

SWE711M



混合气体用增强型 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 T49 2T1-1M21 A 相当 AWS A5.20 E71T1-1M ISO 17632-A-T 42 2 P M1

产品特性 DESCRIPTION

混合气体保护用钛型药芯焊丝, 适用于全位置焊接, 氩气的加入降低了电弧氧化性, 减少合金元素损失, 同时改善电弧稳定性和熔滴过渡形态。同时飞溅相较于二氧化碳保护的产品降低 2%, 几乎没有飞溅。富氩环境下焊接时, Mn、Si 烧损更少, 可保留更高含量的合金元素, 从而提升焊缝的强度和韧性, 特别适合对焊缝质量要求高的结构件焊接。

Titanium-type flux-cored welding wire for mixed gas shielding is suitable for all-position welding. It features less spatter during welding, more stable strength and lower hydrogen content, along with a soft and stable arc. Additionally, it produces low fume, creates smooth and aesthetic weld beads, and allows for easy slag removal.

应用 APPLICATIONS

适用于核电工程、造船、钢结构、建筑、桥梁、机械设备、车辆制造、海洋平台、管道、锅炉及压力容器等对焊接要求较高的领域。
It is widely used for welding needs of shipbuilding, steel structure, construction, bridges, machinery and equipment, vehicle manufacturing, offshore platforms, pipelines, boilers and pressure vessels.

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	1.3	0.018	0.009

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	450	540	30		120

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.4	φ1.6
电流 Current [A]	平焊 Flat	100-220	150-280	150-300	180-350
	上立焊/仰焊 V-Up&Overhead	100-210	140-270	140-270	170-330
	下立焊 Vertical Downward	150-250	200-280	250-300	150-250

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