

SWE91K2

SE 东南焊材®
SOUTHEAST
WELDING MATERIAL

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高强钢用药芯焊丝
Flux cored wire For High strength Steel

执行标准 CLASSIFICATION

符合 GB/T36233 T62 4 T1 1 C1 A N3M1 相当 AWS A5.29 E91T1 K2C ISO 18276A T55 4 Mn1.5Ni P C1 1

产品特性 DESCRIPTION

SWE91K2 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。

SWE91K2 mainly provides high tensile strength and good crack resistance. It focuses on meeting the mechanical property requirements of high-strength structures in normal temperature 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 620MPa 级高强钢结构的焊接，多用于船舶、机械制造、容器、石油化工、桥梁等钢结构的焊接。

It is suitable for welding 620MPa-grade high-strength steel structures, and is mostly used for welding steel structures in shipbuilding, machinery manufacturing, pressure vessels, petrochemical industry, bridges and other fields.

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	P	S	V	Ni	Cr	Mo	Al
GB/T Standard	≤0.15	≤0.80	0.50-1.75	≤0.03	≤0.03	≤0.05	1.0-2.0	≤0.15	≤0.35	-
例值 Typical values	0.05	0.40	1.45	0.010	0.006	0.01	1.55	0.02	0.13	-

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	≥15	-40°C	≥27
例值 Typical values	560	650	23		102

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	φ1.0			φ1.2		φ1.6	
	平焊 Flat			120-300		180-450	
电流 Current [A]	上立焊/仰焊 V-Up&Overhead			100-200		120-260	
	下立焊 Vertical Downward			150-250		200-280	

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

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