

SW·ER80S-B2



高性能 55kg 级耐热钢用气体保护焊丝
550Mpa MIG Wire for heat-resistant steel

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执行标准 CLASSIFICATION

符合 GB/T8110 G55 M13 1CM AWS A5.28 ER80SB2 ISO 14341 AG Z CrMo1Si

产品特性 DESCRIPTION

SWER80S-B2 是耐热钢用气保实心焊丝, 采用混合气体保护。电弧柔和, 焊接稳定; 焊缝成形平整、美观。通过严格控制焊丝的硫、磷杂质含量, 使焊缝获得优良的综合力学性能。

SWER55-B2 is a gas-shielded solid welding wire for heat-resistant steel, which adopts mixed gas shielding. It features a soft arc and stable welding performance, with flat and aesthetically pleasing weld formation. By strictly controlling the content of sulfur and phosphorus impurities in the welding wire, the weld is endowed with excellent comprehensive mechanical properties.

应用 APPLICATIONS

适用于焊接工作稳定在 520 摄氏度以下的 Cr1%-Mo0.5%的耐热钢, 如焊接锅炉管道、高压容器、石油精炼设备等。

It is suitable for welding Cr1%-Mo0.5% heat-resistant steel where the welding work operates stably below 520°C, such as welding boiler pipes, high-pressure vessels, petroleum refining equipment, etc.

电 源 类 型

CURRENT TYPE

焊枪接正电极 DC+

过程保护 PROCESS

100% CO₂ 或 Ar+0.5-5%O₂

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
GB/T Standard	0.07-0.12	0.40-0.7	0.40-0.7	≤0.025	≤0.025	≤0.35	≤0.20	1.20-1.5	0.4-0.65
例值 Typical values	0.09	0.52	0.61	0.010	0.011	0.012	0.008	1.32	-

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	≥470	≥550	≥19	-	-
例值 Typical values	512	603	23	-	-

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ1.0	φ1.2	φ1.6
电流 Current [A]	平焊 Flat	180-220	200-320	220-350

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