

SW·ER309

SE 东南焊材®
SOUTHEAST
WELDING MATERIAL

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 S309 AWS A5.9 ER309 ISO 14343-A-G 22 12 H

产品特性 DESCRIPTION

SW-MG309 焊丝主要成分是 22Cr-12Ni, 为不锈钢 MIG 焊丝, 可全位置焊接。焊接作业性极佳--送丝顺畅、电弧稳定、成形美观、飞溅极少。熔敷金属含有铁素体, 抗裂性能良好, 耐腐蚀性能优良, 因合金的含量高, 耐高温性良好。

The main component of SW-MG309 welding wire is 22Cr-12Ni, which is stainless steel MIG welding wire and can be welded in all positions. It has excellent welding performance, smooth wire feeding, stable arc, beautiful shape, and very little spatter. The deposited metal contains ferrite, which has good crack resistance and corrosion resistance. Due to the high content of alloy, it has great high temperature resistance.

应用 APPLICATIONS

常应用于碳钢与不锈钢异种材料焊接或应用于韧性较差的马氏体、珠光体不锈钢焊接。应用场合如石油化工、火力电站等行业。

It is often used for welding carbon steel and stainless steel dissimilar materials or for welding martensitic and pearlitic stainless steels with poor toughness. Applications such as petrochemical, thermal power plants and other industries.

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	V
GB/T Standard	≤0.12	0.3-0.65	1.0-2.50	≤0.030	≤0.030	≤0.75	12.0-14.0	23.0-25.0	≤0.75	-
例值 Typical values	0.081	0.40	1.61	0.012	0.013	0.23	13.15	23.85	0.23	-

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