

SWER347L

SE 东南焊材
SOUTHEAST
WELDING MATERIAL

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 TS347L-FC11 AWS A5.22 E347T1-1 ISO 17633-A-T 19 9 Nb Rc1 1

产品特性 DESCRIPTION

SW-ER347L 成分为 20 Cr 和 10 Ni, 添加 Nb 作为稳定剂, 全焊缝金属显微组织通常为奥氏体, 含有少量铁素体。 铌的添加降低了晶间碳化铬沉淀, 从而降低了晶间腐蚀的敏感性。 常用于焊接成分相似且用铌或钛稳定的铬镍不锈钢母材。 尽管铌是 347 型合金中通常指定的稳定元素, 但因为钽 (Ta) 的存在, Ta 和 Nb 在稳定碳和提供高温强度方面几乎同样有效。 如果母材稀释产生低铁素体或全奥氏体焊缝金属, 则焊缝的裂纹敏感性可能会大幅增加。

The composition of SW-ER347L includes 20% Cr and 10% Ni, with niobium (Nb) added as a stabilizer. The microstructure of the full weld metal is typically austenitic, containing a small amount of ferrite. The addition of niobium reduces the precipitation of intergranular chromium carbides, thereby lowering the susceptibility to intergranular corrosion. This filler metal is commonly used for welding base metals of chromium-nickel stainless steel that have a similar composition and are stabilized with niobium or titanium. Although niobium is the stabilizer element usually specified in Type 347 alloys, tantalum (Ta) may be present. Tantalum and niobium are nearly equally effective in stabilizing carbon and providing high-temperature strength. If base metal dilution results in a weld metal with low ferrite content or fully austenitic structure, the crack susceptibility of the weld may increase significantly.

应用 APPLICATIONS

应用于食品机械、医疗器械、压力容器、石油化工等场合, 如焊接 18%Cr-8%Ni-Nb 不锈钢 (SUS347 等), 低碳 18%Cr-8%Ni-Ti 不锈钢 (SUS321 等)。 It is applied in scenarios such as food machinery, medical equipment, pressure vessels, and petrochemical industry, for example, in welding 18%Cr-8%Ni-Nb stainless steel (e.g., SUS347) and low-carbon 18%Cr-8%Ni-Ti stainless steel (e.g., SUS321).

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	Nb+Ta	Al
GB/T Standard	≤0.04	≤1.0	0.50-2.50	≤0.04	≤0.030	≤0.75	9.0-11.0	18.0-21.0	8×C-1.0	-
例值 Typical values	0.029	0.69	1.68	0.021	0.003	0.08	9.6	19.57	0.48	-

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

试验项目	R _{el} /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	-	≥520	≥25	-	-
例值 Typical values	-	540	38	-	-

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
上立焊/仰焊 V-Up&Overhead	100-160	140-180	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