

SW·ERNiFeCr-2



镍 基 实 心 焊 丝
Nickel-based solid wire

江苏省溧阳市南渡镇金山路 2 号
Tel: 05198089768 Fax: 051980897358
SEWELD@163.COM
WWW.SEWELD.COM

执行标准 CLASSIFICATION

符合 GB/T 15620 SNI7718 相当 GB/T 15620 SNI7718 AWS A5.14 ERNiFeCr2 ISO 18274 SNI 7718

产品特性 DESCRIPTION

SW-ERNiFeCr-2 焊丝用于镍铬铌钼（如 UNS N07718）合金的焊接。采用钨极惰性气体保护焊、金属熔化极气体保护焊和等离子弧焊等焊接方法。焊缝金属采用时效强化处理。

SW-ERNiFeCr-2 welding wire is used for welding nickel-chromium-niobium-molybdenum alloys (such as UNS N07718). Welding methods including Gas Tungsten Arc Welding (GTAW), Gas Metal Arc Welding (GMAW) and Plasma Arc Welding (PAW) are adopted for this purpose. The weld metal undergoes age hardening treatment.

应用 APPLICATIONS

用于焊接处理 还原性酸性介质 的设备，如接触磷酸、有机酸（如柠檬酸）的反应釜、换热器及管道，可抵御介质的腐蚀并保持结构稳定性。适用于合成氨、甲醇等化工装置中高温高压管道的焊接，能在 400-600°C 环境下承受一定的工作应力。

It is used for welding equipment that handles reducing acidic media, such as reaction kettles, heat exchangers and pipelines in contact with phosphoric acid and organic acids (e.g., citric acid), and can resist medium corrosion while maintaining structural stability. It is suitable for welding high-temperature and high-pressure pipelines in chemical plants such as ammonia synthesis and methanol production, and can withstand a certain level of working stress in an environment of 400-600°C.

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	Fe	Cu	Ni	Cr	Mo	AL
GB/T Standard	≤0.08	≤0.35	≤0.35	≤0.015	≤24	≤0.30	50.0-55.0	17.0-21.0	2.8-3.3	0.7-1.1
例值 Typical values	0.003	0.095	0.095	0.011	23.9	0.005	52.3	18.2	2.94	0.81

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