

SW·ERNiCrCoMo-1



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T15620 SNI6617 相当 GB/T 15620 SNI6617AWSA5.14 ERNiCrCoMo1 ISO 18274 SNI 6617

产品特性 DESCRIPTION

SW-ERNiCrCoMo-1 焊丝用于低碳镍钴铬钼合金 (如 UNS N06617) 的焊接和钢表面堆焊。也可用于异种高温合金 (1150℃左右时具有高温强度和抗氧化性能) 和铸造高镍合金的焊接。

SW-ERNiCrCoMo-1 welding wire is used for welding low-carbon nickel-cobalt-chromium-molybdenum alloys (such as UNS N06617) and surfacing on the surface of steels. It can also be used for welding dissimilar high-temperature alloys (which have high-temperature strength and oxidation resistance at approximately 1150℃) and cast high-nickel alloys.

应用 APPLICATIONS

用于焊接处理 含氟、含氯的高温酸性介质 设备, 如氟化工反应釜、氯碱工业的电解槽及相关管道, 可耐受氟离子、氯离子的强腐蚀。

It is used for welding equipment that handles high-temperature acidic media containing fluorine and chlorine, such as fluorochemical reaction kettles, electrolyzers in the chlor-alkali industry and related pipelines, and can withstand the strong corrosion of fluoride ions and chloride ions.

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	Co	Cu	Ni	Cr	Mo	AL
GB/T Standard	0.05-0.15	≤1.0	≤1.0	≤0.030	10.0-15.0	≤0.5	≥44	20.0-24.0	8.0-10.0	0.8-1.5
例值 Typical values	0.065	0.084	0.19	0.008	11.9	0.008	53.48	21.7	9.52	0.84

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