Packaging and spool types
Stick electrodes
Rutile and low-hydrogen electrodes are packed in cardboard packs with polyethylene shrink wrapping. They are supplied in units of three or six in outer boxes made of corrugated board (Figures 1 & 2). Stainless electrodes are packed in polyethylene boxes with a re-sealable lid (Figure 3).

Tig rods
Tig rods are packed in strong, air-tight fibre cylinders with a re-sealable plastic lid (Figure 4).

Strip electrodes
OK Band welding strip is normally supplied in 30 kg coils and a frequent dimension is 60 x 0.5 mm. However, other widths such as 30 or 90 mm or larger coil weights are available on request.

VacPac™
No re-baking - no quivers - no holding ovens
VacPac vacuum packaging eliminates the costly re-baking and handling routines normally associated with the storage of electrodes, by preventing airborne moisture absorption. VacPac is simple and convenient to use, ensuring that the electrodes keep their "factory fresh", low-moisture condition until the sealed vacuum is released and the electrodes are used. When stored under conditions in which the sealed VacPac electrodes are not damaged, their shelf life is virtually unlimited.

Quality control is simple. The date and time of issue from the warehouse are written on the foil to monitor safe usage within the time limits prescribed for the various electrode types after opening the VacPac. The foil, showing all the necessary product information, is left in place after opening.

The VacPac sizing options make it possible to match the number of electrodes to the expected production rate and are the electrodes are available as full, half and quarter packs, containing approximately 4, 2.5 and 1 kg of electrodes.
Packaging

Flux

ESAB fluxes are normally supplied in paper bags of 20 or 25 kg each. An inner bag of polythene provides extra protection from moisture pick-up from the surrounding atmosphere. ESAB fluxes for submerged arc welding can also be supplied in steel buckets of 25 kg. This packaging type is very strong and is used for demanding handling conditions. The re-sealable metal lid has a rubber seal to prevent the flux from absorbing moisture.

Big Barrel is a bulk packaging alternative for SAW fluxes. The steel barrel contains about 250 kg, depending on the volume weight of the flux. This large packaging for flux offers more rational handling. The Big Barrel is environmentally compatible and reduces waste.

Big Bag is intended for bulk usage. Fluxes, including OK Flux 10.71, are now available in 500-1,000 kg content. Big Bag offers six-fold security in terms of weight and has base dimensions of 85 x 85 cm. The height of a one-tonne Big Bag is 88 cm, enabling two bags to be stacked in a truck or container for transport.

Big Bag is made of layers of fabric, coated on the inside for moisture protection. There is a discharge spout with a diameter of 150 mm. It can easily be re-closed with a rope so that only part of the flux is taken out at any time. Big Bag has four strong straps allowing it to be lifted by a fork-lift truck or overhead crane and emptied directly into a flux container.
MARATHON PAC™ — endless feedability

For many customers, Marathon Pac bulk drums for MIG/MAG and FCAW are key in maximising production efficiency and quality; in manual welding and especially in mechanised and robotic welding. Marathon Pac can cut the time taken by spool changes and maintenance by almost 95%. Marathon Pac comes in three sizes – the standard version, the jumbo version and the mini version – and is available for non-alloyed and low-alloyed MAG wires, stainless MIG wires, aluminium MIG wires, MAG-brazing wires and cored wires. In addition, there is an "endless version", which makes it possible to combine the content of a series of Marathon Pacs to form a continuous in-line supply source, thereby necessitating no stops whatsoever for wire exchange. This is ideal for multi-robot stations. A special wire resistance welder is available from ESAB for this purpose. Availability and content weight are given in the table below.

<table>
<thead>
<tr>
<th>Marathon Pac version</th>
<th>Wire types</th>
<th>Filling content</th>
</tr>
</thead>
<tbody>
<tr>
<td>Standard version</td>
<td>Non-flow-alloyed</td>
<td>250 kg (ø 0.8 mm: 200 kg)</td>
</tr>
<tr>
<td>(w x h: 513 x 830 mm)</td>
<td>Stainless</td>
<td>250 kg (ø 0.8 mm: 200 kg)</td>
</tr>
<tr>
<td></td>
<td>MAG-brazing</td>
<td>200 kg</td>
</tr>
<tr>
<td></td>
<td>Cored wires</td>
<td>depending on wire type</td>
</tr>
<tr>
<td>Jumbo version</td>
<td>Non-flow-alloyed</td>
<td>475 kg (min. ø 1.0 mm)</td>
</tr>
<tr>
<td>(w x h: 595 x 935 mm)</td>
<td>Stainless</td>
<td>475 kg (min. ø 1.0 mm)</td>
</tr>
<tr>
<td></td>
<td>Aluminium</td>
<td>141 kg</td>
</tr>
<tr>
<td></td>
<td>Cored wires</td>
<td>depending on wire type</td>
</tr>
<tr>
<td>Mini version</td>
<td>Stainless</td>
<td>100 kg</td>
</tr>
<tr>
<td>(w x h: 513 x 500 mm)</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Endless version</td>
<td>Non-flow-alloyed wires</td>
<td>2 x 250 kg</td>
</tr>
<tr>
<td>(2 x standard or jumbo version)</td>
<td></td>
<td>2 x 475 kg</td>
</tr>
<tr>
<td></td>
<td>Stainless</td>
<td>2 x 250 kg</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2 x 475 kg</td>
</tr>
</tbody>
</table>
Packaging

Perfect delivery to the welding head
The special coiling technique that is used when packing the drum ensures that the wire is never twisted or warped, which would otherwise cause arc wander. Welds are well positioned and perfectly straight. The unwinding process from the drum is automatic, so no separate de-coiling equipment is needed and no additional forces are required, like those that are needed when pulling a traditional revolving spool. This translates into a lower wear rate for the wire feeder.

Easy recycling
Marathon Pac comes in octagonal cardboard drums that are fully recyclable. They can be folded flat after use to save on storage space.

Marathon Pac (left) and Jumbo Marathon Pac.

Mini Marathon Pac

Endless Marathon Pac
### Spool 03

- **03-0**: 25 kg
- **03-2**: 30 kg
- **03-3**: 15 kg

Random-wound wire basket. Can be fitted to ESAB’s 0416 492 880 or 0153 872 880 coil holder. This spool is also suitable for coil holders with crossed arms. The empty basket is non-returnable.

### Spool 04

- **04-0**: 280 kg

Random-wound pay-off drum. The empty spool is non-returnable.

### Spool 08

- **08-0**: 30 kg

Random-wound spool without cardboard former. Can be fitted to ESAB’s 0416 492 880 or 0153 872 880 coil holders. This spool is not suitable for coil holders with crossed arms.
Spool types

**Spool 24**
Plastic spool. Layer wound.
EN 759: S 300
24-7 15 kg

**Spool 25**
Plastic spool. Random wound.
EN 759: S 300
25-0 15 kg
25-2 10 kg

**Spool 28/31**
**Eurospool**
28-0 30 kg
28-1 25 kg
28-2 15 kg
Precision-wound octagonal wire basket. Can be fitted to ESAB's 0416 492 880 or 0153 872 880 coil holder. This spool is also suitable for coil holders with crossed arms. The empty basket is non-returnable.

**Spool 34**
34-0 300 kg
Random-wound wooden bobbin. Decoiling stand required. The empty bobbin is non-returnable.
### Spool types

#### Spool 46
- Plastic spool. Random wound
- EN 759: S 200
- 46-0: 5 kg
- 46-2: 2 kg

#### Spool 48
- Random-wound coil sheet metal former. Can be fitted to ESAB’s 0671 155 480 coil holder. Decoiling stand required.
- 48-0: 100 kg
- 48-1: 75 kg

#### Spool 66/68
- Wire basket. Random wound.
- EN 759: BS 300
- 66-copper-coated, 68-bare
- 66-0: 15 kg
- 66-1: 18 kg
- 66-2: 10 kg
- 66-3: 16 kg

#### Spool 67/69
- Wire basket. Layer wound.
- EN 759: BS 300
- 67-copper-coated, 69-bare
- 67-0: 15 kg
- 67-1: 18 kg
- 67-3: 16 kg
Spool types

Spool 76
Wire basket. Random wound.
EN 759: B 300

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
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</tr>
</thead>
<tbody>
<tr>
<td>76-0</td>
<td>15 kg</td>
<td></td>
</tr>
<tr>
<td>76-1</td>
<td>18 kg</td>
<td></td>
</tr>
<tr>
<td>76-3</td>
<td>16 kg</td>
<td></td>
</tr>
</tbody>
</table>

Spool 77
Wire basket. Layer wound.
EN 759: B 300

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
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<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>77-0</td>
<td>15 kg</td>
<td></td>
</tr>
<tr>
<td>77-1</td>
<td>18 kg</td>
<td></td>
</tr>
<tr>
<td>77-3</td>
<td>16 kg</td>
<td></td>
</tr>
</tbody>
</table>

Spool 93
MARATHON PAC™
93-0-200 kg, 93-2-250 kg
93-X-catch weight

Accessories:
1. Wire conduit attachment
2. Wire conduits
3. Connector wire feed unit
4. Lifting yoke
5. Trolley

Spool 94
MARATHON PAC™
94-0 475 kg

Accessories:
1. Plastic hood
2. Quick connector
3. Wire conduits
4. Connector wire feed unit
5. Lifting yoke
6. Trolley
Spool types

**Spool 95**
MARATHON PAC™
95-0 100 kg

Accessories:
1. Quick connector
2. Wire conduits
3. Connector wire feed unit
4. Lifting yoke
5. Trolley

**Spool 98**
EN 759: BS 300
Layer-wound wire basket, plastic coated, which is used without adapter. Fitting to hub with diam. = 51 mm. Empty spool is recyclable.

98-2 15 kg
98-3 18 kg
98-4 16 kg
98-6 6 kg
98-7 7 kg