

SW·ERNiCrMo-15



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T 15620 SNI7725 相当 GB/T 15620 SNI7725 AWS A5.14 ERNiCrMo15 ISO 18274 SNI 7725

产品特性 DESCRIPTION

SW-ERNiCrMo-15 焊丝用于高强度耐腐蚀镍合金，特别是 UNS N7725 和 UNS N09925 的焊接，也用于与钢的焊接和高强度镍铬钼合金表面堆焊。强度达到最大值是，焊后需要进行沉淀淬火，可进行各种热处理。

SW-ERNiCrMo-15 welding wire is used for welding high-strength corrosion-resistant nickel alloys, particularly UNS N7725 and UNS N09925. It is also used for welding to steels and surfacing the surface of high-strength nickel-chromium-molybdenum alloys. When maximum strength is required, post-weld precipitation hardening is necessary, and various heat treatments can be performed.

应用 APPLICATIONS

用于焊接处理强腐蚀性介质的设备，如接触硫酸、盐酸、磷酸、醋酸等强酸的反应釜、换热器、储罐及管道。

It is used for welding equipment that handles highly corrosive media, such as reaction kettles, heat exchangers, storage tanks and pipelines that come into contact with strong acids like sulfuric acid, hydrochloric acid, phosphoric acid and acetic acid.

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	Fe	Nb	Ni	Cr	Ti	AL
GB/T Standard	≤0.030	≤0.20	≤0.4	7.0-9.5	≥8.0	2.75-4.00	55.0-59.0	19.0-22.5	1.0-1.7	≤0.35
例值 Typical values	0.008	0.03	0.12	7.8	8.9	3.11	56.74	19.84	1.23	0.02

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