

SW·ER70S-2



碳钢气保护实心焊丝
Solid Wire For Carbon Steel

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执行标准 CLASSIFICATION

相当 AWSA5.18 ER70S2 ISO 14341BG 49A 4 C1 S2

产品特性 DESCRIPTION

SW-ER70S-2 由于添加了脱氧剂, 这些填充金属可用于焊接表面生锈或肮脏的母材, 由于填充丝中含有三重脱氧剂, 与 SW-ER70S-6 相比, SW-ER70S-2 更适合焊接在生锈的表面上, 但要牺牲一些焊接质量。

Due to the addition of deoxidizers, these filler metals can be used for welding base metals with rusty or dirty surfaces. As the filler wire contains triple deoxidizers, SW-ER70S-2 is more suitable for welding on rusty surfaces compared to SW-ER70S-6, but this comes at the cost of some welding quality.

应用 APPLICATIONS

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电源类型 Current type

焊枪接正电极 DC+

保护气体 Protection

100%Ar

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	AL	Ti	Zr	Ni	Cr	Mo	V
GB/T Standard	≤0.07	0.4-0.7	0.9-1.4	0.05-0.15	0.05-0.15	0.02-0.12	≤0.15	≤0.15	≤0.15	≤0.03
例值 Typical values	0.041	0.45	1.20	0.065	0.08	0.06	0.005	0.005	0.002	0.002

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	Φ0.8	Φ1.0	Φ1.2
电流 Current [A]	平焊 Flat 80~150	120~220	150~240

包装 PACKAGING

1kg 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
40-1000mm × 5kg 10kg 直条焊丝 Straight Stick Welding Wire