

SWE81-K2



低温钢用药芯焊丝

Flux cored wire For Low-temperature&High Tensile Steel

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执行标准 CLASSIFICATION

符合 GB/T 10045 T554T1-1C1A-N3 AWS A5.29 E81T1-K2C ISO 17632-B-T554T1-1CA-N3

产品特性 DESCRIPTION

SWE81K2 主要提供较高的抗拉强度和良好的抗裂性，侧重于常温或稍低温环境下，满足高强度结构的力学性能要求，如船舶、大型机械设备等，且具备一定的低温冲击韧性。

SWE81K2 mainly provides high tensile strength and good crack resistance. It focuses on meeting the mechanical property requirements of high-strength structures in normal or slightly low-temperature environments, such as ships and large mechanical equipment, and also has a certain degree of low-temperature impact toughness.

应用 APPLICATIONS

适用于 Q550 及 ASTM A514 等等强度等级的钢材。

It is suitable for steels of equivalent strength grades such as Q550 and ASTM A514.

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 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	P	S	Ni	Mo
GB/T Standard	≤0.12	≤0.80	≤1.75	≤0.030	≤0.030	1.00-2.00	≤0.35
例值 Typical values	0.05	0.35	1.35	0.017	0.008	1.45	-

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	≥460	550-740	≥17	-	≥27
例值 Typical values	495	580	28	-30°C	120

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	φ1.2			φ1.4		φ1.6	
	平焊 Flat			120-300		150-400	
电流 Current [A]	上立焊/仰焊 V-Up&Overhead			120-260		150-300	
	下立焊 Vertical Downward			-		-	

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