

Bimeccanica has “*Castolin*” electrodes specifically for welding accessories to the steel used for the trapezoidal screws and related components.
The electrodes are supplied by us in 2,5 Kg boxes or loose in quantities required by the client.

List of electrodes available from stock:

- > **Electrodes art. “EC 4080”** excellent for welding steel AVP R50/R80/R100 - 39NiCrMo3 ($\varnothing 2,4 \times L.250$ - Kg 2,5 box = about 170 pieces).
- > **Electrodes art. “33500”** specifically for welding stainless steel AISI 303/304/316 ($\varnothing 2,4 \times L.300$ - Kg 2,5 box = about 130 pieces).
- > If having to weld screws and components in anticorrosive 100 aluminium alloy we can supply art. “EC 4001” electrodes on request.

CODE (LOOSE)	ARTICLE (LOOSE)	CODE (BOX)	ARTICLE (BOX)	For welding materials:
108ECS00	EC 4080/SF	108ECC00	EC 4080/SC (Kg 2,5)	Steel R50/R80/R100
108ECS01	33500/SF	108ECC01	33500/SC (Kg 2,5)	Stainless steel AISI 303/304/316
108ECS02	EC 4001/SF	108ECC02	EC 4001/SC	Anticorrosive 100 aluminium alloy



Trapezoidal screws with threaded shanks with insertion of Threaded Sleeve Nuts “MFA/MFI” and welding in relief or hidden to guarantee axial support of the load from the unscrewing of the sleeve nut itself. **PHOTO(1)** welding and thread visible - **PHOTO(2)** welding turned and visible - **PHOTO(3)** internal welding and turning to flush finish



Nuts/lead nuts welded with *Castolin EC 4080* electrodes. **PHOTOS (4/5/6)** welding of “CQA” nut with Safety Support “TDS” for strong support of the load.
PHOTO (7) welding of “CQA” nut directly to the structure but with low load support.

