

SWE71NH

SE 东南焊材®
SOUTHEAST
WELDING MATERIAL

耐候钢用药芯焊丝
Flux Cored Wire For Weather Proof Steel

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执行标准 CLASSIFICATION

符合 GB/T10045 T49 4T1-1 C1 A NCC2 相当 A5.29 E71T1 GC

产品特性 DESCRIPTION

SWE71NH 属于定制化耐候钢焊丝，常用于海工、公路及桥梁等长期暴露于大气中的户外结构。

SWE71NH is a customized weathering steel welding wire, which is often used in outdoor structures that are exposed to the atmosphere for a long time, such as marine engineering, highways and bridges.

应用 APPLICATIONS

适用于 Q355NH 及 ASTM A588 等同等强度的钢材。

It is suitable for steels with equivalent strength such as Q355NH and ASTM A588.

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
GB/T Standard	≤0.12	0.2-0.8	0.8-1.6	≤0.03	≤0.03	0.20-0.50	0.3-0.8	0.1-0.4
例值 Typical values	0.04	0.30	1.25	0.012	0.005	0.33	0.71	0.21

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	-40°C	≥47
例值 Typical values	460	550	27.5		120

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.2	φ1.4	φ1.6
电流 Current [A]	平焊 Flat	150-300	180-320	200-400
	上立焊/仰焊 V-Up&Overhead	120-260	150-280	180-280
	下立焊 Vertical Downward	110-180	130-200	150-230

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