

# SWE91NH

 **东南焊材**  
SOUTHEAST  
WELDING MATERIAL

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

## 执行标准 CLASSIFICATION

符合 GB/T 36233 T62 4T1 1 C1 A G 相当 A5.29 E91T1 GC

## 产品特性 DESCRIPTION

SWE91NH 耐候钢焊材常用于海洋工程装备、跨江跨海大桥、重型机械等。

The SWE91NH weathering steel welding consumable is often used in marine engineering equipment, river-crossing and sea-crossing bridges, heavy machinery, and other applications.

## 应用 APPLICATIONS

适用于 Q620NH 及 A847 Grade D 等同等强度的钢材。

It is suitable for steels with equivalent strength such as Q620NH and A847 Grade D.

## 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%Co<sub>2</sub> 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 | 0.5-1.0 | 0.15-0.50 |
| 例值 Typical values | 0.05  | 0.32    | 1.25    | 0.010 | 0.006 | 0.030     | 0.80    | 0.25      |

## 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     | ≥500                 | ≥630          | ≥19       | -40°C     | ≥54    |
| 例值 Typical values | 600                  | 680           | 22.5      |           | 105    |

## 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