

# SW·ER70S-4

碳钢气保护实心焊丝  
Solid Wire For Carbon Steel



## 执行标准 CLASSIFICATION

符合 GB/T 8110 G49AZC1S4 相当 GB/T 8110 G49AZC1S4 AWS A5.18 ER70S4 ISO 14341AG 49 Z C1 S4

## 产品特性 DESCRIPTION

SW-ER70S-4 类别的焊丝和填充丝适用于焊接其条件要求比 SW-ER70S-3 填充金属能提供更多脱氧能力的钢种。典型的母材标准通常与 SW-ER70S-2 类别适用的一样。本类别不要求冲击试验。

Welding wires and filler wires in the SW-ER70S-4 category are suitable for welding steel grades that require more deoxidizing capacity than what the SW-ER70S-3 filler metals can provide. Typically, the standard specifications for the base metals are the same as those applicable to the SW-ER70S-2 category. Impact testing is not required for this category.

## 应用 APPLICATIONS

适用于板金薄板焊接，钢管焊接。

Suitable for sheet metal thin plate welding and steel pipe welding.

## 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      | P      | S      | Cu    | Ni    | Cr    | Mo    | V     |
|-------------------|-----------|-----------|---------|--------|--------|-------|-------|-------|-------|-------|
| GB/T Standard     | 0.06-0.15 | 0.65-0.85 | 1.0-1.5 | ≤0.025 | ≤0.025 | ≤0.5  | ≤0.15 | ≤0.15 | ≤0.15 | ≤0.03 |
| 例值 Typical values | 0.085     | 0.718     | 1.05    | 0.014  | 0.014  | 0.106 | 0.005 | 0.018 | 0.006 | 0.003 |

## 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