

E308LT0-3



不锈钢自保护药芯焊丝
Self-shielded Flux-Cored Wire For Stainless Steel

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执行标准 CLASSIFICATION

符合 GB/T 17853 TS308L-FN 0 相当 AWS A5.22/A5.22M E308LT0-3 ISO 17633B TS 308LFU0

产品特性 DESCRIPTION

东南焊材®不锈钢自保护药芯焊丝, 结合气保药性焊丝的飞溅低、成型美观、易脱渣、成分均匀等优点, 并调整焊丝渣系使其不用外加保护气体, 可以像手工焊条一样进行焊接, 大大增加了焊接操作的便利与灵活。本产品可使用普通 350、500 等型号的焊接设备, 关闭气体保护即可进行焊接, 也可采用 250、200 足额输出功率的自保护专用焊机, 产品适用于户外、高空等作业环境。

Self-shielded flux-cored welding wire for stainless steel, combined with the advantages of low spatter, beautiful shape, easy slag removal and uniform composition of gas-retaining welding wire, and adjusts the slag system of the welding wire so that it can be like a manual electrode without external shielding gas welding in the same way, which greatly increases the convenience and flexibility of the welding operation. This product is suitable for 350 and 500 general welding equipment and other small welding machines can be used. No external gas shield required. It is also suitable for self-protected special welding machines with full output power of 250 and 200. The product is suitable for outdoor, high-altitude, and other operating environments. Use instead of welding rod.

应用 APPLICATIONS

适用于户外不锈钢焊接作业或进行展架、不锈钢结构件、户外作业、高空焊接作业等焊接环境。

Suitable for outdoor stainless steel welding operations, such as exhibition stands, stainless steel structural parts.

电源类型 CURRENT TYPE

焊枪接正电极 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	Cr	Ni	Cu	Mo	Al
GB/T Standard	≤0.04	≤1.0	0.5-2.5	19.5-22.0	9.0-11.0	≤0.75	≤0.75	-
例值 Typical values	0.035	0.48	1.05	19.85	9.53	0.04	0.03	0.54

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	-	≥520	≥25	-	-
例值 Typical values	-	569	34	-	-

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ0.8&0.9	φ1.0	φ1.2
电流 Current [A]	平焊 Flat	100-180	120-220	150-230
	上立焊/仰焊 V-Up&Overhead	100-160	120-200	150-220
	下立焊 Vertical Downward	110-190	130-230	160-230

包装 PACKAGING

1kg 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