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增强型 490Mpa 级低碳钢药芯焊丝
Reinforced Type Mild Steel 490Mpa Flux cored wire

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执行标准 CLASSIFICATION

符合 GB/T 10045 T492T1-1C1 A 相当 AWS A5.20 E71T-1C ISO 17632-A-T 42 2 P C/M 1

产品特性 DESCRIPTION

适用于全位置焊接，有良好的冲击性能。焊接性能优良，电弧柔和稳定，飞溅少、烟尘低、焊道平滑美观，脱渣容易。

It is suitable for all-position welding and has good impact performance. Excellent welding performance, soft and stable arc, less spatter, low smoke and dust, smooth and beautiful welding bead, easy to remove slag.

应用 APPLICATIONS

用于造船、钢结构、建筑、桥梁、机械设备、车辆制造、海洋平台、管道、锅炉及压力容器等焊接需求。

Widely adopted in various fields, such as shipbuilding, steel structure, construction, bridges, machinery equipment, automobile manufacturing, Marine platform, pipe, boiler and pressure vessel, etc

电源类型 CURRENT TYPE

焊枪接正电极 DC+

过程保护 PROCESS

二氧化碳气保焊 Co2 gas-shielded welding

焊接位置 WELDING POSITIONS

平焊、角焊、仰焊、立向上焊、立向下焊 Flat, fillet, tilt, vertical up, vertical down

熔敷金属化学成分 CHEMICAL COMPOSITION OF WELDED METAL %

试验项目 Item	C	Si	Mn	P	S
GB/T Standard	≤0.18	≤0.9	≤2.00	≤0.030	≤0.030
例值 Typical values	0.055	0.40	1.35	0.018	0.011

熔敷金属力学性能 MECHANICAL PROPERTIES OF WELDED METAL

试验项目 Item	Rel/Rp0.2 屈服强度 (MPa)	Rm 抗拉强度 (MPa)	A 伸长率 (%)	试验温度 (°C)	KV2(J)
GB/T Standard	≥390	490-670	≥18	-20	≥27
例值 Typical values	440	535	32		110

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.6
电流 Current [A]	平焊 Flat	100-200	120-300	180-450
	上立焊/仰焊 V-Up&Overhead	100-200	120-260	180-280
	下立焊 Vertical Downward	150-250	200-280	250-300

包装 PACKAGING

5kg 15kg 盘装 Coil 也可以定制其他包装和规格 Other packaging and other diameters: please consult us