

SWE410NiMo



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 TS410NiMo-F C1 1 AWS A5.22 E410NiMoT1-1 ISO 17633A T 13 4 P C1 1

产品特性 DESCRIPTION

SW-E410NiMo 主要成分为 11-13 Cr, 增加 Ni、Mo 耐蚀性更强, 尤其提升了抗点蚀、缝隙腐蚀和耐还原性介质腐蚀的能力, 可以应对更为复杂的腐蚀环境。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。

SW-E410NiMo has a main composition of 11-13% chromium (Cr), and the microstructure of the all-weld metal is almost entirely martensitic. To achieve sufficient ductility in 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 overlays on carbon steel to resist corrosion, erosion, or abrasion.

应用 APPLICATIONS

适用于焊接 04Cr13Ni5Mo、ASTMCA6NM 钢, 多用于焊接水轮机转子、阀门等耐磨耐腐蚀件。

It is suitable for welding 04Cr13Ni5Mo and ASTM CA6NM steels, and is mostly used for welding wear-resistant and corrosion-resistant components such as hydraulic turbine rotors and valves.

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	≤0.06	≤1.00	≤1.0	≤0.040	≤0.030	≤0.75	4.0-5.0	11.0-12.5	0.4-0.7
例值 Typical values	0.053	0.5	0.3	0.016	0.003	0.08	4.3	11.6	0.45

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
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