

SW·ER316

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 S316 相当 GB/T 29713 S316 AWS A5.9 ER316 ISO 14343-A

产品特性 DESCRIPTION

该分类的标称成分为 19 Cr、12.5 Ni 和 2.5 Mo，全焊缝金属显微组织通常为奥氏体和少量铁素体。这种填充金属用于焊接 316 型和类似合金。它已成功用于涉及高温服务的特殊贱金属的某些应用。钼的存在提供了高温下的抗蠕变性和卤化物气氛中的抗点蚀性。

The nominal composition of this classification is 19% Cr, 12.5% Ni, and 2.5% Mo, and the microstructure of the all-weld metal is typically austenite with a small amount of ferrite. This filler metal is used for welding Type 316 and similar alloys. It has been successfully applied in certain applications involving special base metals for high-temperature service. The presence of molybdenum provides creep resistance at high temperatures and pitting corrosion resistance in halide atmospheres.

应用 APPLICATIONS

常应用于石油化工、化肥设备，如 06Cr17NiMo2 (SUS 316) 等材料的焊接。

It is often used in the welding of equipment in the petrochemical and fertilizer industries, such as materials like 06Cr17NiMo2 (equivalent to SUS316).

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	≤0.08	0.3-0.65	1.0-2.50	≤0.030	≤0.030	≤0.75	11.0-14.0	18.0-20.0	2.0-3.0
例值 Typical values	0.048	0.45	1.75	0.011	0.010	0.26	12.52	19.63	2.5

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