

SW·ERNiCr-3



镍 基 实 心 焊 丝
Nickel-based solid wire

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执行标准 CLASSIFICATION

符合 GB/T15620 SNI6082 相当 GB/T 15620 SNI6082 AWS A5.14 ERNiCr3 ISO 18274 SNI 6082

产品特性 DESCRIPTION

SW-ERNiCr-3 焊丝用于镍铬合金（如 UNS N06075、N07080、N08800、N08801）的焊接。也可用于镀层与异种金属接头的焊接和低温条件下镍钢的焊接。

SW-ERNiCr-3 welding wire is used for welding nickel-chromium alloys (such as UNS N06075, N07080, N08800, and N08801). It can also be used for welding joints between coatings and dissimilar metals, as well as for welding nickel steels under low-temperature conditions.

应用 APPLICATIONS

SW-ERNiCr-3 主要用于钢的表面的堆焊，也用于镍铬合金自身的焊接及钢与镍基合金的焊接。

SW-ERNiCr-3 is mainly used for the surfacing welding of steel surfaces, and is also applied to the welding of nickel-chromium alloys themselves as well as the welding between steel and nickel-based alloys.

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	Nb	Cu	Ni	Cr	Ti	Fe
GB/T Standard	≤0.1	≤0.5	2.5-3.5	≤0.020	2.0-3.0	≤0.5	≥67	18-22	≤0.7	≤3.0
例值 Typical values	0.038	0.14	3.4	0.003	2.5	0.082	70.28	21	0.40	0.79

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