

SW·ERNi-1



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 SNi2061 相当 GB/T 15620 SNi2061 AWS A5.14 ERNi1 ISO 18274 SNi 2061

产品特性 DESCRIPTION

SW-ERNi-1 焊丝焊缝具有良好的抗裂性能, 优良的耐腐蚀性能, 特别是耐碱腐蚀性能。

The weld of SW-ERNi-1 welding wire exhibits excellent crack resistance and superior corrosion resistance, particularly in terms of alkali corrosion resistance.

应用 APPLICATIONS

SW-ERNi-1 焊丝用于工业纯镍的锻件和铸件焊接, 如 UNS N02200 或 UNS N02201, 也可用于焊接镍板复合钢和钢表面堆焊以及异种金属焊接。

The SW-ERNi-1 welding wire is used for welding forgings and castings of commercial pure nickel, such as UNS N02200 or UNS N02201. It can also be applied to the welding of nickel-clad steel, surfacing on steel surfaces, and the welding of dissimilar metals.

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	Fe	Cu	Ni	Ti	S	P
GB/T Standard	≤0.15	≤0.7	≤1.0	≤1.5	≤1.0	≤0.2	≥92	2.0-3.5	≤0.015	≤0.020
例值 Typical values	0.005	0.3	0.47	0.6	0.098	0.014	93.9	2.38	0.002	0.003

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