

SW·ER307



不 锈 钢 气 体 保 护 焊 丝
MIG WIRES FOR STAINLESS STEEL

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执行标准 CLASSIFICATION

符合 GB/T 29713 S307 AWS A5.9 ER307 ISO 14343-B-SS307

产品特性 DESCRIPTION

SW-MG307 焊丝主要成分是 18Cr-8Ni-4Mn, 为纯奥氏体不锈钢焊丝, 可全位置焊接。熔敷金属对裂纹敏感度低, 适用于非磁性、高锰钢、硬化性耐蚀钢焊接。焊接作业性极佳--送丝顺畅、电弧稳定、成形美观、飞溅极少。

The main component of SW-MG307 welding wire is 18Cr-8Ni-4Mn, which is pure austenitic stainless steel welding wire and can be welded in all positions. The deposited metal has low sensitivity to cracks and is suitable for welding non-magnetic, high-manganese steel and hardenable corrosion-resistant steel. It has excellent welding performance, smooth wire feeding, stable arc, beautiful shape, and very little spatter.

应用 APPLICATIONS

常应用于核潜艇、防弹钢板等需要无磁性的特殊场合, 也可用于难焊且易开裂的异种钢材焊接。

It is often used in special occasions such as nuclear submarines and bullet-proof steel plates that require non-magnetic properties. It can also be used to weld dissimilar steels that are difficult to weld and easy to crack.

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
GB/T Standard	0.04-0.14	0.3-0.65	3.30-4.75	≤0.030	≤0.030	≤0.75	8.0-10.7	19.5-22.0	0.5-1.50
例值 Typical values	0.080	0.43	4.50	0.012	0.011	0.18	9.52	20.02	0.97

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