

SW·ER321

SE 东南焊材®
SOUTHEAST
WELDING MATERIAL

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

执行标准 CLASSIFICATION

符合 GB/T 29713 S321 相当 GB/T 29713 S321 AWS A5.9 ER321

产品特性 DESCRIPTION

SW-ER321 主要成分为 19.5 Cr 和 9.5 Ni, 添加钛, 全焊缝金属显微组织通常为奥氏体, 含有少量铁素体。钛的作用与 347 型中的铌相同, 可以减少晶间碳化铬沉淀, 从而提高抗晶间腐蚀能力。该类别的填充金属用于采用惰性气体保护工艺焊接成分相似的铬镍不锈钢母材。因为 Ti 在埋弧焊时烧损较为严重, 不推荐埋弧焊使用。

The main composition of SW-ER321 consists of 19.5% Cr and 9.5% Ni, with titanium added. The microstructure of the all-weld metal is typically austenite, containing a small amount of ferrite. Titanium serves the same function as niobium in Type 347: it reduces the precipitation of chromium carbides at grain boundaries, thereby enhancing intergranular corrosion resistance. Filler metals in this classification are used for welding chromium-nickel stainless steel base metals with similar compositions using inert gas shielded processes. However, titanium suffers significant burn-off during submerged arc welding (SAW), so its use in this welding process is not recommended.

应用 APPLICATIONS

常应用于食品机械、医疗机械、压力容器、石油化工等场合, 如 07Cr19Ni11Ti (SUS 321)。

It is often used in applications such as food machinery, medical machinery, pressure vessels, and the petrochemical industry, for materials like 07Cr19Ni11Ti (SUS 321).

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	9.0-10.5	18.5-20.5	≤0.75
例值 Typical values	0.038	0.47	1.54	0.015	0.009	0.24	9.76	19.60	0.42

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