

SWE91Ni2



高 强 钢 用 药 芯 焊 丝
Flux cored wire For High strength Steel

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执行标准 CLASSIFICATION

符合 GB/T17493 T62 4 T1-1 C1 A N5 相当 AWS A5.29 E91T1 Ni2 C ISO 17632-A-T55 4 2Ni P C11

产品特性 DESCRIPTION

SWE91Ni2 专为 9% Cr 系列马氏体耐热钢 (如 P91、T91 钢) 焊接设计的焊丝。

SWE91Ni2 is a welding wire specifically designed for welding 9% Cr series martensitic heat-resistant steels (such as P91 and T91 steels).

应用 APPLICATIONS

应用于高温、高压工况下的电站锅炉、管道等关键设备的制造与维修。

It is applied in the manufacturing and maintenance of key equipment like power station boilers and pipelines under high-temperature and high-pressure working conditions.

电 源 类 型 CURRENT TYPE

焊枪接正电极 DC+

过程保护 PROCESS

100%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 %

项目	C	Si	Mn	Ni	P	S
GB/T Standard	≤0.12	≤0.80	≤1.75	1.75-2.75	≤0.03	≤0.03
例值 Typical values	0.038	0.41	1.12	1.89	-	-

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	≥530	620-820	≥17	-40°C	≥27
例值 Typical values	565	634	25		72

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