

E 7 1 T 8 - K 6



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

江苏省溧阳市南渡镇金山路 2 号
Tel: 05198089768 Fax: 051980897358
SEWELD@163.COM
WWW.SEWELD.COM

执行标准 CLASSIFICATION

符合 GB/T 10045 T493T8-1NA-N1 AWS A5.29 E71T8-K6 ISO 17632A T 42 4 1Ni Y NO 1

产品特性 DESCRIPTION

SWE71T8-K6 是一种低合金钢自保护药芯焊丝，不需保护气体。焊缝低温韧性优良，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，特别适合立向下焊。

SWE71T8-K6 is a low-alloy steel self-shielded flux-cored welding wire, using without external shielding gas. The weld has excellent toughness in low temperature, high deposition efficiency, large arc penetration and has spray-like shape, easy to operate, beautiful weld formation, and easy slag removal. Adopts to DC negative connection, suitable for all-position welding. Because the slag solidifies quickly, it is especially suitable for vertical downward welding.

应用 APPLICATIONS

SWE71T8-K6 特别适用于对低温韧性要求高的 API X52 至 X65 油管道的现场焊接。用于普通钢及高强度钢的现场焊接，如高层建筑、高炉等。

SWE71T8-K6 is especially suitable for welding of API X52 to X65 oil pipelines with high requirements for toughness in low temperature. Used for on-site welding of ordinary steel and high-strength steel, such as high-rise buildings, blast furnaces, 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	AL	Ni	Mo
GB/T Standard	≤0.12	≤0.80	≤1.75	≤1.80	0.3-1.0	≤0.35
例值 Typical values	0.046	0.26	1.27	0.85	0.35	0.012

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	-30°C	≥27
例值 Typical values	435	535	26		132

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		Φ1.6	Φ2.0
平焊 Flat		120-170	150-230
电流 Current [A]	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