

SWE80M



550Mpa 级金属粉型药芯焊丝
550Mpa Metal powder flux-cored wire

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执行标准 CLASSIFICATION

符合 GB/T 10045-2018 T554T15-1M21A-N2 AWS A5.28 E80M G ISO 17632A T46 3 Z M M21 3

产品特性 DESCRIPTION

SWE80M 产品为金属粉型高强度药芯焊丝，具有熔渣薄、熔覆效率高、不易受潮、氢含量低等特点。本品使用 Ar+20%CO₂ 混合气体减少了硅、锰的烧损，可有效提升焊缝的抗拉和屈服强度及冲击性能。

The SWE80M product is a metal-powder type flux-cored wire for high-strength steel, featuring thin slag, high cladding efficiency, resistance to moisture absorption, and low hydrogen content. When using this product with an Ar + 20% CO₂ mixed gas, the burn loss of silicon and manganese is reduced, which can effectively improve the tensile strength, yield strength, and impact properties of the weld.

应用 APPLICATIONS

适用于 Q550、桥梁 S550QL 及 ASTM A913 等等级别的板材。

It is suitable for plates of equivalent grades such as Q550, bridge steel S550QL, and ASTM A913.

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	Ni	Mo
GB/T Standard	≤0.12	≤0.8	≤1.75	≤0.030	≤0.030	0.80-1.20	≤0.35
例值 Typical values	0.061	0.27	0.96	0.009	0.008	0.88	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	≥460	550-740	≥17	-40	≥27
例值 Typical values	562	639	29		121

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	φ1.0	φ1.2	φ1.6
平焊 Flat	-	150-300	-
电流 Current [A]			
上立焊/仰焊 V-Up&Overhead	-	-	-
下立焊 Vertical Downward	-	-	-

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