

SW·ERNiCrMo-4



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T 15620 SNi6276 相当 GB/T 15620 SNi6276 AWS A5.14 ERNiCrMo4 ISO 18274 SNi 6276

产品特性 DESCRIPTION

SW-ERNiCrMo-4 焊丝是镍基合金用焊丝。焊缝具有优良的塑性、韧性、抗裂性和优良的耐蚀能力。

SW-ERNiCrMo-4 welding wire is a type of welding wire for nickel-based alloys. Its welds possess excellent plasticity, toughness, crack resistance, and superior corrosion resistance.

应用 APPLICATIONS

SW-ERNiCrMo-4 焊丝用于镍铬钼合金（如 UNS N10276）的焊接，也用于低碳镍铬钼合金复合钢面、低碳镍铬钼合金与钢以及其他镍基合金的焊接。

SW-ERNiCrMo-4 welding wire is used for welding nickel-chromium-molybdenum alloys (such as UNS N10276). It is also used for welding the cladding of low-carbon nickel-chromium-molybdenum alloy clad steels, as well as for welding low-carbon nickel-chromium-molybdenum alloys to steels and other nickel-based alloys.

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	≤0.02	≤0.08	≤1.0	≤0.020	≤0.015	≤0.5	≥50.0	14.5-16.5	15.0-17.0	≤0.35
例值 Typical values	0.008	0.05	0.35	0.005	0.002	0.03	56.8	15.9	16.55	-

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