

H 1 0 M n 2



江苏省溧阳市南渡镇金山路 2 号
Tel: 05198089768 Fax: 051980897358
SEWELD@163.COM
WWW.SEWELD.COM

埋 弧 焊 丝
Submerged Arc Welding Wires

执行标准 CLASSIFICATION

符合 GB/T 5293 SU34 AWS A5.17 EH14 ISO 14171-B-SU33

产品特性 DESCRIPTION

H10Mn2 含有较高的锰含量，主要用于碳钢和低合金钢的焊接，特别是在需要较高强度的应用中。适合在低温环境下强度要求更高的板材焊接。

H10Mn2 contains a relatively high manganese content and is mainly used for the welding of carbon steel and low-alloy steel, especially in applications requiring higher strength. It is suitable for the welding of plates that demand higher strength in low-temperature environments.

应用 APPLICATIONS

与烧结型焊剂 101 配合，500MPa 抗拉强度等级母材的高速焊接及填充焊接均可。具有非常稳定的熔敷金属机械性能。

When matched with sintered flux 101, it is suitable for both high-speed welding and fill welding of base metals with a tensile strength grade of 500MPa. It exhibits extremely stable mechanical properties of deposited metal.

电源类型 CURRENT TYPE

焊枪接正电极 DC+

过程保护 PROCESS

配合 SJ101 焊剂 / SJ101 FLUX

焊接位置 WELDING POSITIONS

平焊、角焊 Flat, fillet

熔敷金属化学成分 CHEMICAL COMPOSITION OF WELDED METAL %

项目	C	Si	Mn	P	S	Cu	Ni	Cr
GB/T Standard	≤0.12	≤0.07	1.5-1.9	≤0.03	≤0.03	≤0.35	≤0.30	≤0.2
例值 Typical values	0.066	0.011	1.62	0.011	0.011	0.12	0.007	0.013

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)
配合 SJ101 焊剂例值	≥390	490-670	≥18	-40	≥27

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]		φ2.5	φ3.2	φ4.0	φ5.0
电流 Current [A]	平焊 Flat	340 ~ 490	400 ~ 540	460 ~ 610	560 ~ 660

包装 PACKAGING

25 kg 200 kg 250 kg 盘装 Coil 也可以定制其他包装和规格 Other packaging and other diameters: please consult us