

# E71T8-NiJ



高韧性抗冲击型自保护药芯焊丝  
Gasless Flux cored welding wire for Low temperature Steel

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## 执行标准 CLASSIFICATION

符合 GB/T 10045-2018 T494T8-1NA-N2 相当 AWS A5.29 E7118-Ni1-J ISO 17632A T 42 3 1Ni Y NO 1

## 产品特性 DESCRIPTION

SWE71T8-Ni 是一种低合金自保护药芯焊丝, 不需要保护气体。熔敷金属中含 0.8%-1.10%Ni, 具有优良的低温韧性, 抗裂性能好。其熔敷效率高, 电弧穿透力大, 呈喷射状, 操作容易, 焊缝成形美观, 脱渣容易。采用直流正接, 适宜全位置焊接。由于熔渣凝固快, 特备适合立向下焊。可用于焊接厚板及刚性大的重要结构。

SWE71T8-Ni is a low-alloy self-shielded flux-cored welding wire, which does not require shielding gas. The deposited metal contains 0.8%-1.10% Ni, which has excellent low temperature toughness and good crack resistance. Its deposition efficiency is high, the arc penetrating power is large and has spray-like shape. It is easy to operate, the weld seam is beautifully formed, and the slag removal is easy. Adopt DC negative connection, suitable for all-position welding. Because the slag solidifies fast, it is specially suitable for vertical downward welding. It can be used for welding thick plates and important structures with high rigidity.

## 应用 APPLICATIONS

用于焊接要求韧性和需要加镍的焊缝, 特别适合于对低温韧性要求高的 API X52 至 X70 油气管道的现场焊接。也可用于普通钢、耐大气腐蚀钢及高强度的自动和半自动焊接, 如输油输气管、海洋平台、贮罐等。

It is used for welding welds that require high toughness and nickel, and is especially suitable for on-site welding of API X52 to X70 oil and gas pipelines that require great low-temperature toughness. It can also be used for ordinary steel, atmospheric corrosion-resistant steel and high-strength automatic and semi-automatic welding, such as oil and gas pipelines, offshore platforms, storage tanks, etc.

## 电源类型 CURRENT TYPE

焊枪接负电极 DC-

## 过程保护 PROCESS

无需气体保护 Self-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 %

| 项目                | C     | Si    | Mn    | Ni        | Mo    | AL    |
|-------------------|-------|-------|-------|-----------|-------|-------|
| GB/T Standard     | ≤0.12 | ≤0.80 | ≤1.75 | 0.80-1.20 | ≤0.35 | ≤1.80 |
| 例值 Typical values | 0.038 | 0.20  | 1.15  | 0.99      | 0.02  | 0.92  |

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

| 试验项目              | 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       | -40°C     | ≥27    |
| 例值 Typical values | 420                  | 521           | 27        |           | 134    |

## 作业条件 OPERATING CONDITIONS

| 直径 Diameter [mm] |                       | Φ1.6    | Φ2.0    |
|------------------|-----------------------|---------|---------|
| 电流 Current [A]   | 平焊 Flat               | 120-170 | 150-230 |
|                  | 上立焊/仰焊 V-Up&Overhead  | 100-150 | 140-180 |
|                  | 下立焊 Vertical Downward | 130-170 | 160-250 |

## 包装 PACKAGING

15kg 25kg 盘装 Coil 也可以定制其他包装和规格 Other packaging and other diameters: please consult us