

SWE309L

SE 东南焊材®
SOUTHEAST
WELDING MATERIAL

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

执行标准 CLASSIFICATION

符合 GB T17853 E309LT1-1/-4 AWS A5.22 E309L T1-1 ISO 17633A T 23 12 L P C1 1

产品特性 DESCRIPTION

SWE309L 为低碳 (0.03%) 的药芯焊丝可以减少晶间碳化物沉淀的可能性, 从而在不使用稳定剂 (如铌或钛) 的情况下, 提高抗晶间腐蚀的能力。
SWE309L is a low-carbon (0.03%) flux-cored wire, which can reduce the possibility of intergranular carbide precipitation. Thus, it enhances the resistance to intergranular corrosion without the use of stabilizers (such as niobium or titanium).

应用 APPLICATIONS

用于碳钢和不锈钢异种材料焊接、石油化工行业反应容器内壁堆焊过渡金属或应用于韧性较差的马氏体、铁素体不锈钢焊接。
It is used for the welding of dissimilar materials between carbon steel and stainless steel, the surfacing of transition metals on the inner wall of reaction vessels in the petrochemical industry, and the welding of martensitic and ferritic stainless steels with poor toughness.

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
GB/T Standard	≤0.04	≤1.00	0.5-2.5	≤0.040	≤0.030	≤0.75	12-14	22.0-25.0	≤0.75
例值 Typical values	0.021	0.58	1.68	0.018	0.003	0.07	12.39	23.82	0.08

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	≥520	≥25	-20	≥27
例值 Typical values	470	545	39		115

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.6
平焊 Flat		120-200	140-220	200-300
电流 Current [A]	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