

SW·ER347

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 S347 AWS A5.9 ER347 ISO 14343-A-G 19 9 Nb

产品特性 DESCRIPTION

SW-MG347 焊丝主要成分是 19Cr-11Ni-Nb，为不锈钢 MIG 焊丝，可全位置焊接。因在 SUS308 基础上添加 Nb，能有效改善耐腐蚀性，尤其提高抗晶界腐蚀性能。焊接作业性极佳--送丝顺畅、电弧稳定、成形美观、飞溅极少。

The main component of SW-MG347 welding wire is 19Cr-11Ni-Nb, which is stainless steel MIG welding wire, which can be welded in all positions. Because Nb is added on the basis of SUS308, it can effectively improve the corrosion resistance, especially the grain boundary corrosion resistance. It has excellent welding performance, smooth wire feeding, stable arc, beautiful shape, and very little spatter.

应用 APPLICATIONS

常应用食品机械、医疗机械、压力容器、石油化工等场合，如 07Cr19Ni11Ti(SUS 321), 07Cr18Ni11Nb(SUS 347)。

Often used in food machinery, medical machinery, pressure vessels, petrochemicals and other occasions, such as 07Cr19Ni11Ti (SUS 321), 07Cr18Ni11Nb (SUS 347).

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	Nb
GB/T Standard	≤0.08	0.3-0.65	1.0-2.5	≤0.030	≤0.030	≤0.75	9.0-11.0	19.0-21.5	≤0.75	10×C-1.0
例值 Typical values	0.027	0.40	1.80	0.015	0.012	0.33	9.92	20.39	0.44	0.81

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

TIG 直条焊丝 Straight Stick Welding Wire