

SW·ERNiCrMo-10



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T15620 SNi6022 相当 GB/T 15620 SNi6022 AWS A5.14 ERNiCrMo10 ISO 18274 SNi 6022

产品特性 DESCRIPTION

SW-ERNiCrMo-10 焊丝的焊缝具有优良的抗裂性能和高温性能，再许多腐蚀环境条件下具有很好的耐蚀性能，特别耐点蚀和缝隙腐蚀性能。

The welds of SW-ERNiCrMo-10 welding wire exhibit excellent crack resistance and high-temperature performance, and possess good corrosion resistance under many corrosive environmental conditions, particularly in terms of pitting corrosion resistance and crevice corrosion resistance.

应用 APPLICATIONS

SW-ERNiCrMo-10 适用于 N0622 等镍铬钼系合金焊接，也可以用于钢与镍基合金的异种焊接及钢的表面堆焊。

SW-ERNiCrMo-10 is suitable for the welding of nickel-chromium-molybdenum alloys such as N0622. It can also be used for the dissimilar welding between steel and nickel-based alloys, as well as the surfacing welding on steel surfaces.

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	Fe	W	Cu	Ni	Cr	V	Mo
GB/T Standard	≤0.01	≤0.1	≤0.5	2.0-6.0	2.5-3.5	≤0.5	≥49	20-22.5	≤0.30	12.5-14.5
例值 Typical values	0.009	0.05	0.18	2.61	3.2	0.015	57.7	21.8	0.01	13.6

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