

SW·ER2594



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

江苏省溧阳市南渡镇金山路 2 号
Tel:05198089768 Fax:051980897358
SEWELD@163.COM
WWW.SEWELD.COM

执行标准 CLASSIFICATION

符合 GB/T 17853 S2594 相当 GB/T 17853 S2594 AWS A5.9 ER2594 ISO 14343-A-G 25 9 4 N L

产品特性 DESCRIPTION

焊丝是奥氏体-铁素体双相不锈钢，可全位置焊接。由于熔敷金属含有 40%左右的铁素体，所以熔敷金属兼有奥氏体不锈钢的综合性能和铁素体不锈钢的抗应力腐蚀特性，从而成为石化行业应用中一种新兴的材料。焊接作业性极佳——送丝顺畅、电弧稳定、成形美观、飞溅极少。

This welding wire is an austenitic-ferritic duplex stainless steel and suitable for all-position welding. Since the deposited metal contains approximately 40% ferrite, it combines the comprehensive properties of austenitic stainless steel and the stress corrosion resistance of ferritic stainless steel, thus becoming an emerging material in petrochemical industry applications. It exhibits excellent welding operability—with smooth wire feeding, stable arc, good weld appearance, and minimal spatter.

应用 APPLICATIONS

适用于 UNS S32750、S32760 双相不锈钢的焊接，广泛用于海水淡化、石油化工设备，纸浆漂白设备和海洋工程。含 CL 的反应釜、高温高压脱硫塔。It is suitable for welding duplex stainless steels of UNS S32750 and UNS S32760, and is widely used in seawater desalination, petrochemical equipment, pulp bleaching equipment, and marine engineering, as well as in chlorine-containing (Cl-containing) reaction kettles and high-temperature and high-pressure desulfurization towers.

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	V
GB/T Standard	≤0.030	≤1.0	≤2.50	≤0.030	≤0.020	≤1.50	8.0-10.5	24.0-27.0	2.5-4.5	-
例值 Typical values	0.021	0.56	2.10	0.011	0.009	0.15	9.75	25.6	3.25	-

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