

SW·ERNiCrMo-13



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T 15620 SNi6059 相当 GB/T 15620 SNi6059 AWS A5.14 ERNiCrMo13 ISO 18274 SNi 6059

产品特性 DESCRIPTION

该类别填充金属的标称成分 (W%) 为 59 Ni、23 Cr、16 Mo、1 Fe 和低碳, 可使用 GTAW、GMAW、SAW 和 PAW 工艺的焊接熔覆。

The nominal composition (in weight percent) of this category of filler metals is 59% Ni, 23% Cr, 16% Mo, 1% Fe, and low carbon. They can be used for weld cladding via GTAW, GMAW, SAW, and PAW processes.

应用 APPLICATIONS

可用于焊接处理 混合酸介质 的设备, 如同时接触硝酸 (氧化性) 与盐酸 (还原性) 的反应釜、酸洗槽, 以及生产农药、染料的耐腐蚀管道。

It can be used for welding equipment that handles mixed acid media, such as reaction kettles and pickling tanks that come into contact with both nitric acid (oxidizing) and hydrochloric acid (reducing), as well as corrosion-resistant pipelines for pesticide and dye production.

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	Mo	AL	Cu	Ni	Cr
GB/T Standard	≤0.01	≤0.1	≤0.5	15.0-16.5	0.1-0.4	≤0.5	≥56	22-24
例值 Typical values	0.005	0.05	0.12	15.7	0.23	0.02	56.8	22.8

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