

SEWELD 410

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 T17853 TS410-F C1 1 AWSA5.22 E410T1-1 ISO 17633A T 13 P C1 1

产品特性 DESCRIPTION

SW-E410 主要成分为 11-13 Cr, 全焊缝金属显微组织几乎全为马氏体。为了实现焊缝有足够的延展性, 需要进行预热和焊后热处理。此类填充金属最常见的应用是焊接具有相似成分的合金。它还用于在碳钢上沉积覆盖层以抵抗腐蚀、侵蚀或磨损。

SW-E410 has a main composition of 11-13% chromium (Cr), and the microstructure of the all-weld metal is almost entirely martensitic. In order to achieve sufficient ductility of the weld, preheating and post-weld heat treatment are required. The most common application of this type of filler metal is welding alloys with similar compositions. It is also used to deposit overlay on carbon steel to resist corrosion, erosion or abrasion.

应用 APPLICATIONS

适用于焊接 06Cr13 等 13Cr 马氏体不锈钢, 也可用于耐蚀、耐磨的表面堆焊。

It is suitable for welding 13Cr martensitic stainless steels such as 06Cr13. It can also be used for surface surfacing to achieve corrosion resistance and wear resistance.

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	≤0.12	≤1.00	≤1.2	≤0.040	≤0.030	≤0.75	≤0.6	11.0-13.5	≤0.75
例值 Typical values	0.038	0.45	0.45	0.024	0.004	0.035	0.04	11.8	0.05

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	490-670	≥18	-20	≥27
例值 Typical values	470	556	27		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

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