

**По вопросам продаж и поддержки обращайтесь:**

Алматы (7273)495-231	Казань (843)206-01-48	Новокузнецк (3843)20-46-81	Смоленск (4812)29-41-54
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Екатеринбург (343)384-55-89	Москва (495)268-04-70	Санкт-Петербург (812)309-46-40	Хабаровск (4212)92-98-04
Иваново (4932)77-34-06	Мурманск (8152)59-64-93	Саратов (845)249-38-78	Челябинск (351)202-03-61
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Россия (495)268-04-70	Киргизия (996)312-96-26-47	Казахстан (7172)727-132	



# DRY AND WET LUBRICANTS FOR WELDING WIRE

CO2 wire, electrodes, FCW, Sub Arc, Copper Coated and Copper free CO2 wires

PANLUBE ®	PROPERTIES	CHARACTERISTICS	SURFACE PREPARATION
<b>S37</b>	calcium lubricants	For medium drawing speed (12-16 m/s).	Mechanical descaling.
<b>S44</b>		For high speed (12-16 m/s).	
<b>S55</b>	calcium lubricant low fat content	For high speed (up to 20 m/s).	1. mechanical descaling 2. acid pickling, lime or borax or PANCOVER coating
<b>S59</b>	calcium lubricant medium fat content	Easy to be removed in the following wet drawing operation.	Mechanical descaling.
<b>S103</b>	calcium lubricant, medium fat content, high melting point	For very high speed, in combination with S55 or S44.	1. mechanical descaling 2. belt descaling and borax or PANCOVER coating
<b>S104</b>	calcium lubricant	High lubrication and high melting point.	Mechanical descaling.
<b>S244</b>	calcium lubricant medium fat content	For very high drawing speed, on the first dies followed by sodium (S1285- S1440), not suitable for the further wet drawing operation.	Orbital belt descaling and pre-coating (Pancover 4780).
<b>S466</b>	calcium - sodium lubricant medium fat content	For high drawing speed, on the first dies followed by sodium (S1285 - S1440), not suitable for further wet drawing operation.	Orbital belt descaling and pre-coating (Pancover 4780) or pickled and salt coated material.
<b>S2000</b>	calcium - sodium lubricant medium fat content	For final dies after a calcium lubricant (S44, S55, S59, S103).	1. mechanical descaling 2. acid pickling + lime or borax or PANCOVER coating
<b>S1280</b>	low borax sodium lubricant with high content of stearic acid	For high drawing speed, on final dies in combination with S466, S55 or S244.	1. mechanical descaling 2. orbital belt and pre-coating 3. acid pickling, lime, borax or PANCOVER coating
<b>S1285</b>	borax free sodium lubricant with high content of stearic acid		
<b>S1440</b>	low borax sodium lubricant, high melting point		
<b>S1103</b>	special lubricants for skin pass	Very good neutralization properties and high feedability in the welding machine.	Copper-bronzed coated wire
<b>L30SP</b>			
<b>L3000</b>	water soluble liquid lubricants: different balance of degreasing and lubrication	Strong stability against the action of lime and calcium lubricants, excellent degreasing action to prepare the surface for the further copper coating process. Developed also to offer an excellent resistance to acid contamination and high die life of skin pass die at very high drawing speed.	After first drawing from: 1. mechanically descaled rod 2. mechanically descaled and PANCOVER coating 3. pickled and lime or PANCOVER coating
<b>L3009</b>			
<b>L3019</b>			



PANLUBE ®	PROPERTIES	CHARACTERISTICS	SURFACE PREPARATION
L3048	special lubricant for skin pass	Special oil to be used for the skin pass of copper coated wire with PCD dies at high speed (up to 30 m/s).	
L3110	liquid oils not water soluble	For the protection and lubrication of the copper coated welding wire.	Anti-rusting agents and protective oils.
L3112		For the protection and lubrication of the copper free welding wire.	
G4250	special water dispersible grease	For the lubrication of the skin pass of copper free wire.	Acid cleaning and neutralising.
PANCOVER ®			
4722	water soluble salt compound	Preparation of bath for the production of copper free CO2 welding wire.	Copper free CO2 welding wire.
PANCHEM ®			
5625	water soluble powder	Preparation of bath for the production of bronze CO2 welding wire.	Bronze coated CO2 wire.
5630			

## DRY AND WET LUBRICANTS FOR FLUX CORE WIRE

PANLUBE ®	PROPERTIES	CHARACTERISTICS	SURFACE PREPARATION
S466	calcium - sodium lubricant	For breakdown operation.	
S600	calcium lubricants high content of stearic acid	Fine product for in-line drawing at high speed. It contains Molibendum.	Forming and rolling without coating.
S600VMO		Fine product for in-line drawing at high speed. It contains Molibendum. For non baked type.	
S601		Very fine product with graphite and additives for baked type FCW.	
S1504	borax free sodium lubricant	For the first die after filling up.	Seamless tube.
L3000	water soluble liquid lubricant	For wet drawing of seamless FCW before copper coating.	

## WIRE FOR ELECTRODES

PANLUBE ®	PROPERTIES	CHARACTERISTICS	SURFACE PREPARATION
S56	calcium lubricant	Low residual on the wire.	Mechanical descaling or pickled and lime coated rod.
S433		For old machine with bad cooling.	
S616	calcium - sodium lubricants	To be used on all the dies with the last die in water.	Mechanical descaling.
S622		To be used for big diameters with the last die in water.	
S933		To be used on all the dies, low residual easy to be removed in water.	
S1450	borax free sodium lubricant	Low consumption, clean wire.	Mechanical descaling or pickled and lime coated rod.

## PHOSPHATE COATINGS (PANCOVER F SERIES)

PANCOVER ®	PROPERTIES	CHARACTERISTICS	SURFACE PREPARATION
F4500A	zinc phosphates accelerated with nitrate/nitrite	For general applications for cold heading and high carbon steel wire: high coating weight, very adherent crystals. Suitable for oil and dry lubrication. It can be used either for batch or in-line treatments.	
F4501P			
F4620UN	zinc phosphates accelerated with nitrate/chlorite	Universal product for application on high and low carbon steel, on acid pickled or shot blaster rod. Single product easy to use, very stable working conditions. It produces a smooth and black finish on the drawn wire, it can be used for batch or in-line operations.	1. acid pickling 2. shot blasting
F4640		It is specific for cold heading wire, prepared by acid pickling: high coating weight suitable for the reactive soap coating.	
F4550A	zinc calcium phosphates accelerated with nitrate/nitrite	Product suitable for high speed drawing for high carbon steel wires.	Acid pickling.
F4551P			

## NON REACTIVE PRE-COATINGS (PANCOVER)

4700	chloride free products, special additives have been included to enhance the adherence to the rod/wire surface	Borax free pre-coating product for stainless steel wires, bars, tubes and profiles. The coating film has a low tendency to moisture pick-up enabling long storage before final use.	1. acid pickling 2. shot blasting
4730		Medium borax content pre-coating product for stainless steel wires, bars, tubes and profiles. The coating film has a low tendency to pick up moisture enabling long storage before final use. This product can be used either for stainless steel or carbon steel, batch or in-line treatment, specially indicated for mattress spring wire.	3. molten salts descaling
4750	low borax pre-coating	Low borax pre-coating product for stainless steel wires, bars, tubes and profiles. The coating film has a low tendency to moisture pick-up enabling long storage before final use.	
4760	borax free product, special additives have been included to enhance the adherence to the rod/wire surface	Designed to avoid the presence of boron in waste water: it can be used either on rod or fine wire.	1. acid pickling 2. shot blasting
4770	very low hygroscopicity, low borax	Particularly indicated for high humidity environment.	
4780	borax free pre-coating compound, water soluble	It is used for the in-line treatment of multi-wire coating after in-line phosphate.	
S1300	special activated sodium stearates	Suitable for the preparation of finishing coating for Cold Heading wire. Application for hot dip.	Shot blasting or acid pickling and phosphate coating.
S1303		Suitable for the preparation of finishing treatment of steel tube after phosphate coating.	
POL651E	polymer based product	To be used after phosphate coating for cold heading application.	

## **PANLUBE S280**

Flux Core

Dry Drawing Lubricants

For high drawing speed

### Characteristics

Calcium lubricant

### Surface preparation

For high speed drawing.

## **PANULBE S1504**

Welding

Flux Core

Dry Drawing Lubricants

For first die after filling up

### Characteristics

borax free sodium lubricant

### Surface preparation

For the first die after filling up.

Seamless tube.

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