

SW-ER309LSi



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 S309LSi 相当 GB/T 29713 S309LSi AWS A5.9 ER309LSi ISO 14343-AG 23 12 L Si

产品特性 DESCRIPTION

SW-ER309LSi 超低碳不锈钢焊丝, 较 SW-ER309L, 增加的 Si 含量, 使焊接流动性提升, 但裂纹敏感性增加。常用于不锈钢与低碳钢等异种钢的焊接。
SW-ER309LSi is an ultra-low carbon stainless steel welding wire. Compared with SW-ER309L, its increased silicon content improves the welding fluidity, but also increases the crack sensitivity. It is often used for the welding of dissimilar steels such as stainless steel and low-carbon steel.

应用 APPLICATIONS

常应用于碳钢与不锈钢异种材料焊接、石油化工行业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 widely used in
It is often used for the welding of dissimilar materials between carbon steel and stainless steel, the surfacing of transition metals on the inner wall of reaction vessels in the petrochemical industry, or the welding of martensitic and ferritic stainless steels 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
GB/T Standard	≤0.030	0.65-1.0	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	0.78	2.33	0.012	0.014	0.19	13.84	23.93	0.46

作业条件 OPERATING CONDITIONS

直径 Diameter [mm]	Φ0.8	Φ1.0	Φ1.2
电流 Current [A]	平焊 Flat 70~150	100~200	140~220

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