

SW·ER90S-G



高强钢气保护实心焊丝
Solid Wire For High-strength Steel

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执行标准 CLASSIFICATION

符合 GB/T 39281 G62A 4 M21 3M1T 相当 GB/T 39281 G62A 4 M21 3M1T AWS A5.28 ER90SG ISO 16834BG 59A 2 M21 3M1T

产品特性 DESCRIPTION

SW-ER90S-G 未包含在前面所列的产品中, 并且仅规定了某些机械性能要求。适用于单道和多道焊。应咨询填充金属供应商了解这些类别的成分、性能、特性和预期用途。

SW-ER90S-G is not included in the products listed earlier, and only certain mechanical property requirements are specified for it. It is suitable for both single-pass welding and multi-pass welding. The filler metal supplier should be consulted for information regarding the composition, performance, characteristics and intended applications of this category.

应用 APPLICATIONS

适用于焊接 620MPa 抗拉强度等级高强钢结构, 如工程机械、管线、石油化工、煤矿机械等低合金钢的焊接。

It is suitable for welding high-strength steel structures with a tensile strength grade of 620MPa, such as the welding of low-alloy steels used in engineering machinery, pipelines, petrochemical industry, coal mine machinery, etc.

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	Ti	Cr
GB/T Standard	≤0.11	0.5-0.9	1.4-1.8	≤0.025	≤0.025	≤0.50	≤0.17	0.1-0.6
例值 Typical values	0.05	0.65	1.62	0.011	0.012	0.05	0.03	0.32

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