

SWE310



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/T 17853 TS310-FC11 AWS A5.22 E310T1-1

产品特性 DESCRIPTION

SWE310 是一种 CO₂ 气体保护不锈钢药芯焊丝,适用于耐高温板材及硝酸腐蚀环境下板材的焊接, 产品电弧柔和稳定, 飞溅少, 成形美观, 脱渣容易, 具有良好的焊接工艺性能, 可进行全位置焊接。

SWE310 is a type of stainless steel flux-cored wire for CO₂ gas shielded welding. It is suitable for welding high-temperature resistant plates and plates used in nitric acid corrosion environments. This product features a soft and stable electric arc, low spatter, beautiful weld formation, easy slag removal, and excellent welding process performance, enabling all-position welding.

应用 APPLICATIONS

适用于 SUS310S 耐高温板材的焊接, 如高温炉、煤炭焦化设备等、也可用于异种材料的焊接。

It is suitable for welding SUS310S high-temperature resistant plates, such as those used in high-temperature furnaces, coal coking equipment, etc., and can also be used for welding dissimilar materials.

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	0.08-0.15	0.30-0.65	1.00-2.50	≤0.030	≤0.030	≤0.75	20.0-22.5	25-28	≤0.75
例值 Typical values	0.087	0.56	2.00	0.012	0.011	0.32	21.85	27.28	0.36

熔敷金属力学性能 MECHANICAL PROPERTIES OF WELDED METAL

试验项目	R _e /R _{p0.2} 屈服强度 (MPa)	R _m 抗拉强度 (MPa)	A 伸长率 (%)	试验温度 (°C)	KV ₂ (J)
GB/T Standard	--	≥390	≥30	-	-
例值 Typical values	-	589	34	-	-

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	φ1.2		φ1.6	
	平焊 Flat		200-300	
	上立焊/仰焊 V-Up&Overhead		220-320	
	下立焊 Vertical Downward		200-280	
电流 Current [A]	140-220		220-320	

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