

SW·ERNiFeCr-1



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T 15620 SNI8065 相当 GB/T 15620 SNI8065 AWS A5.14 ERNiFeCr1 ISO 18274 SNI 8065

产品特性 DESCRIPTION

SW-ERNiFeCr-1 焊丝用于镍铬钼铜合金 (如 UNS N08904)、镍铬钼铁合金 (如 UNS N08825) 的焊接。也可用于钢材表面堆焊和隔离层堆焊。

SW-ERNiFeCr-1 welding wire is used for welding nickel-chromium-molybdenum-copper alloys (such as UNS N08904) and nickel-chromium-molybdenum-iron alloys (such as UNS N08825). It can also be used for surfacing on the surface of steels and surfacing of isolation layers.

应用 APPLICATIONS

主要用于焊接镍 - 铁 - 铬系合金 (如 Alloy 825、Alloy 925 等) 以及异种钢焊接, 尤其在高温、腐蚀环境下表现优异。

It is mainly used for welding nickel-iron-chromium series alloys (such as Alloy 825, Alloy 925, etc.) as well as dissimilar steel welding, and performs excellently especially in high-temperature and corrosive environments.

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	AL	Ti	Cu	Ni	Cr	Mo	Fe
GB/T Standard	≤0.05	≤0.5	≤1.0	≤0.2	0.6-1.2	1.5-3.0	38.0-46.0	19.5-23.5	2.5-3.5	≥22.0
例值 Typical values	0.011	0.23	0.22	0.005	0.78	1.85	42.1	19.8	2.65	23.1

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