

SWE81B2



热 强 钢 用 药 芯 焊 丝
490Mpa Flux cored wire for heat-resistant steel

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执行标准 CLASSIFICATION

符合 GB/T 17493 E551T1-B2C AWS A5.29 E81T-1-B2C ISO 17634A T CrMo1 P C1 1

产品特性 DESCRIPTION

SWE81B2 产品为金红石型药芯焊丝，焊接过程为喷射过渡，具有焊接飞溅小，焊道平滑，熔覆效率高等特点。Mo 的原子间结合力极强，所以在高温下仍有较好的强度，可以有效减少高温环境下的热变形并增加了焊道的耐腐蚀性。

The SWE81B2 product is a rutile-type flux-cored wire. It features spray transfer during welding, with characteristics such as low welding spatter, smooth weld beads, and high deposition efficiency. Molybdenum (Mo) has extremely strong interatomic bonding force, so it maintains good strength even at high temperatures, which can effectively reduce thermal deformation in high-temperature environments and enhance the corrosion resistance of weld beads.

应用 APPLICATIONS

适用于：15CrMoR 管件及 ASTM SA387 钢材的焊接。

It is suitable for the welding of 15CrMoR pipe fittings and ASTM SA387 steel.

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	Cr	Mo
GB/T Standard	0.05-0.12	≤0.8	≤1.25	≤0.030	≤0.030	1.00-1.50	0.40-0.65
例值 Typical values	0.058	0.25	0.80	0.014	0.010	1.15	0.45

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	≥470	550-690	≥17	常温	-
例值 Typical values	550	630	23		72

焊后热处理 Heat Treatment: (660-700) °C×60min

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.2	φ1.4	φ1.6
平焊 Flat		150-300	180-320	200-400
电流 Current [A]	上立焊/仰焊 V-Up&Overhead	120-260	150-280	180-280
	下立焊 Vertical Downward	110-180	130-200	150-230

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