

SWE307



不 锈 钢 药 芯 焊 丝
Flux cored wire For stainless steel

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执行标准 CLASSIFICATION

符合 AWS A5.22 E307-F C1 1 ISO 17633A T 18 9 Mn Mo P C1 1

产品特性 DESCRIPTION

SWE307 为 21Cr、9.5Ni、4N 和 1Mo 合金。该类别的药芯焊丝主要用于奥氏体锰钢和碳钢锻件或铸件等不同钢种之间的焊接，具有良好抗裂性。
SWE307 is an alloy containing 21%Cr, 9.5%Ni, 4%N and 1%Mo. Flux-cored wires in this category are mainly used for welding between different steel grades such as austenitic manganese steel and carbon steel forgings or castings, and have good crack resistance.

应用 APPLICATIONS

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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	Mo	Mo	Cu	Ni	Cr
GB/T Standard	≤0.13	≤1.00	3.3-4.75	0.5-1.5	≤0.75	≤0.75	9.0-10.5	18.0-20.5
例值 Typical values	0.03	0.35	3.86	0.65	0.05	0.05	9.5	18.3

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	≥390	490-670	≥18	-20	≥27
例值 Typical values	470	556	27		115

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.6
电流 Current [A]	平焊 Flat	120-200	140-220	200-300
	上立焊/仰焊 V-Up&Overhead	100-160	140-180	220-320
	下立焊 Vertical Downward	-	-	-

包装 PACKAGING

5kg 12.5kg 盘装 Coil

也可以定制其他包装和规格 Other packaging and other diameters: please consult us