

SW·ER410



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 S410 相当 GB/T 29713 S410 AWS A5.9 ER410 ISO 14343-AG 13

产品特性 DESCRIPTION

SW-ER410 主要成分为 12 Cr, 全焊缝金属显微组织几乎全为马氏体。焊接金属是空气硬化钢。为了实现许多工程目的的足够延展性的焊缝, 需要进行预热和焊后热处理。此类填充金属最常见的应用是焊接具有相似成分的合金。它还用于在碳钢上沉积覆盖层以抵抗腐蚀、侵蚀或磨损。

The main composition of SW-ER410 is 12% Cr, and the microstructure of the all-weld metal is almost entirely martensite. The weld metal is an air-hardening steel. To achieve welds with sufficient ductility for many engineering purposes, preheating and post-weld heat treatment are required. The most common application of this type of filler metal is welding alloys with similar compositions. It is also used to deposit claddings on carbon steel to resist corrosion, erosion, or wear.

应用 APPLICATIONS

常用于水电站以及阀门等耐磨耐蚀场合, 如 12Cr13 (SUS 410)。

It is often used in wear-resistant and corrosion-resistant applications such as hydropower stations and valves, for materials like 12Cr13 (SUS 410).

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	≤0.12	≤0.50	≤0.60	≤0.030	≤0.030	≤0.75	≤0.60	11.5-13.5	≤0.75
例值 Typical values	0.080	0.30	0.41	0.021	0.011	0.33	0.19	11.83	0.35

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