

SWE309LMo

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

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执行标准 CLASSIFICATION

符合 GB T17853 E309LMo-F C1 1 AWS A5.22 E309LMoT1-1 ISO 17633A T 23 12 2 L P C1

产品特性 DESCRIPTION

SWE309LMo 较 SWE309L 添加了 2.0%-3.0% 的 Mo，以增加其在含氟 F、氯 Cl、溴 Br、碘 I 环境中的点蚀抗性。SWE309LMo 药芯焊丝主要应用是母材的表面改性，以提高其耐腐蚀性。它还用于多层堆焊的打底层，填料金属如 SWE316 或 SWE317 不锈钢。如果没有 SWE309Mo 的打底层，防止铬和钼等元素的过量稀释。

Compared with SWE309L, SWE309LMo has an additional 2.0%-3.0% molybdenum (Mo) added to enhance its pitting corrosion resistance in environments containing fluorine (F), chlorine (Cl), bromine (Br), and iodine (I). The main application of SWE309LMo flux-cored wire is surface modification of base metals to improve their corrosion resistance. It is also used as the backing layer in multi-layer surfacing, with filler metals such as SWE316 or SWE317 stainless steel. Without the backing layer of SWE309Mo, it can prevent excessive dilution of elements such as chromium (Cr) and molybdenum (Mo).

应用 APPLICATIONS

用于焊接耐硫酸介质（硫酸）腐蚀的同类型不锈钢容器，也可作不锈钢衬里、复合钢板、异种钢的焊接。

It is used for welding stainless steel vessels of the same type that resist corrosion from sulfuric acid media (ammonium sulfate). It can also be used for welding stainless steel linings, clad steel plates, and dissimilar steels.

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	Cu	Ni	Cr	Mo
GB/T Standard	≤0.04	≤1.00	0.5-2.5	≤0.040	≤0.030	≤0.75	12-16	21.0-25.0	2.0-3.0
例值 Typical values	0.027	0.52	1.30	0.022	0.006	0.07	12.50	22.2	2.32

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	≥15	-20	≥27
例值 Typical values	470	550	30		115

作业条件 OPERATING CONDITIONS

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

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