

SEWELD

SE 东南焊材
SOUTHEAST
WELDING MATERIAL

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490Mpa 级金属粉型药芯焊丝
490Mpa Metal powder flux-cored wire

执行标准 CLASSIFICATION

符合 GB/T 10045T49 3 T15 0 M21 A 相当 AWS A5.18 E70C 6M ISO 17632A T42 3 P M21 3

产品特性 DESCRIPTION

金属粉型 50kg 级药芯焊丝, 药粉中增加了较多的金属合金成分, 除有效的保证焊缝强度外, 也增加了焊接铁水流动性, 焊接效率较一般材料提升 10%。产品中增加了氟化物的含量, 氟化物在焊接过程中与氢产生化合物, 有效的降低焊缝氢含量, 增强了焊缝的抗裂性, 产品适用于厚板材料和易开裂结构的焊接场景。

The metal powder type 50kg class flux-cored welding wire has an increased amount of metal alloy components in its powder. In addition to effectively ensuring the weld strength, it also improves the fluidity of the welding molten iron, increasing the welding efficiency by 10% compared with ordinary materials. The fluoride content in the product has been increased. During the welding process, fluoride forms compounds with hydrogen, which effectively reduces the hydrogen content in the weld and enhances the crack resistance of the weld. This product is suitable for welding scenarios involving thick plate materials and crack-prone structures.

应用 APPLICATIONS

用于造船、钢结构、建筑、桥梁、机械设备、车辆制造、海洋平台、管道、锅炉及压力容器等焊接需求

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 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 %

试验项目 Item	C	Si	Mn	P	S	Ni	Cr	Mo	V
GB/T Standard	≤0.18	≤0.9	≤2.00	≤0.030	≤0.030	≤0.5	≤0.2	≤0.3	≤0.08
例值 Typical values	0.047	0.43	1.23	0.010	0.011	0.002	0.05	0.02	0.012

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

试验项目 Item	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	467	554	27		92

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.4	φ1.6
电流 Current [A]	平焊 Flat	120 ~ 250	150-280	150-300	150-320

包装 PACKAGING

5kg 15kg 盘装 Coil

也可以定制其他包装和规格 Other packaging and other diameters: please consult us