

SWE308L



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

江苏省溧阳市南渡镇金山路 2 号
Tel:05198089768 Fax:051980897358
SEWELD@163.COM
WWW.SEWELD.COM

执行标准 CLASSIFICATION

符合 GB/T17853 TS308L-FC11 相当 AWS A5.22 E308L T1-1 ISO 17633A T19 9 L P C1 1

产品特性 DESCRIPTION

SWE308L 为低碳 (0.03%) 降低了碳化物在晶间析出的可能性, 从而在使用稳定剂 (如铌或钛) 的情况下提高了抗晶间腐蚀的能力。

SWE308L is a low-carbon type (with a carbon content of 0.03%), which reduces the possibility of carbide precipitation at grain boundaries. Thus, when stabilizers (such as niobium or titanium) are used, it enhances the resistance to intergranular corrosion.

应用 APPLICATIONS

用于石油化学, 压力容器、食品机械等不锈钢焊接件

It is used for stainless steel weldments in petrochemical industry, pressure vessels, food machinery and other fields.

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	Cu	Ni	Cr	Mo	Al
GB/T Standard	≤0.04	≤1.0	0.5-2.5	≤0.040	≤0.030	≤0.75	9.0-12.0	18-21	≤0.75	-
例值 Typical values	0.030	0.60	1.74	0.016	0.003	0.08	9.34	19.29	0.034	-

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	-	≥520	≥25	-	-
例值 Typical values	-	550	43.5	-	-

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 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