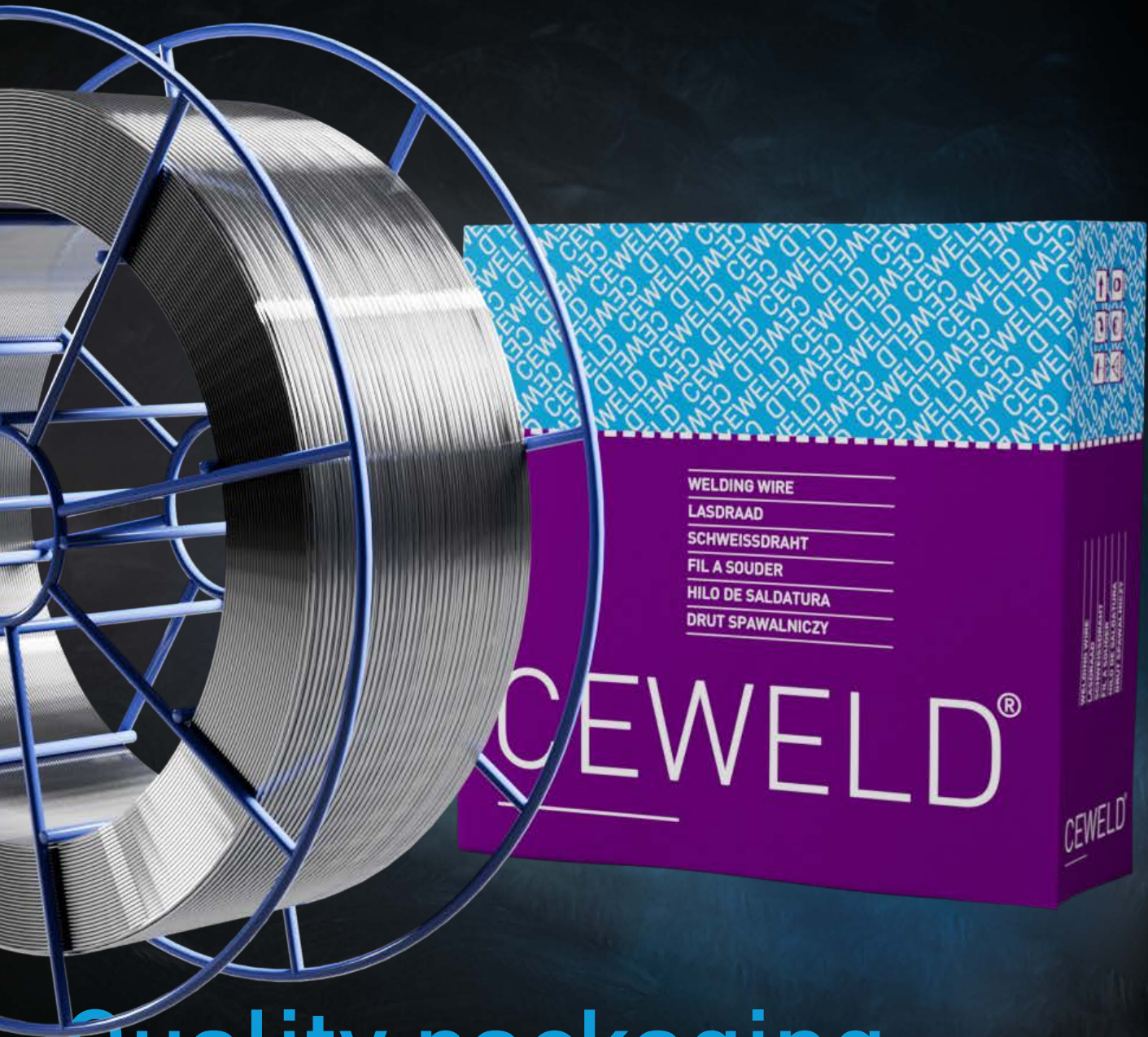




THE FILLER METAL SPECIALIST



Quality packaging

WELDING KNOWHOW PACKAGING AND STORAGE

www.certilas.com

Certilas

THE FILLER METAL SPECIALIST

The CEWELD product range is probably the widest range of filler metals you`l find in the market because we spend all our time and efforts on filler metals and not on welding related products such as welding machines, clamps and helmets.

Our metallurgical team and our application specialists are fully dedicated to improve and develop new products within the AWS or EN ISO standards but also developing special and new products is something that separates us from the competitor. With more then 2.000 tons welding consumables in stock we can grant our customers quick deliveries: goods ordered before 15.00 o`clock are usually shipped the same working day.

We operate from a very modern automated warehousing system and our complete supply chain system is covered by a unique traceability system to grant overall quality. Furthermore we offer very user-friendly Apps to easy calculate the cost for filler metal, gas and labor, and you can download certificates according EN 10204, 24 hours per day through our app and this website.

Our Welding consumables fully comply with the applicable international standards. Our aim is to keep looking forward and be the filler metal specialist.



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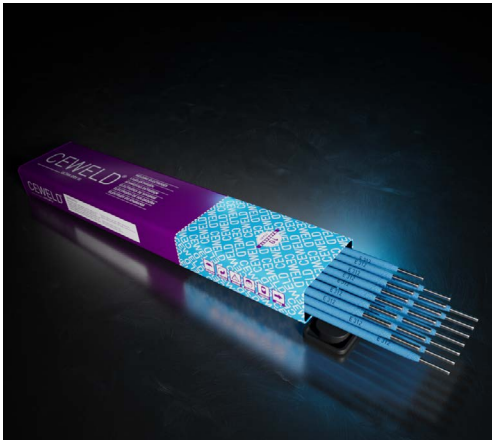
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STICK ELECTRODES



The most beautiful packing for stick electrodes

Hydrogen cracks at high tensile strength steels was the main driver behind the development of our new re-closable metal can for welding electrodes. Environment and other motivations were taken in consideration and end 2011 we launched the first hermetically sealable metal can on the market for welding electrodes. Metal packing seemed the best choice, 100% recyclable and now you can throw away your empty packing together with the metal scrap. Compare to the usual carton packing on the market it offers also the advantage that metal can not catch flame which is a huge step forward in fire prevention



The best vacuum packing for stick electrodes

In practical scenarios, vacuum-packed electrodes often experience leakage over time. Up to 40% losses occur within one year after purchase, and unfortunately, these issues are frequently detected too late. The standard vacuum packaging in the market appears to be overly sensitive to transport and storage conditions, leading to leaks.

To maintain consistent quality, we have an in-house vacuum packaging process that ensures the integrity of our vacuum-sealed packaging

Key Benefits of our vacuum packaging

Long-Term Storage Resilience: Survives extended storage periods without compromising electrode quality.

Durability: Withstands rough handling during both use and storage.



TIG Welding

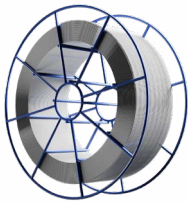
All TIG products are 1000mm long, and are delivered in tubes & boxes. Delivery sizes are 5kg. Aluminum is delivered in 2,5kg boxes.

A SELECTION OF AVAILABLE SPOOL TYPES



Plastic spool D 200

Diameter: 200 mm
 Width: 55 mm
 Suitable for: 50 mm hub
 Standard weight 5 kg
 (depending on the wire)



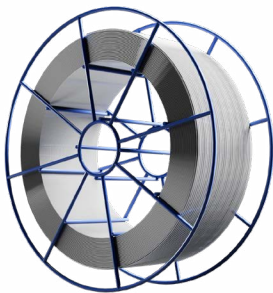
Basket spool BS 200

Diameter: 200 mm
 Width: 55 mm
 Suitable for: 50 mm hub
 Standard weight : 5 kg
 (depending on the wire)



Basket spool D 300

Diameter: 300 mm
 Width: 103 mm
 Suitable for: 50 mm hub
 Standard weight : 10 - 18 kg
 (depending on the wire)



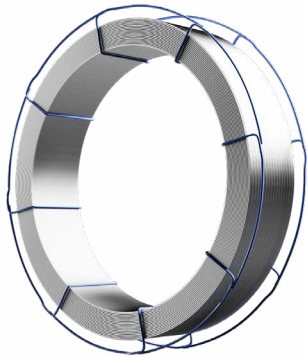
Basket spool S 300 & BS 300

Diameter: 300 mm
 Width: 108 mm
 Suitable for: 50 mm hub
 Standard weight : 10 - 18 kg
 (depending on the wire)



Basket spool B 300 (K 300)

Diameter: 300 mm
 Width: 100 mm
 Suitable for: 50 mm hub but an adaptor needed
 Standard weight : 10 - 18 kg
 (depending on the wire)



Basket spool B 415

Diameter: 415 mm
 Width: 100 mm
 Suitable for: 50 mm hub
 Standard weight : 20 - 30 kg
 (depending on the wire)



Reel S 760

Diameter: 7600 mm
 (500 mm also possible)
 Width: 290 mm
 Suitable for: 50 mm hub
 Standard weight : 150-300 kg
 (depending on the wire)

Available barrels

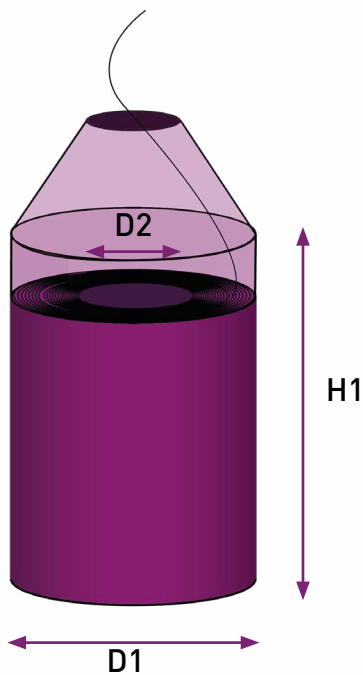
Diameter: 500 - 750 mm

Certilas bulk pack options can be supplied with a complete set of wire dispensing equipment, from the drum dolly, wire conduit, quick connectors to drum cones.

Contact us for more information.

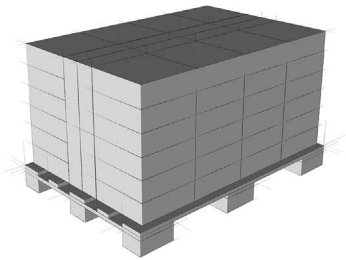
Euro pallet: 2 per Pallet 400-700 kg

Special Pallet: (1150 x 1150 mm) 4 per pallet 800-1400 Kg



Typ	d1 (mm)	d2 (mm)	h1 (mm)	Weight(kg)
1	500	300	480	max. 80
2	500	300	785	max. 250
3	510	300	810	max. 275
4	560	300	840	max. 375
5	570	300	790	max. 300
6	570	300	1000	max. 450
7	600	300	890	max. 500
8	600	300	1000	max. 450
9	630	300	890	max. 500
10	750	min 300	950	max. 750

A SELECTION OF POSSIBLE PACKING SCHEMES



FOR SPOOL TYPE B 300 / BS 300 / S300 / D 300

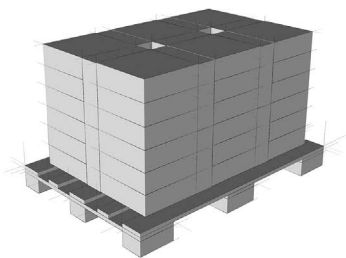
64 Spools per Euro-Pallet (15-20 kg each spool)

Net-weight: 960 - 1152 kg

Hight incl. Pallet: ~780 mm

Width: ~820 mm

Length: ~1220 mm



FOR SPOOL TYPE B 300 / BS 300 / S300 / D 300

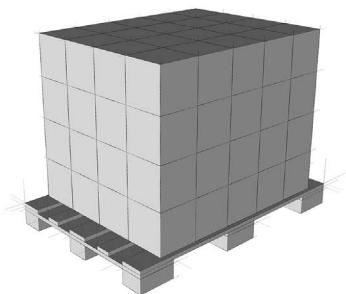
48 Spools per Euro-Pallet (15-20 kg each spool)

Net-weight: 750 - 900 kg

Hight incl. Pallet: 780 mm

Width: 820 mm

Length: 1200 mm



FOR SPOOL TYPE BS 200 / D 200

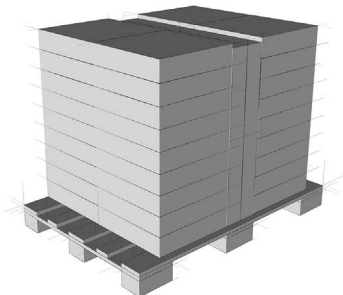
160 - 240 Spools per Euro-Pallet (5 kg each spool)

Net-weight: 800 - 1200 kg

Hight incl. Pallet: 850 mm

Width: 850 mm

Length: 1200 mm



FOR SPOOL TYPE BS 415

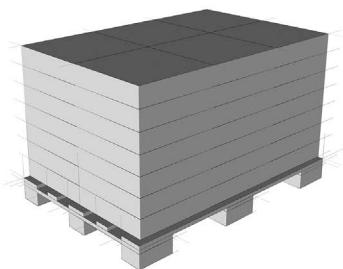
40 Spools per Euro-Pallet (20-30 kg each spool)

Net-weight: 800 -1200 kg

Hight incl. Pallet: 850 mm

Width: 850 mm

Length: 1200 mm



FOR SPOOL TYPE BS 415

42 Spools per Euro-Pallet (20-30 kg each spool)

Net-weight: 840 -1260 kg

Hight incl. Pallet: 850 mm

Width: 850 mm

Length: 1260 mm

Cardboard tube

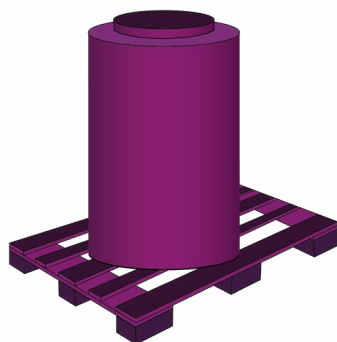
1 tube per Euro-Pallet

Net-weight: 850 -1000 kg

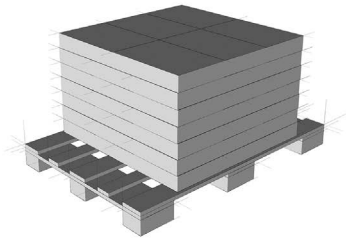
Hight incl. Pallet: 900 - 1350 mm

Width: 800 mm

Length: 1200 mm



POWDER



AL BAG FOR WELDING FLUX

H 620 mm x W 320 mm x L 100mm

Net-weight: per pack 25 kg

AL Bag on Pallet

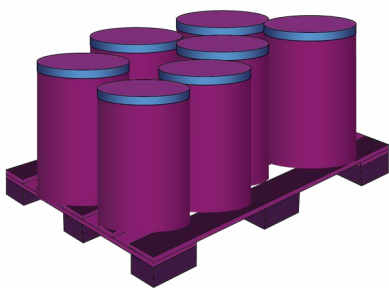
42 per Euro-Pallet

Net-weight: 1050 kg

Height incl. pallet 1000mm

Width: 1150 mm

Length 1150 mm



PE and AL Bag on Pallet

H 445 mm, D 300

Netto-Gewicht: 25 kg 18 pro Euro- Palette : ~ 450 kg

Net-weight:

Width: 820 mm

Length 1260 mm

Other possible pallets

Width: 1150 mm

Length 1150 mm



BIG BAG

H 1150 mm x W 1150 mm x L 1120 mm

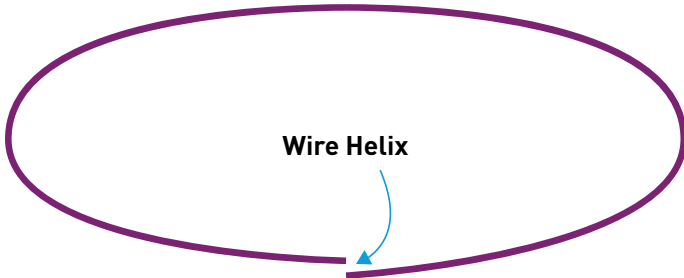
Net-weight: 960 kg 1 pro Palette

Height incl. pallet 1120 mm

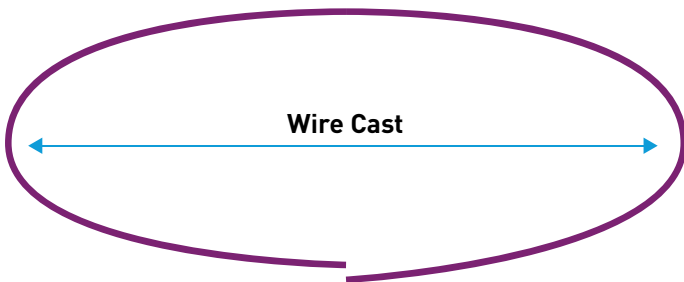
Width: 1150 mm

Length 1150 mm

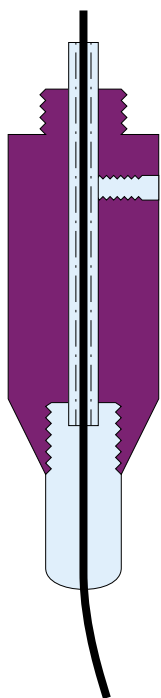
HELIX, CAST AND TWIST



Helix - The helix of welding wire is the distance the unspooled wire rises from the floor. The average wire might have a helix of 25 mm from Spools like S 200 mm over this like B 300 it can 50 mm which is acceptable for AWS and ISO but contributes to over-welding, more labor and more filler metal. The helix contributes to an oscillation of wire and therefore, makes the weld bead wider. This increases heat, distortion, time and weld cracking. Have you measured the helix of your welding wire lately?

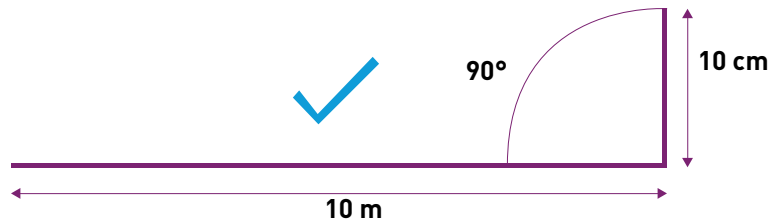


Cast - The cast of welding wire is essentially the diameter of the wire when you take it off of the spool. Average weld wire packaged on a spool has a cast of 660 mm whereas a true robotic weld wire does not have cast, but instead forms a sinewave when laid on the floor. This permits a faster welding speed and less spatter because the weld wire is precisely melted into the joint.



Cast forces wire to make better electrical contact with the tip

Twist - The twist is more difficult to test than the helix and cast, but can be carried out in the application. To do this, pull approximately 10 m of the wire from the barrel or from the large spool. Bend the end of the wire by 90 degrees and hold the bent part in the 12 o'clock position. Attach the other end so that it cannot turn. Then pull the wire 10 meters and release the wire slowly so that it can rotate. More than two turns for 10 m is a lot and could cause problems with the contact of the wire in the torch or can lead to knots in barrels. Coiled wire generally has the biggest problem with cast and helix, while twisting is less common.



STORAGE RECOMMENDATIONS FOR WELDING CONSUMABLES

COATED ELECTRODES

Store electrodes always in original (re)closable cans and reclose the can after taking out the electrodes. Ultra Dry III vacuum packed electrodes can be used for approximately 6 hours after opening the packaging without re-drying, the atmospheric conditions must be $\leq 35^{\circ}\text{C}$ and $\leq 90\%\text{RH}$. When electrodes out of the original packaging are exposed for more than 10 hours to an atmosphere with relative humidity of $\geq 60\%$, re-drying is recommended. For electrodes with a yield $\geq 460\text{MPa}$ the recommendation is a maximum of 3 times re-drying.

SOLID-, SEAMLESS FLUX-CORED WIRE AND STRIP

Store wire always in the undamaged original packaging. We recommend especially for aluminum wires to acclimatize them for 24 hours in the workshop. Solid-, seamless flux-cored wires and strip don't need re-drying. A large temperature difference should be avoided in order to prevent condensation.

Wire Storage Recommendations:

Dry Area: Store wires in a dry environment to prevent moisture-related issues.

Avoid Weather Exposure: Keep wires away from weather influences such as rain or extreme humidity.

Original Packaging: Whenever possible, store wires in their original packaging to maintain their integrity.

Temperature Consideration: Avoid sudden temperature drops to prevent the formation of condensate water on the wires.

It is sufficient to slightly warm the storeroom during winter months. Partly used wire spools must be re-packed in their original plastic bag, carefully sealed, and stored in their original cardboard boxes. Remember these guidelines to ensure proper wire storage.

SAW (UP) AND ESW WELDING POWDER

Store fluxes always in undamaged and unopened original steel can or bag. Keep fluxes away from water, oil and grease products. Unprotected fluxes must, after 12 hours use, be re-dried in a drying oven.

Recycling:

Moisture, oil and grease must be removed from the compressed air used for the recycling system. Addition of new flux must be done with the proportion of at least one part new flux on three parts recycled flux.

Re-drying:

Agglomerated fluxes 2-4 hours at $300^{\circ}\text{C} \pm 25^{\circ}\text{C}$

Fused fluxes 2-4 hours at $200^{\circ}\text{C} \pm 50^{\circ}\text{C}$

FOLDED FLUX-CORED WIRE

Store wire always in the undamaged original packaging. When there are big temperature differences between night and day, recommendation is to keep the spool not on the machine at night, but to store the spool in a room where the temperature is above the dew point.

Re-drying:

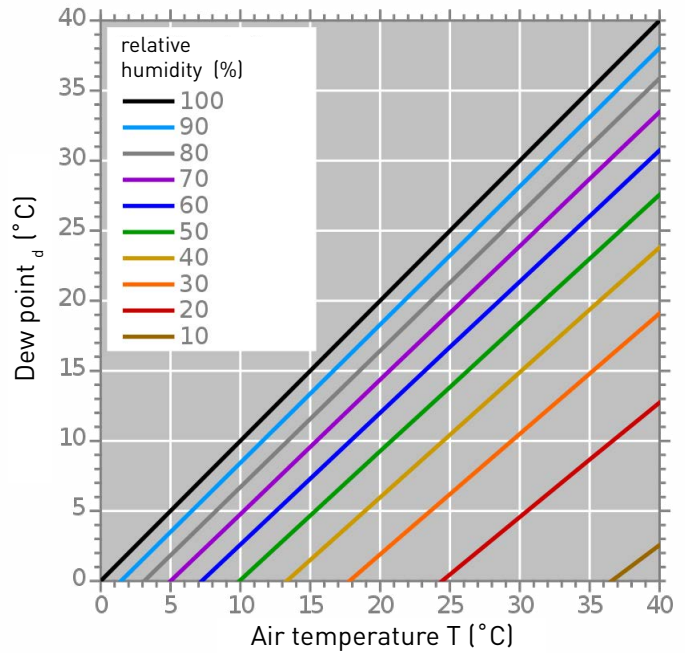
Steel spools: At least 4 hours at 150°C

Plastic spools: At least 48 hours at 50°C

KEEPING AND STORAGE OF WELDING CONSUMABLES

In general, all products that are stored in unopened original packaging can be kept with observance of the following: Electrodes, welding wires and fluxes must be protected against atmospheric influences such as rain, snow and condensation. In order to be sure that no condensation takes place in these products it is recommended to store the products in an environment which is above the dew point. This temperature is dependent on the prevailing relative humidity of air at that place.

AVOID CONTACT WITH WATER, OIL AND GREASE. IN GENERAL, A MAXIMUM STORAGE PERIOD OF 3 YEARS APPLIES TO ALL WELDING CONSUMABLES AND FLUXES.



TEMPERATURE CONSIDERATIONS FOR WIRE STORAGE:

- Avoid Sudden Temperature Drops:** Prevent abrupt changes in temperature.
- Prevent Condensation:** Take measures to avoid the formation of condensation.
- Stay Above Dew Point:** Ensure that the temperature does not fall below the dew point.

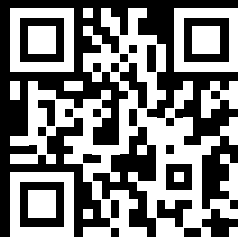
For instance, if the daytime temperature is 30°C and the nighttime temperature drops to 22°C with a relative humidity of 70%, condensation may form on the surface of cool wires during the morning hours. It's crucial to prevent this occurrence.

Feel free to reach out if you have any further questions!

DISCLAIMER

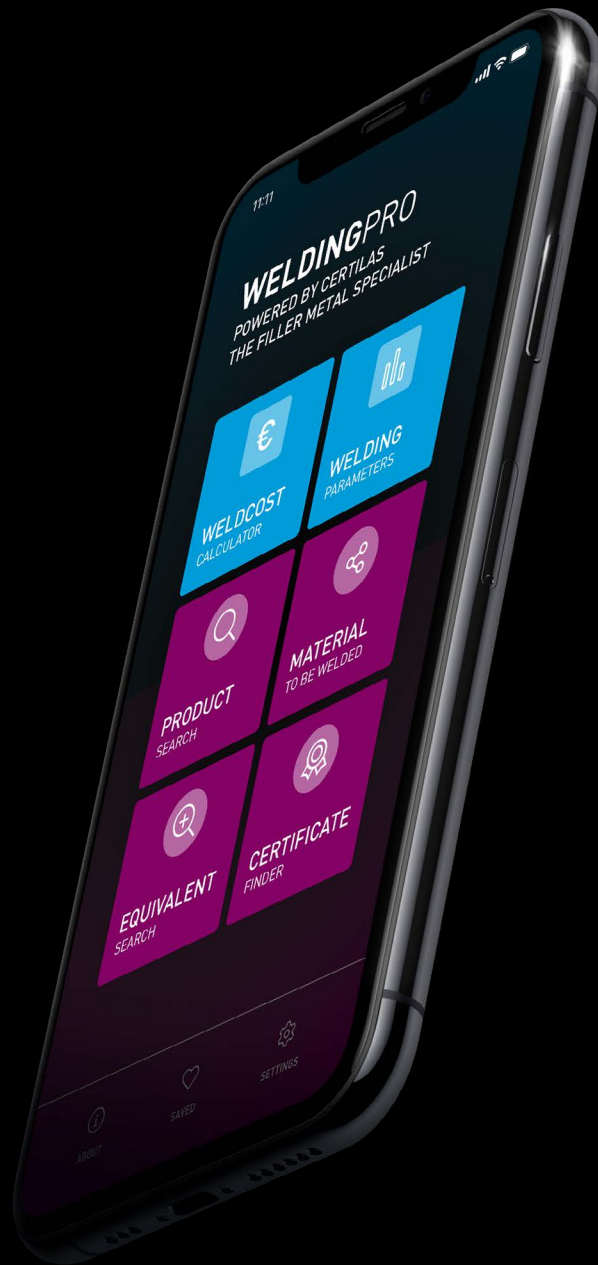
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