

SWE2209



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 TS2209-FC11 AWS A5.22 E2209T1-1 ISO 17633A T22 9 3 N L P C1 1

产品特性 DESCRIPTION

SWE2209 为 22.5Cr、8.5Ni、3Mo 和 0.15N。这种合金的沉积层具有由奥氏体-铁素体基体组成的“双相”显微组织。这些不锈钢的特点是具有高抗拉强度，抗应力腐蚀开裂，以及更好的抗点蚀性能。

WE2209 consists of 22.5% Cr, 8.5% Ni, 3% Mo, and 0.15% N. The deposit of this alloy has a "duplex" microstructure composed of an austenitic-ferritic matrix. These stainless steels are characterized by high tensile strength, resistance to stress corrosion cracking, and better pitting corrosion resistance.

应用 APPLICATIONS

适用于焊接 22%Cr 的双相不锈钢，如 UNS531803(即 Alloy2205)的焊接。

It is suitable for welding 22%Cr duplex stainless steels, such as UNS S31803 (i.e., Alloy 2205).

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	N
GB/T Standard	≤0.04	≤1.0	0.5-2.0	≤0.04	≤0.03	≤0.75	7.5-10.0	21.0-24.0	2.5-4.0	0.08-2.0
例值 Typical values	0.033	0.50	1.14	0.015	0.004	0.022	8.19	22.45	3.4	0.13

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	-	≥690	≥15	-	-
例值 Typical values	-	820	26	-	-

作业条件 OPERATING CONDITIONS

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

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