## HARDFACING COMPARISON CHART

**Electrodes**

| | Unibraze | Postle | Select Arc | Artec | Lincoln | McKay | Stoody |
|---|---|---|---|---|---|---|---|
| 1 | | 14 | | | | | |
| 2 | | 21 | | 60 Ecoface | MM or M1 | 58 | SelfHardening |
| 3 | | 26 | | | | | |
| 4 | | 27 | | Railtec | BU | 32 | BuildUpLH |
| 5 | | 30 | | 264/Unicron265 | | | |
| 6 | | Super 35 | | 222 | | | |
| 7 | | 40 | | 440S | | | |
| 8 | | 50 | | 2 | | | |
| 9 | | 51 | | 2000/3 | | | |
| 10 | | 52 | | 1 | | | |
| 11 | | 94 | | 606 | | | |
| 12 | | 95 | | 604C | | | |
| 13 | | 205 | | 0-Ni-Mang | Mangjet | 118 | DynaMang/NicroMag |
| 14 | | 206HD | | 207/275/277/278 | | | |
| 15 | | 207 | | 41 Cr-Ni-Mang | 15CrMn | ChromeMang | 2110 |
| 16 | | 210 | | | | | 19/21/77 |
| 17 | | 213 | | | ME | 48/140 | 21/31 |
| 18 | | 214 | | 63 Hardcro | 60 | 155 | 35 |
| 19 | | 215HD | | 661T | | | |
| 20 | | 216HD | | | | | |
| 21 | | 218HD | | | | | |
| 22 | | 247CB | | | 70 | | |
| 23 | | 248CB | | 67 | | | 145 |
| 24 | | 249 | | | | | |
| 25 | | 250 | | 88 | | | |
| 26 | | 301 | | | | | Versaloy GP |
| 27 | | 305 | | | | | |
| 28 | | 306HD | | | | | |
| 29 | | 344 | | 220 | | | |
| 30 | | 505 | | 125 | | | Cast Weld GP |
| 31 | | 515 | | 139 | | | Cast Weld M |
| 32 | | 950 | | 603PHB | | | |
| 33 | | 5150 | | 90 | | | |

**Cored Wire**

| | Unibraze | Postle | Select Arc | Artec | Lincoln | McKay | Stoody |
|---|---|---|---|---|---|---|---|
| 1 | | 14 | | | | | |
| 2 | | 285-FCO | | | | 219-0 | 120-0 |
| 3 | | 287-FCO | BU | | BU/33 | BU-0 | Buildup 0 |
| 4 | Techniwear 71P | 299-SPL | | | | WC-O | 130-O |
| 5 | | 2817-FCO | 44 | | | 244-O | 117 |
| 6 | Techniwear 50 | 2820-SPL | 50 | | 50 | 240-O/250-O | 121,131 or Sa/53 |
| 7 | Techniwear 8262M | 2826-SPL | | | | | |
| 8 | | 2829-SPL | | | | | |
| 9 | Techniwear 61 | 2832-SPL | 60HC | | 60-0 | 255G | 101 HC |
| 10 | Techniwear 58 | 2834-SPL | | | 60-0 | 255-O/258TiCo | 100HC |
| 11 | Techniwear 67M | 2836-SPL | 65 | W 5070M | | A45-O | 145 |
| 12 | | 2849-SPL | | | | | Van Car |
| 13 | | 2850-FCO | MN | | Lincore M | 218-O | Nicro/Dynamang |
| 14 | | 2853-FCO | | | | | |
| 15 | | 2865-FCO | GP | WD1041 | 15CrMn | AP-O | 110 |
| 16 | | 2871-SPL | | | | | |
| 17 | Techniwear 25 | 2891-SPL | | | 33 | BU-O/242-O | Build-up G |
| 18 | Techniwear 40 | 2892-SPL | 42 | WD1030 | 40-O | 242-O/BU-G | Super BuildUp/105-G |
| 19 | | 2893-SPL | | | | | 105-G |
| 20 | Techniwear 56 | 2898-FCO | 52W / 58 | FCS558 | 55-O T&D | 258-O | 965-O/G, 102-O/G |
| 21 | | 2898-SPL | | | 55-G | 260-G | |
| 22 | | 2899-SPL | | | | 258-S | |
| 23 | Techniwear CF65 | CF27 | | | | | |

# HARDFACING COMPARISON CHART

**Electrodes**

| Eutectic | Filotech | Sodel | Soudotec | Airco | Allstate | Certainium | Cronatron | |
|---|---|---|---|---|---|---|---|---|
| 9000 | | 59 | 359 | | | 27-B | 99 | 1 |
| N2/N61 | | 22/221 | 390 | 388 | ard-Tuf 56 | 267 | | 2 |
| 6800/6899 | | | | | | | | 3 |
| 4002/2-B | | | | Hardcraft250 | Roll Matrix | 283 | | 4 |
| 0/680CGS/4026 | | 330/335 | 230/265 | | 275/275super | 707/707SP/770 | 333/3330 | 5 |
| BeautyWeld/4666 | | 31 | 222 | | Steel Arc+ | 702 | 338 | 6 |
| 101/2109/4021 | | 18 | 70 | | 34 | 608 | 510 | 7 |
| 23/244/2233 | | 35 | 160 | | 4-60/SuperS-60 | 889 | 211/2110 | 8 |
| 2/24/2240 | | 355/389 | 169 | | 4 IMP | | 222 | 9 |
| 27 | | 352 | 168 | | 6 IMP | 885 | 235 | 10 |
| 1851 | | 661 | 561/563 | | 20 | 425 | 625 | 11 |
| 28 | | | | | 24 AC/DC | 429 | 666 | 12 |
| 40 | | 324 | 342 | Mangcraft | Ni-Matrix | 282 | 777 | 13 |
| 646XHD | | 333 | 277 | | Super Join M | 706/792 | 7770 | 14 |
| 4 | | 325 | 340 | 361 | | | | 15 |
| | | | | | | | | 16 |
| | | | | | HS-7 | | | 17 |
| 5005 | | 2024 | 330 | CR70 | HS-2C | 281 | 711 | 18 |
| | | | | | | 247 | 7330 | 19 |
| | | | | | | 246 | 7350/7355 | 20 |
| | | | | | | 248/249 | 7230/7370 | 21 |
| 6710 | | 2023 | 333 | | | | | 22 |
| 6715 | | | | | HS-65W | | | 23 |
| 112 | | | | | | 222/223 | | 24 |
| hamfertrode | | 112/512 | 212/211/G/12 | | Chamfer Rod | 100 | 110/1100 | 25 |
| 680/4026 | | 330/335 | 230/265 | | 275/Super275 | 707/770 | 333/3330 | 26 |
| Super 110 | | 32/320 | 220 | | HY-10 | 705 | 375 | 27 |
| 66XHD | | 127 | 218 | | 616 | 747 | | 28 |
| Steeltectic | | 30/11 | 21 | | Steel Arc+ | 701 | 321 | 29 |
| 3055/4055 | | Ni-60 | Ni-62 | | 8-60. | | | 30 |
| 3099/4099 | | Ni-99 | Ni-98 | | 8 | | 8 | 31 |
| 280/2800 | | 361 | | | 24DC | 423 | | 32 |
| | | CU 89 | 189 | | | | | 33 |

**Cored Wire**

| Eutectic | Filotech | Sodel | Soudotec | Airco | Allstate | Certainium | Cronatron | |
|---|---|---|---|---|---|---|---|---|
| 9000 | | 59 | 359 | | | 27-B | 99 | 1 |
| OA3206 | | | | | | | | 2 |
| | | | | | | | | 3 |
| | | | | | | | | 4 |
| | | | | | | | | 5 |
| O25A/4625 | HA-3/HA 50 | 8210 | 8332 | | | 248 FC | | 6 |
| | | | | | | | | 7 |
| | | | | | | | | 8 |
| DO-10 | | | | | | | | 9 |
| DO-10/4601 | HA 60 | 8240 | 8330 | | | | | 10 |
| 3952 | | | | | | | | 11 |
| | | | | | | | | 12 |
| OA 3220 | | 9240 | 8342 | | | | 7109MN | 13 |
| | | | | | | | | 14 |
| 3205 | Macromang | 9250 | 8340 | | | 282 FC | 7100 SS | 15 |
| DO-14 | | | | | | | | 16 |
| 3010A | HA-1 | 9320**** | | | | | 7940 | 17 |
| | | 9320**** | | | | | | 18 |
| | | | | | | | | 19 |
| 4415 | | | | | | 246 FC | | 20 |
| 4415 | | | | | | 246 FC | | 21 |
| | | | | | | | | 22 |
| | | | | | | | | 23 |

# HARDFACING COMPARISON CHART

**Electrodes**

| | Unibraze | Postle | Hobart | MG | Nassau | OMR | Rankin |
|---|---|---|---|---|---|---|---|
| 1 | | 14 | | 799 | Polaris-G | | |
| 2 | | 21 | | 755/760 | Olympia A | HA600 | BX |
| 3 | | 26 | | | Gemini C | | |
| 4 | | 27 | | 740 | | | BU/700 |
| 5 | | 30 | | 600/Super600 | Brutus AAA/Brutus A | A220 | |
| 6 | | Super 35 | | 500 | Tartan A | A177 | |
| 7 | | 40 | | 400 | Neptune A | A131/A130 | |
| 8 | | 50 | | 210/289 | Jupiter A | A150/A154 | |
| 9 | | 51 | | 200 | Jupiter B | | |
| 10 | | 52 | | 220 | | | |
| 11 | | 94 | | 300 | | | |
| 12 | | 95 | | 310 | Venus B | | |
| 13 | | 205 | | | Apollo A | HA501 | RanMang 1 |
| 14 | | 206HD | | 750 | | HA500 | |
| 15 | | 207 | | 745 | | | RanMang 2 |
| 16 | | 210 | | | | | C |
| 17 | | 213 | | | | | M |
| 18 | | 214 | | 765/770 | Omega N | HA601 | 35 |
| 19 | | 215HD | | 7065/7070 | Zota C | | 303 |
| 20 | | 216HD | | | | | 305 |
| 21 | | 218HD | | 7090 | | | 203 |
| 22 | | 247CB | | | | | |
| 23 | | 248CB | | 790 | | | |
| 24 | | 249 | | 780/788 | | | |
| 25 | | 250 | | 570 | Electra | | |
| 26 | | 301 | | 600/Super600 | Brutus AAA/Brutus A | | |
| 27 | | 305 | | 530 | | A213 | |
| 28 | | 306HD | | 540 | Polaris A | A183 | |
| 29 | | 344 | | 505 | Tartan B | | |
| 30 | | 505 | | 260 | | | |
| 31 | | 515 | | 250 | | | |
| 32 | | 950 | | 320 | Venus A | | |
| 33 | | 5150 | | | | | |

**Cored Wire**

| | Unibraze | Postle | Hobart | MG | Nassau | OMR | Rankin |
|---|---|---|---|---|---|---|---|
| 1 | | 14 | | 799 | Polaris-G | | |
| 2 | | 285-FCO | | | | | |
| 3 | | 287-FCO | | | | | BU |
| 4 | Techniwear 71P | 299-SPL | | | | | Rantung WC |
| 5 | | 2817-FCO | | | | | O/BX-2 |
| 6 | Techniwear 50 | 2820-SPL | 16-O | | | | Rankin C/O |
| 7 | Techniwear 8262M | 2826-SPL | | | | | |
| 8 | | 2829-SPL | | | | | D |
| 9 | Techniwear 61 | 2832-SPL | 43-O | | | | R-101 |
| 10 | Techniwear 58 | 2834-SPL | 38-O | | | | Rankin H/100 |
| 11 | Techniwear 67M | 2836-SPL | 45-O | | | | 23 |
| 12 | | 2849-SPL | | | | | |
| 13 | | 2850-FCO | 150-O | | | | Automang 1 |
| 14 | | 2853-FCO | | | | | |
| 15 | | 2865-FCO | MC-O | | | | Automang 3 |
| 16 | | 2871-SPL | | | | | |
| 17 | Techniwear 25 | 2891-SPL | 250/BU-0 | | | | Build Up |
| 18 | Techniwear 40 | 2892-SPL | 40-O | | | | |
| 19 | | 2893-SPL | | | | | BB-G |
| 20 | Techniwear 56 | 2898-FCO | | | | | Ranomatic BX/D |
| 21 | | 2898-SPL | 960 | | | | Rankin 969/DDG |
| 22 | | 2899-SPL | 55-O/S | | | | Ranomatic 200 |
| 23 | Techniwear CF65 | CF27 | | | | | |

# HARDFACING COMPARISON CHART

## Electrodes

| Rexarc | Soudokay | Stulz | UTP | WA | Welding Alloys | Weld Mold |
|---|---|---|---|---|---|---|
| | | 4 | | | | |
| | | | 67S/6700/600 | | | |
| | | | 700/7000 | | | 673 |
| | | Build Up | 620/622 | | | 525 |
| | | | 65 | | | 880/8800 |
| | | | 611 | | | 201 |
| | | | 48/49 | | | 11C |
| | | | 8FN/84FN/85FN86FN | | | |
| | | | 8/8KO/8S/8VW/83/8811/888 | | | |
| | | | 81/81S | | | 777 |
| | | | 34N | | | |
| | | | | | | |
| | | XL | 7200 | | | 325 |
| | | | 63/630 | | | |
| | | | | | | |
| | | | | | | |
| | | Universel | | | | |
| | | 60 | 7100/711B/61 | | | 353 |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | 713 | | | |
| | | 75 | 75 | | | |
| | | | 82AS | | | 100 |
| | | | 65 | | | 880/8800 |
| | | | 62/Super TI | | | |
| | | | 613Kb/614Kb | | | 515 |
| | | | 612 | | | 202 |
| | | | 55 | | | 750 |
| | | | 99 | | | 700 |
| | | | 32 | | | |
| | | | | | | |

## Cored Wire

| Rexarc | Soudokay | Stulz | UTP | WA | Welding Alloys | Weld Mold |
|---|---|---|---|---|---|---|
| | | 4 | | | | |
| | | | | | | |
| | | | OA300/OA1020 (1/16 and 7/64) | | T-O | |
| | | | | | 60/3/D-O | WM-SA.WC |
| | | | | | DP-O | |
| A-11 | 450-O/500-O | 12 S/A | OA2000/OA2010/OA400 | | MC-O | |
| | | | | | | |
| | | | OA2040 | | | |
| | | | OA2030 | | | |
| A-01 | 785-O/600TiCo | No.10 | | | HC-O | |
| | | | OA-2040 | | CNV-O | CNV-O |
| | | | | | | |
| Ni-Mang | 14MnCr-O | XL-S/A | OA1000/OA7200 | | NM-O | |
| | | | | | | |
| 1414 | 450-O | 1616/SA | OA1010/OA450 | | AP-O | |
| | | | | | | |
| AS-3 | 300-O | Build Up | OA1020/OA300/OA350/OA250 | 250 HT | T-O | 525 FC |
| | | 50 S/A | OA1020 (.045) | 300HT/350HT | R-O/G | |
| | | | | | | |
| A-12 | 600-O | | OA500/OA600/OA2020(1/16,7/64) | 600HT | WLC- O/G | |
| | | | OA1015 | 600HT | L-G/W-D | |
| A-12 | | | OA2020 (.045) | | W-G/S | |
| | | | | | | |