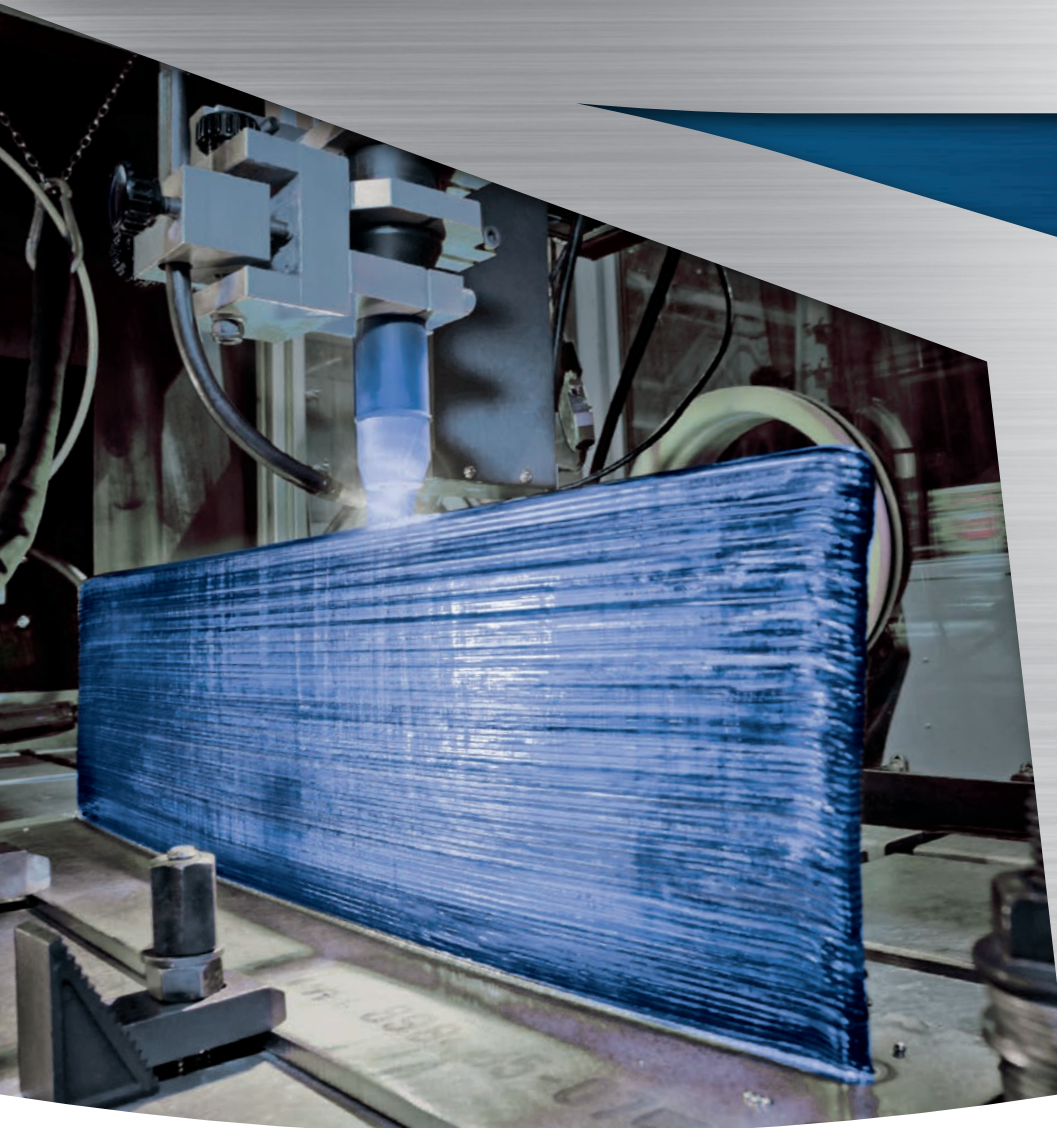


Lasting Connections

PRICING GUIDELINE 2023/24 3DPRINT SOLID WIRES

Product range dedicated to
Wire Arc Additive Manufacturing





THE FUTURE OF PRODUCTIVITY: WIRE ARC ADDITIVE MANUFACTURING (WAAM)

3D PRINTING WITH THE BEST-IN-CLASS WIRE ALLOYS

Additive manufacturing – popularly known as 3D printing – is one of the most revolutionary new manufacturing methods of our time.

Wire Arc Additive Manufacturing is a new disruptive technology that is being enthusiastically adopted at voestalpine Böhler Welding for its leading brand Böhler Welding. It not only allows almost lossless processing of high-value material but also results in high-strength components with a flexibility that would not be conceivable using conventional methods.

The specialists at Böhler Welding are continuously researching and offer specifically made products for wire arc additive manufacturing, i.e.

- » a specific chemistry developed for WAAM applications
- » a surface finishing dedicated to the grades chosen
- » a dedicated packaging adopted to the application field

Metallurgical benefits	Process benefits
Made for low cooling rates and high heat input	High process stability for Robotic MIG or other mechanised processes
Accepts multiple hardening/tempering cycles by multiple layers	Drum and spool weights can widely be adopted to the weight of parts
Optimised for post print heat treatment	Low alloyed steel
(when required)	Extended quality control to ensure consistent arc and feeding behavior

PRICE RECOMMENDATION

Productname	Article	Ø mm	Spool type	Weight kg	Short text	Recommended End User Price [€/kg]	Min.	Max.	Alloy Surcharge included	Alloy Surcharge Code
3Dprint AM 15-5 PH	40806	1,0	BS300	15	2B3DPRINTAM155PH 1,0-BS300-GREY-15	32,2	29,0	35,4	YES	D26
	38943	1,2	BS300	15	2B3DPRINTAM155PH 1,2-BS300-GREY-15	31,1	28,0	34,2	YES	D26
	40816	1,2	ECOdrum	250	2B3DPRINTAM155PH 1,2-DRUM-O-250	31,3	28,2	34,4	YES	D26
	86828	1,2	MEGAdrum	300	2B3DPRINTAM155PH 1,2-DRUM-R65-300	31,5	28,4	34,7	YES	D26
3Dprint AM 17-4 PH	42136	1,0	BS300	15	2B3DPRINTAM174PH 1,0-BS300-GREY-15	32,2	29,0	35,4	YES	D30
	38946	1,2	BS300	15	2B3DPRINTAM174PH 1,2-BS300-GREY-15	31,1	28,0	34,2	YES	D30
	42137	1,2	ECOdrum	250	2B3DPRINTAM174PH 1,2-DRUM-O-250	31,3	28,2	34,4	YES	D30
	86836	1,2	MEGAdrum	300	2B3DPRINTAM174PH 1,2-DRUM-R65-300	31,7	28,5	34,9	YES	D30
3Dprint AM 2205	40827	1,0	BS300	15	2B3DPRINTAM2205 1,0-BS300-GREY-15	18,9	17,0	20,8	NO	D12
	40830	1,0	ECOdrum	250	2B3DPRINTAM2205 1,0-DRUM-O-250	19,1	17,2	21,0	NO	D12
	40837	1,2	BS300	15	2B3DPRINTAM2205 1,2-BS300-GREY-15	17,8	16,0	19,6	NO	D12
	40840	1,2	ECOdrum	250	2B3DPRINTAM2205 1,2-DRUM-O-250	18,0	16,2	19,8	NO	D12
3Dprint AM 2209	40845	1,0	BS300	15	2B3DPRINTAM2209 1,0-BS300-GREY-15	18,9	17,0	20,8	NO	D12
	38768	1,2	BS300	15	2B3DPRINTAM2209 1,2-BS300-GREY-15	17,8	16,0	19,6	NO	D12
	40849	1,2	ECOdrum	250	2B3DPRINTAM2209 1,2-DRUM-O-250	18,0	16,2	19,8	NO	D12
	54776	1,2	ECOdrum	320	2B3DPRINTAM2209 1,2-DRUM-O60-400-320kg	18,5	16,7	20,4	NO	D12
3Dprint AM 2594	72056	1,2	Basket spool BS300	15	2B3DPRINTAM2594 1,2-BS300-GREY-15	20,2	18,2	22,2	NO	D12
	72057	1,2	ECOdrum	250	2B3DPRINTAM2594 1,2-DRUM-O52-250	20,9	18,8	22,9	NO	D12
3Dprint AM 304L	38755	1,2	BS300	15	2B3DPRINTAM304L 1,2-BS300-GREY-15	6,5	5,9	7,2	NO	D01
	40817	1,2	ECOdrum	250	2B3DPRINTAM304L 1,2-DRUM-O-250	6,7	6,0	7,4	NO	D01
3Dprint AM 316L	38514	1,2	BS300	15	2B3DPRINTAM316L 1,2-BS300-GREY-15	7,6	6,8	8,4	NO	D02
	40818	1,2	ECOdrum	250	2B3DPRINTAM316L 1,2-DRUM-O-250	7,9	7,1	8,7	NO	D02
3Dprint AM 316L Cryo2	84052	1,2	BS300	15	2B3DPRINTAM316LCRYO2 1,2-BS300-GREY-15	8,6	7,7	9,5	NO	D02
	84043	1,2	BASEdrum	250	2B3DPRINTAM316LCRYO2 1,2-DRUM-R52-250	9,1	8,2	10,0	NO	D02
3Dprint AM 316Lsi	84523	1,2	BS300	15	2B3DPRINTAM316LSi 1,2-BS300-GREY-15	7,8	7,0	8,6	NO	D02
	84519	1,2	MEGAdrum	300	2B3DPRINTAM316LSi 1,2-DRUM-R65-300	8,2	7,3	9,0	NO	D02

Productname	Article	Ø mm	Spool type	Weight kg	Short text	Recommended End User Price [€/kg]	Min.	Max.	Alloy Surcharge included	Alloy Surcharge Code
3Dprint AM 410 NiMo Mod	56468	1,0	BS300	15	2B3DPRINTAM410NiMo-mod 1,0-BS300-GREY-15	19,3	17,4	21,2	NO	D26
	42138	1,2	BS300	15	2B3DPRINTAM410NiMo-mod 1,2-BS300-GREY-15	17,2	15,5	18,9	NO	D26
	42139	1,2	ECOdrum	250	2B3DPRINTAM410NiMo-mod 1,2-DRUM-O52-250	17,4	15,7	19,1	NO	D26
	86838	1,2	MEGAdrum	300	2B3DPRINTAM410NiMo-mod 1,2-DRUM-R65-300	17,8	16,0	19,6	NO	D26
3Dprint AM 430	42135	1,2	BS300	15	2B3DPRINTAM430 1,2-BS300-GREY-15	17,2	15,5	18,9	NO	D15
	42134	1,2	ECOdrum	250	2B3DPRINTAM430 1,2-DRUM-O-250	17,4	15,7	19,1	NO	D15
3Dprint AM Tool 40	64622	1,0	BS300	15	2B3DPRINTAMTOOL40 1,0-BS300-GREY-15	21,3	19,2	23,4	NO	D23
	64623	1,2	BS300	15	2B3DPRINTAMTOOL40 1,2-BS300-GREY-15	21,0	18,9	23,1	NO	D23
	87448	1,2	BASEdrum	250	2B3DPRINTAMTOOL40 1,2-DRUM-R52-250	21,6	19,4	23,8	NO	D23
3Dprint AM Tool 45	65350	1,0	BS300	15	2B3DPRINTAMTOOL45 1,0-BS300-GREY-15-3G	51,2	46,1	56,3	NO	D23
	65359	1,2	BS300	15	2B3DPRINTAMTOOL45 1,2-BS300-GREY-15-3G	50,8	45,7	55,9	NO	D23
	68184	1,2	BASEdrum	250	2B3DPRINTAMTOOL45 1,2-DRUM-R52-250-3G	60,5	54,4	66,5	NO	D23
3Dprint AM Tool 45	65375	1,0	BS300	15	2B3DPRINTAMTOOL55 1,0-BS300-GREY-15-3G	32,1	28,9	35,3	NO	D23
	65384	1,2	BS300	15	2B3DPRINTAMTOOL55 1,2-BS300-GREY-15-3G	31,9	28,7	35,1	NO	D23
	68192	1,2	BASEdrum	250	2B3DPRINTAMTOOL55 1,2-DRUM-R52-250-3G	32,4	29,2	35,6	NO	D23
3Dprint AM 625	42140	1,2	BS300	15	2B3DPRINTAM625 1,2-BS300-GREY-15	21,2	19,1	23,3	NO	D14
	42141	2,2	ECOdrum	250	2B3DPRINTAM625 1,2-DRUM-O-250	22,3	20,1	24,5	NO	D14
3Dprint AM 718	42436	1,0	BS300	15	2B3DPRINTAM718 1,0-BS300-GREY-15	37,9	34,1	41,7	NO	D14
	42133	1,2	BS300	15	2B3DPRINTAM718 1,2-BS300-GREY-15	36,8	33,1	40,5	NO	D14
	42132	1,2	ECOdrum	250	2B3DPRINTAM718 1,2-DRUM-O-250	37,9	34,1	41,7	NO	D14
	62212	1,6	BS300	15	2B3DPRINTAM718 1,6-BS300-GREY-15	36,8	33,1	40,5	NO	D14
3Dprint AM Mold36	74216	1,2	BS300	15	2B3DPRINTAMMOLD36 1,2-BS300-GREY-15	18,1	16,3	19,9	NO	D19
	86268	1,2	MEGADrum	300	2B3DPRINTAMMOLD36 1,2DRUM-R65-300	17,8	16,0	19,6	NO	D19
3Dprint AM P22	40798	1,0	BS300	18	2B3DPRINTAMP22 1,0-BS300-GREY-18	11,6	10,4	12,8	NO	D52
	40799	1,2	BS300	18	2B3DPRINTAMP22 1,2-BS300-GREY-18	11,1	10,0	12,2	NO	D52
	40800	1,2	ECOdrum	250	2B3DPRINTAMP22 1,2-DRUM-O-250	11,3	10,2	12,4	NO	D52

PRICE RECOMMENDATION

Productname	Article	Ø mm	Spool type	Weight kg	Short text	Recommended End User Price [€/kg]	Min.	Max.	Alloy Surcharge included	Alloy Surcharge Code
3Dprint AM 35	40785	1,0	BS300	18	3B3DPRINTAM35 1,0-BS300-GREY-18	4,1	3,7	4,5	YES	
	38901	1,2	BS300	18	2B3DPRINTAM35 1,2-BS300-GREY-18	3,9	3,5	4,3	YES	
	40786	1,2	ECOdrum	250	2B3DPRINTAM35 1,2-DRUM-O-250	4,1	3,7	4,5	YES	
3Dprint AM 46	40302	1,2	BS300	18	2B3DPRINTAM46 1,2-BS300-GREY-18	3,9	3,5	4,3	YES	
	40805	1,2	ECOdrum	250	2B3DPRINTAM46 1,2-DRUM-O-250	4,1	3,7	4,5	YES	
3Dprint AM 50	40791	1,0	BS300	18	2B3DPRINTAM50 1,0-BS300-GREY-18	4,9	4,4	5,4	NO	D54
	38904	1,2	BS300	18	2B3DPRINTAM50 1,2-BS300-GREY-18	4,8	4,3	5,3	NO	D54
	40793	1,2	ECOdrum	250	2B3DPRINTAM50 1,2-DRUM-O-250	4,9	4,4	5,4	NO	D54
3Dprint AM 62	38908	1,2	BS300	18	2B3DPRINTAM62 1,2-BS300-GREY-18	5,6	5,0	6,2	NO	D61
	40794	1,2	ECOdrum	250	2B3DPRINTAM62 1,2-DRUM-O-250	5,8	5,2	6,4	NO	D61
3Dprint AM 70	38934	1,2	BS300	18	2B3DPRINTAM70 1,2-BS300-GREY-18	6,4	5,8	7,0	NO	D56
	40796	1,2	ECOdrum	250	2B3DPRINTAM70 1,2-DRUM-O-250	6,7	6,0	7,4	NO	D56
3Dprint AM 80HD	71776	1,0	BS300	18	2B3DPRINTAM80HD 1,0-BS300-GREY-18	8,3	7,5	9,1	NO	D56
	71775	1,0	ECOdrum	250	2B3DPRINTAM80HD 1,0-DRUM-O52-250	8,7	7,8	9,5	NO	D56
	42487	1,2	BS300	18	2B3DPRINTAM80HD 1,2-BS300-GREY-18	8,1	7,3	8,9	NO	D56
	42486	1,2	ECOdrum	250	2B3DPRINTAM80HD 1,2-DRUM-O52-250	8,4	7,6	9,2	NO	D56
3DPRINT AM AI 2219	87748	1,2	MEGADrum	100	2B3DPRINTAMAI2219 1,2-DRUM-R65-100-3G	42,9	38,6	47,1	YES	AI Surch
3DPRINT AM AI 2219	38635	1,2	S300	7	2B3DPRINTAMAL2219 1,2-S300-7-3G	42,1	37,9	46,3	YES	AI Surch
3Dprint AM Cu6327	87814	1,2	BASEdrum	200	2B3DPRINTAMCU6327 1,2-DRUM-R-200-3G	27,0	24,3	29,7	NO	Cu Surch
	71966	1,2	S300	15	2B3DPRINTAMCU6327 1,2-S300-15-3G	27,0	24,3	29,7	NO	Cu Surch
3Dprint AM Cu6328	42496	1,2	BASEdrum	200	2B3DPRINTAMCU6328 1,2-DRUM-R-200-3G	27,0	24,3	29,7	NO	Cu Surch
	42478	1,2	S300	15	2B3DPRINTAMCU6328 1,2-S300-15-3G	27,0	24,3	29,7	NO	Cu Surch
3Dprint AM Ti-2	74996	1,2	S300	3	2B3DPRINTAMTI2 1,2-S300-3-3G	140,0	126,0	154,0	YES	
3Dprint AM Ti-5	52654	1,0	S200	3	2B3DPRINTAMTI5 1,0-S200-3-3G	142,0	127,8	156,2	YES	
	42368	1,0	S300	10	2B3DPRINTTI5 1,0-S300-10-3G	142,0	127,8	156,2	YES	
	52659	1,2	S200	3	2B3DPRINTAMTI5 1,2-S200-3-3G	142,0	127,8	156,2	YES	
	38618	1,2	S300	10	2B3DPRINTTI5 1,0 S300-10-3G	135,7	122,1	149,3	YES	
	85494	1,2	S760S	80	2B3DPRINTAMTI5 1,2-S700-80-3G	130,2	117,2	143,2	YES	
	43883	1,6	S300	10	2B3DPRINTTI5 1,6-S300-10-3G	128,6	115,7	141,5	YES	

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We are a leader in the welding industry with over 100 years of experience, more than 50 subsidiaries and more than 4,000 distribution partners around the world. Our extensive product portfolio and welding expertise combined with our global presence guarantees we are close when you need us. Having a profound understanding of your needs enables us to solve your demanding challenges with Full Welding Solutions - perfectly synchronized and as unique as your company.



Lasting Connections – Perfect alignment of welding machines, consumables and technologies combined with our renowned application and process know-how provide the best solution for your requirements: A true and proven connection between people, products and technologies. The result is what we promise: Full Welding Solutions for Lasting Connections.



Tailor-Made Protectivity™ – Proven under the toughest conditions: Our products protect metal surfaces from wear and corrosion. With over 70 years of experience and the broadest product portfolio in the industry, we are your preferred partner for Surface Protection solutions. We deliver what we promise: Surface Protection tailored to your needs.



In-Depth Know-How – As a manufacturer of soldering and brazing consumables, we offer proven solutions based on 60 years of industrial experience, tested processes and methods, made in Germany. This in-depth know-how makes us the internationally preferred partner to solve your soldering and brazing challenge through innovative solutions. The result is what we promise: Innovation based on in-depth know-how.

The Management System of voestalpine Böhler Welding Group GmbH, Peter-Mueller-Strasse 14-14a, 40469 Duesseldorf, Germany has been approved by Lloyd's Register Quality Assurance to: ISO 9001:2015, ISO 14001:2015, OHSAS 18001:2007, applicable to: Development, Manufacturing and Supply of Welding and Brazing Consumables. More information: www.voestalpine.com/welding



