

SW·ER630

 **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 S630 相当 GB/T 29713 S630 AWS A5.9 ER630 ISO 14343BSS630

产品特性 DESCRIPTION

SW-ER630 主要成分为 16.4 Cr、4.7 Ni 和 3.6 Cu，全焊缝金属通常几乎完全是马氏体，并含有微量铁素体。该成分主要用于焊接 ASTM A 564 630 型和一些其他沉淀硬化不锈钢。对该成分进行了改进，以防止在马氏体微观结构中形成铁素体网络，这对机械性能产生有害影响。根据应用和焊缝尺寸，焊缝金属可以按焊接状态使用；焊接和沉淀硬化；或焊接、固溶处理和沉淀硬化。

The main composition of SW-ER630 is 16.4% Cr, 4.7% Ni, and 3.6% Cu. The all-weld metal is usually almost entirely martensitic, containing a trace amount of ferrite. This composition is primarily used for welding ASTM A564 Type 630 and some other precipitation-hardening stainless steels. Modifications have been made to this composition to prevent the formation of ferrite networks in the martensitic microstructure, as such networks have a detrimental effect on mechanical properties. Depending on the application and weld size, the weld metal can be used in the as-welded condition; welded and precipitation-hardened condition; or welded, solution-treated, and precipitation-hardened condition.

应用 APPLICATIONS

常应用于近似材料的焊接，用于汽轮机转轮耐汽蚀、磨蚀部位的堆焊与补焊。

It is often used for welding materials with similar compositions, and for the surfacing and repair welding of cavitation-resistant and erosion-resistant parts of steam turbine rotors.

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	≤0.05	≤0.75	0.25-0.75	≤0.030	≤0.030	3.25-4.0	4.5-5.0	16.0-16.75	≤0.75
例值 Typical values	0.032	0.32	0.50	0.012	0.011	3.40	4.63	16.55	0.45

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 直条焊丝 Straight Stick Welding Wire