

SW·ERNiCrMo-3



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T15620 SNI6625 相当 GB/T 15620 SNI6625 AWS A5.14 ERNiCrMo3 ISO 18274 SNI 6625

产品特性 DESCRIPTION

SW-ERNiCrMo-3 焊丝用于镍铬钼合金，特别是 UNS N06225 的焊接，也用于与钢的焊接和堆焊镍铬钼合金表面。焊缝金属的耐腐蚀性能与 N06625 相当。

SW-ERNiCrMo-3 welding wire is used for welding nickel-chromium-molybdenum alloys, particularly UNS N06225. It is also used for welding to steels and surfacing the surface of nickel-chromium-molybdenum alloys. The corrosion resistance of the weld metal is comparable to that of N06625.

应用 APPLICATIONS

主要用于镍铬钼合金的焊接，特别是 UNSN06625 类合金与其他钢种以及镍铬钼合金复合钢的焊接和堆焊，也可用于低温条件下的 Ni9%钢焊接。焊接金属与 UNSN06625 合金比较，具有抗腐蚀性能，焊缝金属可以在 540°C 条件下工作。

It is mainly used for welding nickel-chromium-molybdenum alloys, especially for the welding and surfacing of UNS N06625 class alloys with other steel grades as well as nickel-chromium-molybdenum alloy clad steels. It can also be used for welding Ni9% steels under low-temperature conditions. Compared with UNS N06625 alloy, the weld metal has corrosion resistance, and the weld metal can operate at a temperature of 540°C.

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	≤0.10	≤0.5	≤0.5	≤0.020	≤0.015	≤0.5	≥55	20.0-23.0	8.0-10.0
例值 Typical values	0.048	0.12	0.14	0.002	0.010	0.025	60	21.97	8.43

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