

SWE2594



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 TS2594-FC11 AWS A5.22 E2594T1-1 ISO 17633A T25 9 4 N L P C1 1

产品特性 DESCRIPTION

SWE2594 主要成分为 25.5Cr、9.2Ni、3.5Mo 和 0.25N。Cr+3.3 (Mo+0.5W) +16N 的总和, 该焊接金属被称为“在含氯化物水环境中耐腐蚀性优于焊接金属”。

The main components of SWE2594 are 25.5% Cr, 9.2% Ni, 3.5% Mo, and 0.25% N. Based on the sum of Cr + 3.3(Mo + 0.5W) + 16N, this weld metal is known to "have better corrosion resistance than other weld metals in chloride-containing aqueous environments".

应用 APPLICATIONS

适用于双相不锈钢 UNS S32750, UNSJ93380 及双相钢 S32205 的焊接。道间温度 $\leq 100^{\circ}\text{C}$ 。

It is suitable for welding duplex stainless steels such as UNS S32750, UNS J93380, and duplex steel S32205. The interpass temperature shall be $\leq 100^{\circ}\text{C}$.

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	W
GB/T Standard	≤ 0.04	≤ 1.0	0.5-2.5	≤ 0.040	≤ 0.030	≤ 1.5	8.0-10.5	24.0-27.0	2.4-4.5	≤ 1.0
例值 Typical values	0.025	0.62	1.15	0.010	0.001	0.15	9.01	24.82	3.51	0.42

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	-	≥ 760	≥ 13	-	-
例值 Typical values	-	859	19	-	-

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		$\phi 1.0$	$\phi 1.2$	$\phi 1.6$
电流 Current [A]	平焊 Flat	-	120-260	200-300
	上立焊/仰焊 V-Up&Overhead	-	110-250	-
	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