

SW·ER309L



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 S309L 相当 AWS A5.9 ER309L JIS Z3313 T492T1-1CAEN ISO 14343-A-G 23 12 L

产品特性 DESCRIPTION

SW-ER309L 焊丝主要成分是超低碳 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, 因合金的含量高, 耐高温性良好, 含碳量低, 耐腐蚀性能优良。

The main component of SW-MG309L welding wire is ultra-low carbon 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 and has good crack resistance. Due to the high alloy content, it has great high temperature resistance; low carbon content and excellent corrosion resistance.

应用 APPLICATIONS

应用于碳钢与不锈钢异种材料焊接、石化工业如反应容器内壁堆焊过渡金属, 或应用于韧性较差的马氏体、铁素体不锈钢焊接。

It is often used in the welding of carbon steel and stainless steel dissimilar materials, in the petrochemical industry such as the transition metal welding on the inner wall of the reaction vessel, or used in the welding of martensitic and ferritic stainless steel with poor toughness.

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	≤0.030	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	0.021	0.34	1.95	0.012	0.012	0.19	12.92	23.90	0.39	-

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