

SW·ER90S-B3



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 G62 M13 2C1M 相当 GB/T 39281 G62 M13 2C1M AWS A5.28 ER90SB3 ISO 14341AG CrMo2Si

产品特性 DESCRIPTION

SW-ER90S-B3 用于连接 Cr-Mo 和碳钢的不同组合。它们设计用于使用 Ar1-5% O₂ 的 GMAW 或使用 100% Ar 的 GTAW。可以使用 GMAW 工艺的所有转移模式。由于强度较高，需严格控制预热、道间温度和后热，对于避免裂纹至关重要。

SW-ER90S-B3 is used for joining different combinations of Cr-Mo steels and carbon steels. They are designed for Gas Metal Arc Welding (GMAW) using an argon mixture with 1-5% oxygen (Ar1-5% O₂) or Gas Tungsten Arc Welding (GTAW) using 100% argon (100% Ar). All transfer modes of the GMAW process can be applied. Due to their relatively high strength, strict control of preheating temperature, interpass temperature and post-heating temperature is essential to prevent cracking.

应用 APPLICATIONS

适用于焊接工作温度在 550°C 以下的 Cr2.5Mo 的耐热钢，如锅炉管道、高温高压容器、石油精炼设备等的焊接。

It is suitable for welding Cr2.5Mo heat-resistant steel with a service temperature below 550°C, such as the welding of boiler pipes, high-temperature and high-pressure vessels, petroleum refining equipment, 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	Cr	Mo
GB/T Standard	≤0.12	0.3-0.90	0.75-1.50	≤0.025	≤0.025	≤0.35	2.1-2.7	0.9-1.2
例值 Typical values	0.023	0.40	1.63	0.013	0.009	0.16	2.3	1.05

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