● ○ ○ ○									● ● ○			
1.8837 P460ML1			● ● ○ ○ ○								● ○ ○			
1.8831 P460ML2			● ● ○ ○ ○								● ○ ○			
1.8905 P460N			● ● ○ ○ ○								● ○ ○			
1.8935 P460NH			● ● ○ ○ ○								● ○ ○			
1.8915 P460NL1			● ● ○ ○ ○								● ○ ○			
1.8918 P460NL2			● ● ○ ○ ○								● ○ ○			
1.8870 P460Q			● ● ○ ○ ○								● ○ ○			
1.8871 P460QH			● ● ○ ○ ○								● ○ ○			
1.8872 P460QL1			● ● ○ ○ ○								● ○ ○			
1.8864 P460QL2			● ● ○ ○ ○								● ○ ○			
1.8878 S460G1+M (+Q)			● ● ○ ○ ○								● ○ ○			
1.8887 S460G2+M (+Q)			● ● ○ ○ ○								● ○ ○			
1.8883 S460G3 (+M)			● ● ○ ○ ○								● ○ ○			
1.8889 S460G4 (+M)			● ● ○ ○ ○								● ○ ○			
1.8885 S460G5+Q			● ● ○ ○ ○								● ○ ○			
1.8884 S460G6+Q			● ● ○ ○ ○								● ○ ○			
1.8827 S460M			● ● ○ ○ ○								● ○ ○			
1.0982 S460MC			● ● ○ ○ ○								● ○ ○			
1.8849 S460MH			● ● ○ ○ ○								● ○ ○			
1.8838 S460ML			○ ○ ○ ○ ○								● ○ ○			
1.4850 S460MLH			○ ○ ○ ○ ○								● ○ ○			
1.8901 S460N			○ ○ ○ ○ ○								● ○ ○			
1.8953 S460NH			○ ○ ○ ○ ○								● ○ ○			
1.8903 S460NL			○ ○ ○ ○ ○								● ○ ○			
1.8956 S460NLH			○ ○ ○ ○ ○								● ○ ○			
1.8908 S460Q			○ ○ ○ ○ ○								● ○ ○			
1.8906 S460QL			○ ○ ○ ○ ○								● ○ ○			
1.8916 S460QL1			○ ○ ○ ○ ○								○ ○ ○			
1.8977 L485MB (API 5L: X70)			○ ○ ○ ○ ○								○ ○ ○			
1.8955 L485QB (API 5L: X70)			○ ○ ○ ○ ○								○ ○ ○			
1.0438 BST 500 S / B500N	● ●	○ ○ ○ ○ ○									● ○ ○			
1.0466 BST 500 M / B500G3	● ●	○ ○ ○ ○ ○									● ○ ○			

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 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych ($Re \leq 485$ MPa)

- = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
- = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		FCAW											
		Typ											
Materiał dodatkowy	Materiał rodzimy	Coreshield 8											
		T-422 Y N 2	T-35 Z Z Y N 1	OK-Tubrod 14.10	T-46 4 M M 2 H5	OK-Tubrod 14.11	T-42 4 M M 3 H5	OK-Tubrod 14.12	T-42 2 M M 11 T-42 2 M C 1	OK-Tubrod 14.13	T-42 2 M M 2 H5	OK-Tubrod 15.00	T-42 3 B M 2 H5 / T-42 3 B C 2 H5
1.0252	L235	●	○	●	●	●	●	●	●	●	●	●	●
1.0458	L235GA	●	○	●	●	●	●	●	●	●	●	●	●
1.0345	P235GH	●	○	●	●	●	●	●	●	●	●	●	●
1.0112	P235S	●	○	●	●	●	●	●	●	●	●	●	●
1.0253	P235TR1	●	○	●	●	●	●	●	●	●	●	●	●
1.0254	P235TR2	●	○	●	●	●	●	●	●	●	●	●	●
1.0114	S235J0	●	○	●	●	●	●	●	●	●	●	●	●
1.0115	S235J0C	●	○	●	●	●	●	●	●	●	●	●	●
1.0117	S235J2	●	○	●	●	●	●	●	●	●	●	●	●
1.0119	S235J2C	●	○	●	●	●	●	●	●	●	●	●	●
1.0116	S235J2G3	●	○	●	●	●	●	●	●	●	●	●	●
1.0120	S235JRC	●	○	●	●	●	●	●	●	●	●	●	●
1.0122	S235JRC	●	○	●	●	●	●	●	●	●	●	●	●
1.0039	S235JRH	●	○	●	●	●	●	●	●	●	●	●	●
1.0038	S235JR	●	○	●	●	●	●	●	●	●	●	●	●
1.0021	S240GP	●	○	●	●	●	●	●	●	●	●	●	●
1.0459	L245GA	●	○	●	●	●	●	●	●	●	●	●	●
1.0418	L245MB	●	○	●	●	●	●	●	●	●	●	●	●
1.0457	L245NB	●	○	●	●	●	●	●	●	●	●	●	●
1.0352	P245GH	●	○	●	●	●	●	●	●	●	●	●	●
1.0111	P245NB	●	○	●	●	●	●	●	●	●	●	●	●
1.0460	P250GH (C22.8)	●	○	●	●	●	●	●	●	●	●	●	●
1.0452	P255QL	○	○	○	○	○	○	○	○	○	○	○	○
1.0971	S260NC	●	○	●	●	●	●	●	●	●	●	●	●
1.0425	P265GH	●	○	●	●	●	●	●	●	●	●	●	●
1.0130	P265S	●	○	●	●	●	●	●	●	●	●	●	●
1.0423	P265NB	●	○	●	●	●	●	●	●	●	●	●	●
1.0453	P265NL	○	○	○	○	○	○	○	○	○	○	○	○
1.0258	P265TR1	●	○	●	●	●	●	●	●	●	●	●	●
1.0259	P265TR2	●	○	●	●	●	●	●	●	●	●	●	●
1.0023	S270GP	●	○	●	●	●	●	●	●	●	●	●	●
1.0260	L275	●	○	●	●	●	●	●	●	●	●	●	●
1.0487	P275NH	●	○	●	●	●	●	●	●	●	●	●	●
1.0488	P275NL1	○	○	○	○	○	○	○	○	○	○	○	○
1.1104	P275NL2	○	○	○	○	○	○	○	○	○	○	○	○

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		Typ		FCAW											
		Material dodatkowy		Coreshield B		T422YN2		Coreshield N		T352Z2Y-N1		OK Tubrod 14.10		T464M/M2 H5	
		Material rodzimy		Coreshield B		T422YN2		Coreshield N		T352Z2Y-N1		OK Tubrod 14.11		T422M/M3 H5	
1.1100	P275SL	<input checked="" type="checkbox"/>													
1.0143	S275J0	<input checked="" type="checkbox"/>													
1.0140	S275J0C	<input checked="" type="checkbox"/>													
1.0149	S275J0H	<input checked="" type="checkbox"/>													
1.0145	S275J2	<input checked="" type="checkbox"/>													
1.0142	S275J2C	<input checked="" type="checkbox"/>													
1.0138	S275J2H	<input checked="" type="checkbox"/>													
1.0044	S275JR	<input checked="" type="checkbox"/>													
1.0128	S275JRC	<input checked="" type="checkbox"/>													
1.8818	S275M	<input checked="" type="checkbox"/>													
1.8843	S275MH	<input checked="" type="checkbox"/>													
1.8819	S275ML	<input checked="" type="checkbox"/>													
1.8844	S275MLH	<input checked="" type="checkbox"/>													
1.0490	S275N	<input checked="" type="checkbox"/>													
1.0493	S275NH	<input checked="" type="checkbox"/>													
1.0491	S275NL	<input checked="" type="checkbox"/>													
1.0497	S275NLH	<input checked="" type="checkbox"/>													
1.0426	P280GH	<input checked="" type="checkbox"/>													
1.0477	P285NH	<input checked="" type="checkbox"/>													
1.0478	P285QH	<input checked="" type="checkbox"/>													
1.0483	L290GA (API 5L: X42)	<input checked="" type="checkbox"/>													
1.0429	L290MB (API 5L: X42)	<input checked="" type="checkbox"/>													
1.0484	L290NB (API 5L: X42)	<input checked="" type="checkbox"/>													
1.0050	E295 (St50-2)	<input checked="" type="checkbox"/>													
1.0481	P295GH (17Mn4)	<input checked="" type="checkbox"/>													
1.0436	P305GH	<input checked="" type="checkbox"/>													
1.0482	P310GH (19Mn5)	<input checked="" type="checkbox"/>													
1.0437	P310NB	<input checked="" type="checkbox"/>													
1.0972	S315MC	<input checked="" type="checkbox"/>													
1.0973	S315NC	<input checked="" type="checkbox"/>													
1.0046	S320GP	<input checked="" type="checkbox"/>													
1.0060	E335 (S160-2)	<input checked="" type="checkbox"/>													
1.0473	P355GH	<input checked="" type="checkbox"/>													
1.8821	P355M	<input checked="" type="checkbox"/>													
1.8832	P355ML1	<input checked="" type="checkbox"/>													

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		FCAW															
		T 42 2 Y N 2															
		Coreshield 8								Coreshield 15							
		OK Tubrod 14.10								OK Tubrod 14.11							
		T 42 2 M M 13 H 5								T 42 2 M M 11 / T 42 2 M C 1							
		OK Tubrod 14.12								OK Tubrod 14.13							
		T 42 2 M M 12 H 5								T 42 2 M M 12 H 5							
		OK Tubrod 15.00								OK Tubrod 15.06							
		T 42 6 1 N I B M 1 H 5								OK Tubrod 15.13							
		T 46 2 P M 1 / T 42 2 P C 1 H 5								OK Tubrod 15.14							
		T 46 2 P M 2 / T 46 2 P C 2								PZ 6104							
		T 42 5 Z M M 2 H 5								PZ 6111							
		T 46 2 1 N R M 3 / T 42 2 1 N R C								PZ 6113							
		T 46 2 P M 1 H 10 / T 42 2 P C 1 H								PZ 6113-S							
		T 46 3 P C 2 H 5								PZ 6114							
		T 46 4 P M 1 H 5								PZ 6114-S							
		T 46 4 P C 1 H 5								PZ 6116-S							
		T 46 6 1 N P C 1 H 5								PZ 6125							
		T 42 6 1 N I B M 1 H 5								PZ 6130-S							
		T 42 4 B M 3 H 5 / T 42 4 B C 5 H 5								PZ 6138							
		T 46 5 1 N P M 1 H 5															
1.8833	P355ML2	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.0562	P355N	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0557	P355NB	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0565	P355NH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0566	P355NL1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.1106	P355NL2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8866	P355Q	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8867	P355QH	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0571	P355QH1	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8868	P355QL1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8869	P355QL2	○	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8814	S355G1 (+N)		○	○											○	○	○
1.8801	S355G2+N		○	○										○	○	○	○
1.8802	S355G3+N		○	○									○	○	●	●	●
1.8803	S355G4 (+M)		○	○									○	○	○	○	○
1.8804	S355G5+M		○	○									○	○	○	○	○
1.8805	S355G6+M		○	○									○	○	○	○	○
1.8808	S355G7+M (+N)		○	○									○	○	○	○	○
1.8810	S355G8+M (+N)		○	○									○	○	○	○	○
1.8811	S355G9+M (+N)		○	○									○	○	○	○	○
1.8813	S355G10+M (+N)		○	○									○	○	○	○	○
1.8806	S355G11 (+M) (+N)		○	○									○	○	●	●	●
1.8809	S355G12 (+M) (+N)		○	○									○	○	●	●	●
1.1182	S355G13+N (+Q)		○	○									○	○	○	○	○
1.1184	S355G14+N (+Q)		○	○									○	○	○	○	○
1.1190	S355G15+N (+Q)		○	○									○	○	●	●	●
1.0083	S355GP	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0554	S355J0C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0547	S355J0H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0577	S355J2	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0579	S355J2C	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0570	S355J2G3	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0576	S355J2H	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0045	S355JR	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0551	S355JRC	●	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych ($Re \leq 485$ MPa)

- = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
- = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		FCAW															
		Typ															
Material dodatkowy	Material rodzimy	Coreshield 8															
		T422YN12	T352ZY1	OKTubrod 14.10	T464MM2H5	OKTubrod 14.11	T424MM3H5	OKTubrod 14.12	T422MM11/T422MC1	OKTubrod 14.13	T422MM2H5	OKTubrod 15.00	T423BM2HS/T423BC2H5	OKTubrod 15.06	T4261NB1M1H6	T462PM1/T422PC1H5	T462PM2/T462PC2
1.0980	S420MC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8847	S420MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8836	S420ML	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8848	S420MLH	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8902	S420N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0981	S420NC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8750	S420NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8912	S420NL	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8751	S420NLH	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.0523	S430GP	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8975	L450MB (API 5L: X65)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8952	L450QB (API 5L: X65)	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8826	P460M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8837	P460ML1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8831	P460ML2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8905	P460N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8935	P460NH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8915	P460NL1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8918	P460NL2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8870	P460Q	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8871	P460QH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8872	P460QL1	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8864	P460QL2	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8878	S460G1+M (+Q)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8887	S460G2+M (+Q)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8883	S460G3 (+M)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8889	S460G4 (+M)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8885	S460G5+Q	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8884	S460G6+Q	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8827	S460M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0982	S460MC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8849	S460MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8838	S460ML	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.4850	S460MLH	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
1.8901	S460N	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
 ○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

- = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne
- = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych ($Re \leq 485$ MPa)

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

○ – zalecaný materiał dodatkowy; należy uwzględniać lokalne warunki i wymagania technologiczne
○ – odpowiedni materiał dodatkowy; należy uwzględniać lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych ($Re \leq 485$ MPa)

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

○ = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

K



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		SAW															
		Topnik								Drut							
Material rodzimy	Typ	OK Autrod 12.10				S 35 O MS S1				OK Autrod 12.10				S 35 2 MS S1			
		●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0566	P355NL1	○	●							○	●	●	●	●	●	●	●
1.1106	P355NL2	○	○							○	○	●	●	●	●	●	●
1.8866	P355Q	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8867	P355QH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0571	P355QH1	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.8868	P355QL1	○	●							○	●	●	●	●	●	●	●
1.8869	P355QL2	○	○							○	●	●	●	●	●	●	●
1.8814	S355G1 (+N)		●							●	●	●	●	●	●	●	●
1.8801	S355G2+N			●							●						
1.8802	S355G3+N				●							●					
1.8803	S355G4 (+M)					●						●					
1.8804	S355G5+M						●						●				
1.8805	S355G6+M							●						●			
1.8808	S355G7+M (+N)								●						●		
1.8810	S355G8+M (+N)									●					●		
1.8811	S355G9+M (+N)									●					●		
1.8813	S355G10+M (+N)									●					●		
1.8806	S355G11 (+M) (+N)									●					●		
1.8809	S355G12 (+M) (+N)									●					●		
1.1182	S355G13+N (+Q)									●					●		
1.1184	S355G14+N (+Q)									●					●		
1.1190	S355G15+N (+Q)									●					●		
1.0083	S355GP	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0554	S355J0C	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0547	S355J0H	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.0577	S355J2	○	●	●	○	○	○	○	○	●	●	●	●	●	●	●	●
1.0579	S355J2C	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.0570	S355J2G3	○	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0576	S355J2H	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.0045	S355JR	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0551	S355JRC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0596	S355K2	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.0594	S355K2C	○	●	●	○	○	○	○	●	●	●	●	●	●	●	●	●
1.0512	S355K2H	○	●	●	●	●	●	●	●	○	●	●	●	●	●	●	●
1.8823	S355M	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.0976	S355MC	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
1.8845	S355MH	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●

● = zalecany materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne



Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		SAW									
		Topnik					Drut				
Material rodzimy	Typ	OK Autrod 12.10	10.40	S 35.0 MS S1							
		OK Autrod 12.10	10.45	S 35.2 MS S1							
1.8834	S355ML	○	●								
1.8846	S355MLH	○	●								
1.0545	S355N	●	●	●	●	●	●	●	●	●	●
1.0977	S355NC	●	●	●	●	●	●	●	●	●	●
1.0539	S355NH	●	●	●	●	●	●	●	●	●	●
1.0546	S355NL	○	●			○	●	○	●	●	●
1.0549	S355NLH	○	●			○	●	○	●	○	●
1.0070	E360 (Si70-2)										
1.0499	L360GA (API 5L: X52)	●	●		●	●	●	●	●	●	●
1.0578	L360MB (API 5L: X52)	●	●		●	●	●	●	●	●	●
1.0582	L360NB (API 5L: X52)	●	●		●	●	●	●	●	●	●
1.8948	L360QB (API 5L: X52)	●	●		●	●	●	●	●	●	●
1.0522	S390GP	●	●	●	●	●	●	●	●	●	●
1.8973	L415MB (API 5L: X60)										
1.8972	L415NB (API 5L: X60)										
1.8947	L415QB (API 5L: X60)										
1.8824	P420M										
1.8835	P420ML1										
1.8828	P420ML2										
1.8932	P420NH										
1.8936	P420QH										
1.8830	S420G1+M (+Q)										
1.8857	S420G2+M (+Q)										
1.8851	S420G3 (+M)										
1.8859	S420G4 (+M)										
1.8853	S420G5+Q										
1.8852	S420G6+Q										
1.8825	S420M										
1.0980	S420MC										
1.8847	S420MH										
1.8836	S420ML										
1.8848	S420MLH										
1.8902	S420N										
1.0981	S420NC										
1.8750	S420NH										
1.8912	S420NL										
1.8751	S420NLH										

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○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

Typ		SAW									
Topnik	Drut	OK	Autrod	12.10	10.40	S 35 0 MS S1					
		OK	Autrod	12.10	10.45	S 35 2 MS S1					
Material rodzimy		OK	Autrod	12.10	10.71	S 35 4 AB S1					
		OK	Autrod	12.10	10.80	S 38 0 CS S1					
1.0523	S430GP										
	1.8975	L450MB (API 5L: X65)									
1.8952	L450QB (API 5L: X65)										
	1.8826	P460M									
1.8837	P460ML1										
	1.8831	P460ML2									
1.8905	P460N										
	1.8935	P460NH									
1.8915	P460NL1										
	1.8918	P460NL2									
1.8870	P460Q										
	1.8871	P460QH									
1.8872	P460QL1										
	1.8864	P460QL2									
1.8878	S460G1+M (+Q)										
	1.8887	S460G2+M (+Q)									
1.8883	S460G3 (+M)										
	1.8889	S460G4 (+M)									
1.8885	S460G5+Q										
	1.8884	S460G6+Q									
1.8827	S460M										
	1.0982	S460MC									
1.8849	S460MH										
	1.8838	S460ML									
1.4850	S460MLH										
	1.8901	S460N									
1.8953	S460NH										
	1.8903	S460NL									
1.8956	S460NLH										
	1.8908	S460Q									
1.8906	S460QL										
	1.8916	S460QL1									
1.8977	L485MB (API 5L: X70)						●				
	1.8955	L485QB (API 5L: X70)					●				

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Materiały do spawania stali niestopowych i niskostopowych (Re ≤ 485 MPa)

		Typ		SAW											
		Topnik	Drut	OK Autrod 12.10	10.40	S 35.0 MS S1	S 35.2 MS S1	S 35.4 AB S1	S 38.0 CS S1	OK Autrod 12.10	10.45	S 35.0 MS S1	S 35.2 MS S1	S 35.4 AB S1	S 38.0 CS S1
Materiał rodzimy	C22E			OK Autrod 12.10	10.81	S 42 A AR S1	S 42 A AR S1	S 46.0 AR S2	S 42 Z AR S2	OK Autrod 12.20	10.40	S 38.0 MS S2	S 38.2 MS S2	S 38.4 AB S2	S 38.5 AB S2
		○	○	●	●	●	●	●	●	○	○	●	●	●	●
1.1151	C22E	○	○	●	●	●	●	●	●	○	○	●	●	●	●
1.1158	C25E	○	○	●	●	●	●	●	●	○	○	●	●	●	●
1.0528	C 30			●	●	●		●	●	●	●	●	●	●	●
1.1178	C30E			●	●	●		●	●	●	●	●	●	●	●
1.0501	C 35														
1.1181	C35E														
1.0511	C 40														
1.1186	C40E														
1.0503	C 45														
1.1191	C45E														
1.0420	GE200 (GS-38)			○	●	●	○	○	○	●	●	○	●	●	●
1.0449	GS200			○	●	●	○	○	○	●	●	○	●	●	●
1.0445	GE240 (GS-45)			○	●	●	○	○	○	●	●	○	●	●	●
1.0455	GS240			○	●	●	○	○	○	●	●	○	●	●	●
1.0558	GE300 (GS-60)			○	●	●	●	●	●	●	●	●	●	●	●
1.1131	G17Mn5			○	●	●	○	○	○	●	●	●	●	●	●
1.0440	GL-A (S235JRS1)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0441	GL-A (S235JRS2)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0442	GL-B (S235J0S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0474	GL-D (S235J2S2)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0475	GL-D (S235J2S1)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0476	GL-E (S235J4S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0513	GL-A 32 (S315G1S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0514	GL-D 32 (S315G2S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0515	GL-E 32 (S315G3S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.8840	GL-F 32 (S315G4S)									●	●				
1.0583	GL-A 36 (S355G1S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0584	GL-D 36 (S355G2S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.0589	GL-E 36 (S355G3S)	●		●	●	●	○	○	○	●	●	○	●	●	●
1.8841	GL-F 36 (S355G4S)									●	●				
1.0532	GL-A 40 (S390G1S)									●	●				
1.0534	GL-D 40 (S390G2S)									●	●				
1.0560	GL-E 40 (S390G3S)									●	●				
1.8842	GL-F 40 (S390G4S)									●	●				

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○ = odpowiedni materiał dodatkowy; należy uwzględnić lokalne warunki i wymagania technologiczne