

百祥焊材

BEST STRONG WELDING



清苑县百祥货物进出口有限公司

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公司简介

Brief Introduction

百祥公司是专业经营焊材，集科工贸为一体的外向型高新技术企业。经过多年的努力已成为技术力量雄厚，先进的制造工艺的研究生产单位。

公司主要产品为碳钢，不锈钢，低合金钢，堆焊，耐热钢，低温钢及其他特种用途的各种型号焊条，和气体保护焊丝，药芯焊丝，埋弧焊丝，氩弧焊丝等各种型号焊丝。目前已成功研发不同型号的焊材400余种，同时可根据用户要求完成开发，研制，生产任务。

我们以“优秀的产品品质，良好的企业信誉，便捷的商业服务”的优势，这些年为机械，建筑，冶金，桥梁，船舶，石油化工，压力容器等行业的广大用户提供了大量的产品及服务，产品畅销二十多个国家和地区，取得了国内外客商的一致好评。

诚挚欢迎新老客户携手合作，共同发展。

Best Strong Corporation is a export-oriented high-tech enterprise which is engaged in welding material industry with integration of R&D, manufacturing and trade together. After years of effort we become a professional research-production unit with strong technical strength and advanced producing skill.

Our product mainly include welding electrode for carbon steel, stainless steel, low alloyed steel, surfacing, heat-resistant, low temperature application, and various kind of welding wire such as gas-shielded wire, flux-cored wire, submerged arc wire, argon arc wire etc. The product covers 400 varied types, meanwhile we can also develop and produce new special welding material according to customers' requirement.

With our advantages "Outstanding product quality, Good enterprise reputation, Convenient business service", during this years we supplied large amount of welding materials for customers in industry of Machinery, building, metallurgy, bridge, ships, Petroleum & Chemical, Pressure Vessel etc. Our product is popular in more than 20 countries and regions and wins customers' approval and trust.

Sincerely welcome customers cooperate with us and gain mutual development in the future.

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Carbon Steel Welding Electrode				
TYPE	CLASSIFICATION			
	AWS	GB	JIS	DIN
Rutile	A5.1 E6013	J421	D4313	E4332 R3
	E6012			
	E7014	J501Fe		E4321AR11120
		J422	D4303	
Low Hydrogen	A5.1 E7018	J506Fe	D5016	E5154B(R)10
	E7016	J506	D5016	E5143 1310
	E7015	J507		E5155 1310
	E6015	J427		
	E6016	J426	D4316	E4343B10
	E6018	J426Fe		
Cellulosic Pipeliner	A5.1 E6011	J425	D4311	
	E6010	J421X	D4313	E4343C4
	E6013	J421X		
	E7011	J505		
	E7010			
Iron Powder	A5.1 E6024	J421Fe16		
	E7024	J501Fe16		E5142RR11160
	E7028	J507Fe16		E5155B(R)2160
	E7027			
	E6027	J424Fe16	D4327	E4354AR11160

Low Alloy Steel Welding Electrode				
TYPE	CLASSIFICATION			
	AWS	GB	JIS	DIN
500MPa Grade	A5.5 E7015-G	J507CrNi	D4313	E4332 R3
	E7016-G	J506RH		
	E7010-G	J505G		
	E7018-G	J508Ni		E46 6 Mn1Ni B 32H 5
	E7010-A1	J505Mo		
	E7018-A1 H4R			
550MPa Grade	A5.5 E8015-G	J557	D5316	EY5066NiMoBH5
	E8016-G	J556		
	E8018-G	J558		
	E8018-C3			
600MPa Grade	A5.5 E9015-G	J607RH		
	E9016-G	J606RH		
	E9018-G			
700MPa Grade	A5.5 E10015-G			
	E11018-G			E5142RR11160
	E12015-G			E5155B(R)2160
	E12018-G			

Heat Resistant Welding Electrode				
TYPE	CLASSIFICATION			
	AWS	GB	JIS	DIN
Heat Resistant	A5.5 E7015-A1	R107	DT1216	EMoB10+
	E7018-A1	R108		
	E8015-B1	R207		
	E8015-B2	R307	DT2315	ECrMo1B10+
	E9015-B3	R407	DT2415	ECrMo2B10+

BEST STRONG WELDING

Stainless Steel Welding Electrode						
TYPE	CLASSIFICATION					
	AWS	GB	JIS	DIN		
Titanium-Calcium Type AC/DC	A5.4	E308-16	A102	D308-16	E199R26	
		E309-16	A302	D309-16	E2312R26	
		E316-16	A202	D316	E19123R26	
		E310-16	A402	D310-16	E2520R26	
		E309Mo-16	A312	D309Mo-16	E2312R26	
		E347-16	A132	D347-16	E199NbR26	
		E310H-16				
		E308H-16				
		E410-16	G202	D410	E13B20+	
		E308L-16	A002	D308L	E199ncR23	
		E316L-16	A022	D316L	E19123ncR26	
		E309L-16	A062			
		E347L-16	A002Nb			
E309MoL-16	A042					
Low Hydrogen DC	A5.4	E308-15	A107		E199B26	
		E309-15	A307	D309-15	E2212B20+	
		E316-15	A207		E19123B20+	
		E310-15	A407	D310-15	E2520B26	
		E309Mo-15				
		E410-15	G207		E13B20+	
		E347-15	A137	D347-15	E199NbB26	

Hard Facing Welding Electrode					
TYPE	CLASSIFICATION				
	AWS	GB	JIS	CN MARK	
Low and Medium Alloy Steel		D102		EDPMn2-03	
		D107		EDPMn2-15	
		D112		EDPCrMo-A1-03	
		D172		EDPCrMo-A3-03	
		D207		EDPCrMnSi-15	
		D212		EDPCrMo-A4-03	
	High Cr-Mn Steel	EFeMn-A	D256	DF-MnA	EDMn-A-16
EFeMn-B		D266	DF-MnA	EDMn-B-16	
Alloyed Refractory Steel		D322		EDRCrMoWV-A1-15	
		D317		EDRCrMoWV-W3-15	
High Cr Steel	DE-ME	D276	DF-ME	EDCrMn-B-16	
Alloyed Cast Iron		D608		EDZ-A1-08	
Tungsten Carbide		D707		EDW-A-15	

Cast Iron Welding Electrode					
TYPE	CLASSIFICATION				
	AWS	GB	JIS	DIN	
Ni-Cored	A5.15	Eni-CI	Z308	DECNI	
		ENiFe-CI	Z408	DFCNIfe	
		ENiCu-B	Z508		

Low Temperature Welding Electrode					
TYPE	CLASSIFICATION				
	AWS	GB	JIS	CN MARK	
	E7015-G	W607		E5015-G	
		W707		E5015-G	

E6013

符合: GB E4313

相当: J421

碳钢焊条

Carbon Steel Welding Electrode

说明: J421是氧化钛药皮金红石钛白粉型的碳钢焊条, 交直流两用, 可进行全位置焊接, 操作性良好, 再引弧容易。

用途: 焊接低碳钢结构, 特别适用于薄板小件及短焊缝和要求表面光洁的盖面焊。

Description: J421 is a carbon steel rutile type welding electrode with Titanium oxide coating. It can weld in all position and can used AC/DC, along with the excellent welding performances such as stable arc and easy arc-restrike.

Application: Suitable welding of various kind of low carbon steel structures ,especially suitable applies to steel sheet,small parts,short joints as well as surface finish required welding etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	0.30-0.60	≤0.35	≤0.035	≤0.035

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥420	≥330	≥22	≥47
一般结果 Tested	490	400	27	60

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	55-95	90-140	140-200	190-240

E7018

符合: GB E5018

相当: J506Fe

低氢焊条

Low Hydrogen Welding Electrode

说明: J506Fe是铁粉低氢钾型药皮的碳钢焊条, 交直流两用, 可进行全位置焊接。其特点是药皮含有铁粉, 可减少焊接层数。

用途: 适用于碳钢及某些低合金钢的焊接, 如 16Mn 等。

Description: J506Fe is an iron powder low hydrogen potassium electrode. It is used on both AC and DC in all position. As the electrode coating contains iron powder, it can carry out efficiency welding and can reduce welding layers.

Application: Suitable welding carbon steel structures and certain low alloy structures, such as 16Mn etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	≤1.60	≤0.75	≤0.035	≤0.040

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥490	≥400	≥22	≥47
一般结果 Tested	520-580	460	24-30	50-180

融敷金属扩散氢含量: ≤8.0ml/100g (甘油法)

Hydrogen diffuse of weld metal: ≤8.0ml/100g (glyceric method)

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	90-120	120-150	170-200	210-250

E7015

符合: GB E5015

相当: J507

低氢焊条

Low Hydrogen Welding Electrode

说明: J507是低氢钠型药皮的碳钢焊条, 采用直流反接, 可进行全方位焊接, 具有良好的塑性、韧性及抗裂性能。

用途: 可焊接中碳钢和某些低合金钢, 如 09Mn2Si, 16Mn, 09Mn2V 等。

Description: J507 is a Low hydrogen sodium coated type carbon steel electrode, provides excellent welding performance such as good plasticity and toughness, as well as crack resistance. It can be weld in all position on DC reversed.

Application: Suitable for welding of medium carbon steel and certain types of low alloy steel, such as 16Mn, 09MnSi, 09Mn2V etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	≤1.60	≤0.75	≤0.035	≤0.035

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥490	≥400	≥22	≥27
一般结果 Tested	545	450	27	80

融敷金属扩散氢含量: ≤8.0ml / 100g (甘油法)

Hydrogen diffuse of weld metal : ≤8.0ml / 100g (glyceric method)

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	60-90	90-120	140-180	170-210

注意事项: 1. 焊接前焊条须经 350℃ 左右烘焙 1 小时, 随烘随用

2. 焊接前必须对焊件进行清楚铁锈, 油污, 水分等杂质的操作

3. 焊接时须用短弧操作, 以窄焊道为宜

Notes: 1. Electrodes must be baked for 1 hour at 350℃ before welding

2. Weld base must be cleaned up rusty, grease, water and other impurities before welding

3. suitable welding with short arc and bead weld operation

E6011

符合: GB E4311

相当: J425

纤维素型焊条

Cellulosic coated Welding Electrode

说明: J425是纤维素钾型药皮的立向下专用碳钢焊条, 交直流两用, 可进行全位置焊接, 具有焊接效率高, 立向下焊接成型美观, 电弧稳定等特点。

用途: 适用于薄板结构的对接, 角接及搭接焊, 特别适用于船体, 管道, 桥梁等结构。

Description: J425 is a cellulosic potassium coated welding electrode specialized in vertical down weld position. It can be used on AC/DC, along with the excellent welding performances such as stable arc and moulding beauty on vertical down application, high welding efficiency etc.

Application: Suitable butt / fillet / overlap welding of steel sheet, typically applies to pipelines, bridges, ship-building etc (Power station flue, air flue, tank of transformer for example)

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	0.30-0.60	≤0.30	≤0.035	≤0.035

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) 0℃
保证值 Guaranteed	≥420	≥330	≥22	≥27
一般结果 Tested	480-580	390	22-26	105

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	30-50	70-100	90-140	150-200

E7014

符合: GB E5014

相当: J501Fe

铁粉焊条

Iron Powder Welding Electrode

说明: J506Fe是铁粉氧化钛型药皮的碳钢焊条, 交直流两用, 融敷效率很好, 达 110% , 可进行全位置焊接。

用途: 适用于碳钢及某些低合金钢的焊接, 如 16Mn 等船舶, 车辆及机械结构。

Description: J501Fe is an iron powder Titanium oxide coated electrode. It is highly efficient deposited when welding because of iron powder contained in electrode coating.

Application: Suitable welding carbon steel structures and certain low alloy structures, such as 16Mn etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	≤1.25	≤0.90	≤0.035	≤0.040

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥490	≥400	≥17	≥27
一般结果 Tested	520-580	450	17-26	50-100

融敷金属扩散氢含量: ≤8.0ml/100g (甘油法)

Hydrogen diffuse of weld metal: ≤8.0ml/100g (glyceric method)

X射线探伤: I级 X-ray radiographic inspection: II grade

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	70-90	90-130	160-210	210-250

E308L-16

符合: AWS E308L-16

相当: A002

不锈钢焊条

Stainless Steel Welding Electrode

说明: A002是钛钙型药皮的超低碳 00Cr19Ni10不锈钢焊条,具有良好抗晶间腐蚀性能,可交直流两用,操作性极好。

用途: 用于焊接工作温度低于 300℃的耐腐蚀 0Cr18Ni9, 0Cr18Ni11Ti的不锈钢结构。

Description: A002 is a super low carbon 00Cr19Ni10 type stainless steel electrode with Titanium-calcium coating. It has good intergranular corrosion resistance performance.

Application: Suitable welding super low carbon stainless steel structures and 0Cr19Ni11Ti anti-corrosion stainless steel with working temperature below 300 °C, typically used for equipment manufacturing of fibre, fertilizer and petroleum industry.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	镍 (Ni)
≤0.04	0.5-2.5	≤0.90	18.0-21.0	9.0-11.0

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥520	--	≥35	--
一般结果 Tested	--	--	--	--

融敷耐腐蚀性能试验及铁素体含量有供需双方协议确定。

The anti-corrosion performance and ferrite composition should be determined by buyer and seller.

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	50-80	80-110	110-160	160-200

注意事项: 1. 焊接前焊条应经 150℃烘焙 1 小时
2. 尽可能的采用直流焊接, 同时电流不宜过大
3. 融敷金属耐腐蚀性能试验及铁素体含量由供需双方协商确定

Notes: 1. Electrodes must be baked for 1 hour at 150°C before welding operation
2. Works on DC with small welding current as possible
3. Anti-corrosion and ferrite composition should be determined by buyer and seller

E316L-16

符合: AWS E316L-16

相当: A022

不锈钢焊条

Stainless Steel Welding Electrode

说明: A022是钛钙型药皮的超低碳 Cr18Ni12Mo2不锈钢焊条, 具有良好耐热, 耐腐蚀及抗裂性能, 可交直流两用, 操作工艺性能良好。

用途: 用于焊接尿素、合成纤维等设备及其相同类型的不锈钢结构, 也可用于焊后不能进行热处理的铬不锈钢以及复合钢和异种钢等。

Description: A022 is a super low carbon Cr18Ni12Mo2 type stainless steel electrode with Titanium-calcium coating. It provides excellent performance of corrosion resistance, heat-resistance as well as crack resistance. It can work on both AC/DC.

Application: Used for welding equipment manufacturing carbamide, fibre and similar types of stainless steel structures, it can also be used for welding dissimilar steels and compound steels and chromium stainless steels that is not available for heat-treatment after welding.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	镍 (Ni)
≤0.04	0.5-2.5	≤0.90	17.0-20.0	11.0-14.0

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30°C
保证值 Guaranteed	≥490	--	≥30	--
一般结果 Tested	--	--	--	--

参考电流 Recommended Current:

焊条直径 (mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流 (A) Welding Current	50-80	80-110	110-160	160-200

注意事项: 1. 焊接前焊条应经 150°C 烘焙 1 小时
2. 尽可能的采用直流焊接, 同时电流不宜过大
3. 熔敷金属耐腐蚀性能试验及铁素体含量由供需双方协商确定

Notes: 1. Electrodes must be baked for 1 hour at 150°C before welding operation
2. Works on DC with small welding current as possible to avoid insufficient penetration by AC and electrode red-hot by large current.
3. Anti-corrosion and ferrite composition should be determined by buyer and seller

E308-16

符合: AWS E308-16
相当: A102

不锈钢焊条 Stainless Steel Welding Electrode

说明: A102 是钛钙型药皮的低碳 Cr19Ni10 不锈钢焊条, 具有良好的力学性能及抗晶间腐蚀性能, 可交直流两用, 操作性极好。

用途: 用于焊接工作温度低于 300°C 的耐腐蚀 0Cr18Ni9, 0Cr18Ni11Ti 的不锈钢结构。

Description: A102 is a low carbon Cr19Ni10 type stainless steel electrode with Titanium-calcium coating. It has good intergranular corrosion resistance performance

Application: Suitable welding of anti-corrosion stainless steel structures at working temperature below 300°C (typically 0Cr18Ni9, 0Cr18Ni11Ti).

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	镍 (Ni)
≤0.08	0.5-2.5	≤0.90	18.0-21.0	9.0-11.0

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30°C
保证值 Guaranteed	≥550	--	≥35	--
一般结果 Tested	--	--	--	--

融敷耐腐蚀性能试验及铁素体含量有供需双方协议确定。

The anti-corrosion performance and ferrite composition should be determined by buyer and seller.

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	50-80	80-110	110-160	160-200

注意事项: 1. 焊接前焊条应经 150°C 烘焙 1 小时
2. 尽可能的采用直流焊接, 因此可避免交流焊接时熔深较浅, 同时电流不宜过大

Notes: 1. Electrodes must be baked for 1 hour at 150°C before welding operation
2. Operate on DC as possible to avoid insufficient penetration, meanwhile welding Current should be proper low so that electrode won't red-hot.

符合: GB EZNi-1

相当: ENi-CI

铸铁焊条

Cast Iron Welding Electrode

说明: Z308是纯镍焊芯石墨型药皮的铸铁电焊条。该焊条可交直流两用,具有焊接电弧稳定,熔渣覆盖均匀,焊缝成型美观,细小熔滴过渡等良好的操作工艺性能。

用途: 用于重要灰口铸铁薄板件及加工面焊补,如汽缸盖,发动机座,齿轮箱及机床轨等。

Description: Z308 is pure-nickel cored graphite type coated cast iron electrode. It can use AC/DC. It has good welding tech performance such as stable arc, slag uniform, small droplet transfer, weld seam moulding beauty etc.

Application: Suitable welding of important grey iron parts and repair welding for machining surface, such as cylinder cover, engine bearer, gear case and machine rail etc.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	镍 (Ni)	铁 (Fe)
≤2.00	≤1.00	≤2.50	≥90.0	≤8.0

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	60-90	90-110	120-150	150-180

- 注意事项:**
1. 可以通过锤击焊缝消除焊补区应力,避免裂纹发生
 2. 铸铁冷焊应避免使用大电流焊接,以减少母材中杂质元素渗入焊缝并缩小白口区宽度,提高焊缝抗裂性能和机加工能力。
 3. 施焊前焊条须经 80℃-120℃ 烘焙 1 小时

- Notes:**
1. Hammering on welding seam to wipe off the stress in soldering area, so can prevent crack happening.
 2. Large current is prohibited in cast iron cold welding, in order to reduce impurities in base metal and lessen the width of weld heat-affected zone, then enhance crack resistance performance and improve machining ability.
 3. Welding rods should be baked at 80℃ - 120℃ for 1 hour before the operation

Z408

符合: GB EZNiFe-1

相当: ENiFe-CI

铸铁焊条

Cast Iron Welding Electrode

说明: Z408是镍铁合金焊芯强还原性石墨型药皮的铸铁电焊条。具有焊接强度高, 塑性好, 线性膨胀系数低, 熔渣覆盖优良, 焊缝成型美观等特点。

用途: 用于重要高强度灰口铸铁及球墨铸铁件, 如汽缸, 发动机座, 齿轮箱等

Description: Z408 is Ferro-Nickel alloy cored ,strong reducible type graphite coated cast iron electrode.It has good welding performance such as high strength ,low linear expansion coefficient, slag uniform ,small droplet transfer,weld seam moulding beauty etc.

Application: Suitable for important high strength grey iron parts and nodular cast iron, such as cylinder cover, engine bearer, gear case etc.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	镍 (Ni)	铁 (Fe)
≤2.00	≤1.80	≤2.50	45.0-60.0	Rest

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	50-80	80-100	110-140	150-180

注意事项: 1. 施焊前焊条须经 150℃ 烘焙 1 小时

2. 尽可能采用小电流施焊

Notes 1. Welding rods should be baked at 150℃ for 1 hour before welding operation

2. Use small welding current as possible

Z508

符合: GB EZNiCu-1

相当: ENiCu-B

铸铁焊条

Cast Iron Welding Electrode

说明: Z508是镍铜合金(蒙乃尔)焊芯强还原性石墨型药皮的铸铁电焊条。其工艺性及切削性能接近于Z308;同时由于收缩率较大,抗裂性能较差,焊接接头强度较低,故不宜用于受力部位的焊接,但可用于常温或低温预热(300℃左右)的灰口铸铁的焊接。此焊条交直流两用,电弧稳定,操作方便。

用途: 用于强度要求不高的灰口铸铁件的焊补

Description: Z508 is a Nickel-Copper alloy cored(Monel), strong reducible type graphite coated cast iron electrode. Its processing performance and machining performance is close to Z308. It is not suitable for welding stress areas due to its high contractibility rate, lower strength of welding joint, less crack resistance, but can weld grey cast iron at normal temperature and low temperature preheating (at 300℃ or so), it works on DC/AC with stable arc and handy usage.

Application: Use for soldering grey cast iron parts which requires less strength.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	镍 (Ni)	铜 (Cu)
≤1.00	≤2.50	≤0.80	60.0-70.0	24.0-35.0

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	50-80	90-110	120-150	160-190

注意事项: 1. 施焊前焊条须经150℃烘焙1小时
2. 焊接时以窄焊道为宜,每次焊缝长度不超过50毫米,焊后立即用小锤锤击焊缝处以消除焊补区应力,防止裂缝产生。

Notes 1. Welding rods should be baked at 150℃ for 1 hour before welding operation
2. Narrow weld pass with its length no more than 50mm is advisable when welding, after welding immediately hammer on welding seam to wipe off the stress in soldering area and prevent crack

阀门堆焊焊条

Valve Surfacing Welding Electrode

说明: D507是低氢钠型药皮的 1Cr13型阀门堆焊焊条。堆焊金属为 1Cr13 半铁素体高铬钢,堆焊层具有空淬特性,一般不需要热处理。硬度均匀,可在 750℃-800℃退火软化。当加热到900℃-1000℃空冷或油淬后可重新硬化,焊接电流采用直流反接

用途: 通用型的表面堆焊用焊条,用于堆焊工作温度在 450℃以下的碳钢或合金钢的轴及阀门等。

Description: D507 is Low-hydrogen sodium coated 1Cr13 type valve surfacing electrode. Surfacing metal is semi-ferrite high Chromium steel and has air-quenched property, its hardness is uniform and no need for heat treatment. It can be annealed soften between 750℃-800℃, and can be hardened afresh after air/oil cooling from 900℃-1000℃

Application: This is a universal type surface overlaying type electrode, it widely used for shaft and valve which can be welded under overlaying work temperature below 450℃.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	铬 (Cr)	钼 (Mo)
≤0.15	10.0-16.0	--

堆焊层硬度: HRC≥40

Hardness of Surfacing weld layer: HRC≥40

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	70-100	80-120	120-160	160-200

注意事项: 1. 焊接前焊条须经 250℃左右烘焙 1 小时
2. 焊前须将工件预热至 300℃以上,焊后进行不同的热处理可获得相应的硬度

Notes: 1. Electrodes must be baked for 1 hour at 250℃ before welding
2. Preheat metal base up to 300℃ before welding, after welding it can get certain hardness by corresponding heat treatment.

符合: GB EDZ-AI-08

堆焊焊条
Surfacing Welding Electrode

说明: D608是石墨型药皮的铬钼铸铁堆焊焊条。可交直流两用,但采用直流电源更为适宜,由于堆焊金属为铸铁组织的铬、钼碳化物,因此堆焊层具有较高的硬度和耐磨性,对泥沙及矿石的磨耗有良好的抵抗能力

用途: 可用于农业机械,矿山设备等承受砂粒磨损与轻微冲击的零件。

Description: D608 is chrome-molybdenum cast iron type electrode with tungsten coating for deposited welding. It can be operated on AC/DC, but better on DC. Because of chrome-molybdenum carbide in deposit metal, surfacing layer can have more hardness and anti-abrasion ability. It has excellent anti-abrasion ability to sand and ore.

Application: Suitable welding of anti-abrasion welding parts of agriculture and mining machinery etc.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	铬 (Cr)	钼 (Mo)
2.50-4.50	3.00-5.00	3.00-5.00

堆焊层硬度: HRC \geq 55

Hardness of Surfacing weld layer: HRC \geq 55

参考电流 Recommended Current:

焊条直径(mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊条电流(A) Welding Current	60-90	90-120	140-180	170-210

- 注意事项:**
1. 焊接前焊条须经 250℃ 左右烘焙 1 小时, 随烘随用
 2. 焊接时焊件预热至 400℃-500℃, 或先用 J507 低氢焊条堆焊一层再趁热堆焊, 焊后缓冷
 3. 堆焊层不能进行切削加工, 只能磨加工

- Notes:**
1. Electrodes must be baked for 1 hour at 250℃ before welding
 2. Preheat metal base up to 400-500℃ when welding, or pre-deposited welding with J507 low hydrogen electrode then surfacing weld during high temperature and cool down slowly.
 3. hardfacing metal layer is not available for machining, only can be grinding.

E8015-G

符合: GB E5515-G

相当: J557

低合金钢焊条

Low Alloy Steel Welding Electrodes

说明: J557 是低氢钠型药皮的低合金钢焊条。采用直流反接, 可进行全位置焊接。

用途: 适用于中碳钢和 15MnTi 15MnV 等低合金钢结构的焊接。

Description: J557 is a low alloy steel type electrode with low hydrogen sodium coating, it is used DECP in all position,

Application: For welding medium-carbon steel structures and various low alloy steel structures such as 15MnTi 15MnV etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	≥1.00	0.30-0.80	≤0.035	≤0.035

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥540	≥440	≥17	≥27
一般结果 Tested	628	505	27	40

X 射线探伤: I 级 X-ray radiographic inspection: I grade

参考电流 Recommended current:

焊条直径 (mm) Weld rod diameter	2.0	2.5	3.2	4.0	5.0
焊接电流(A) Welding Current	50-80	60-90	80-110	130-170	160-200

E7015-G

符合: GB E5015-G

相当: J507CrNi

低合金钢焊条

Low Alloy Steel Welding Electrodes

说明: J507CrNi是低氢钾型药皮耐海水腐蚀的低合金钢焊条。采用直流反接, 可进行全位置焊接。具有良好的塑性、低温韧性和耐海水腐蚀的性能。

用途: 适用于 Q235、16Mn 和铬铝系统等耐海水腐蚀用钢的海洋重要结构的焊接。

Description: J507CrNi is a low alloy steel type electrode with low hydrogen potassium coating, it is used DECP in all position, provides excellent plasticity, low temperature toughness and seawater corrosion resistance.

Application: For welding various important seawater corrosion resistance steel structures such as Q235, 16Mn and Chromium-Aluminium System etc.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	镍 (Ni)
≤0.10	0.50-0.80	0.30-0.50	0.30-0.50	0.20-0.50

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30°C
保证值 Guaranteed	≥490	≥390	≥22	≥27
一般结果 Tested	540	455	29	42

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended current:

焊条直径 (mm) Weld rod diameter	2.5	3.2	4.0	5.0
焊接电流(A) Welding Current	70-90	90-120	140-180	170-210

BEST STRONG WELDING

MIG/MAG Welding Wire					
TYPE	CLASSIFICATION				
	AWS	GB	JIS	DIN / EN / CN BRAND	
Mild Steel	A5.18	ER70S-6	ER50-6	YGW12	8995 SG2
		ER70S-3	ER50-3	YGW16	
		ER70S-2	ER50-2		
		ER70S-G	ER50-G	YGW11	
		ER49-1	ER49-1		8995 SG3
Low Alloyed Steel	A5.28	ER80S-D2			G4Mo
		ER80S-G			G2Mo
		ER80S-Ni2			G2Ni2
		ER80S-B2		Z3316 YG1CM	
		ER90S-G			G CrMo2Si
		ER90S-B3			
		ER100S-G			G Mn3NiCrMo
	ER110S-G			G Mn3Ni1CrMo	
Stainless Steel	A5.9	ER308L			
		ER308LSi			
		ER309L			
		ER309LSi			
		ER316L			
		ER316LSi			
		ER347Si			
Weather Resistant					H08MnSiCuCrNi H08NiCuMnSi

Submerged Arc Welding Wire					
TYPE	CLASSIFICATION				
	AWS	GB	JIS	DIN / EN / CN BRAND	
Mild Steel	A5.17	EL12	H08A		EN 756 S1
		EM12	H08MnA		EN 756 S2
		EM13K	H10MnSi		
		EH14	H10Mn2	W41	
		EM12K			EN 756 S2Si
Low Alloyed Steel	A5.23	EA2	H08MnMoA		EN 756 S2 Mo
		EA3			EN 756 S4 Mo
		EA4			EN 756 S3 Mo
		EG			EN 756 SZ
		EB2R			EN 756 CrMo1
		EB3R			EN 756 CrMo2
		EF3	H10Mn2NiMoA		
	ENi3			EN 756 S2Ni3	
Stainless Steel	A5.9	ER308			
		ER308L			
		ER309			
		ER309L			
		ER316			
		ER316L			
	ER347				
Heat Resistant		EB2	H13CrMoA H08CrMoVA		

Flux Cored Welding Wire				
TYPE	CLASSIFICATION			
	AWS	GB	JIS	DIN / EN /CN BRAND
Mild Steel	A5.20 E71T-1	YJ502(Q)	YFW-C50DR	
	E71T-9			
	E71T-GS			
	E71T-11			
	E70T-9			
	E70T-1		YFW-C50DM	
Low Alloyed Steel	E70T-5	YJ507(Q)		
	A5.29 E81T1-Ni1	YJ602(Q)		
	E90T-5	YJ607(Q)		
	E100T5	YJ707(Q)		
	E70C-G			
	E80T-G		Z3316 YG1CM	
Stainless Steel	E111T1-K3M			
	A5.22 E308LT0-1	YA308L(Q)		
	E308LT1-1			
	E316LT0-1	YA316L(Q)		
	E316LT1-1			
	E309LT0-1	YA309L(Q)		
Heat Resistant	E309LT1-1			
	E309LMoT1-1			
Low Temperature	A5.29 E91T1-B3			
	E81T1-B2			
SAW Surfacing	A5.29 E81T1-Ni1			
	E91T1-K2			
		M113		
		Z413		

TIG Welding Wire				
TYPE	CLASSIFICATION			
	AWS	GB	JIS	DIN / EN /CN BRAND
Mild Steel	A5.18 ER70S-6	ER50-6		
	ER70S-3	ER50-3		
	ER70S-2	ER50-2		
	ER70S-G	ER50-G		
	ER49-1	ER49-1		
Low Alloyed Steel	A5.28 ER80S-G			
	ER80S-B2			
	ER90S-G			
	ER100S-G			
Stainless Steel	A5.9 ER308L			
	ER308LSi			
	ER309L			
	ER309LSi			
	ER316L			
	ER316LSi			
	ER347Si			

ER70S-6

符合：GB ER50-6

相当：JISYGW12/ DIN SG2

气体保护焊丝

Gas-Shielded Welding Wire

说明：ER50-6是低碳钢实心焊丝，可采用二氧化碳或富氩气体进行单道及多道焊接，具有融敷效率高，电弧稳定，飞溅小，焊缝成型美观，可全位置施焊等工艺性能。

用途：适用于碳钢及 500MPa 级低合金的单道及多道焊接（如车辆、桥梁、建筑、造船，压力容器，管道钢结构的焊接。

Description: ER50-6 is a carbon steel type solid MIG wire copper coating ,with single-pass /multipass GMAW/MIG welding process,provides high fusion efficiency ; stable electric arc with good melting speed and less splash.

Application: Welding of carbon steel , low alloy steel & 500MPa grade low alloy high intensity steel structures etc.such as vehicle , building ; bridge , ship-building , pressure vessel industry , pipeline etc.

熔敷金属化学成分（%） Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
0.06-0.15	1.40-1.85	0.80-1.15	≤0.035	≤0.025

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥490	≥400	≥22	≥27
一般结果 Tested	569	457	27	40

X射线探伤：I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas : CO₂: 75%-95% Ar + Rest CO₂ at the speed 20-25 liter per minute

ER70S-G

符合: GB ER50-G

相当: JISYGW11

管线钢用气体保护焊丝

Pipeliners Gas Shielded MIG Welding Wire

说明: ER50-G是Si-Mn-Ti系气体保护实心焊丝。钛元素可加强晶粒细化从而使焊接电弧稳定飞溅很小,焊缝成型好,有着良好抗气孔,流动性与抗裂性优异等性能。

用途: 适用于 500Mpa 级一般碳钢和低合金钢的焊接,尤其是薄板焊接和高速焊接。

Description: ER50-G is a Si-Mn-Ti system solid gas shielded MIG wire. bringing in Titanium enhances grain refinement of deposited metal, provides good melting speed and stable arc, less splash, weld forming good, good weld liquidity and anti-crack etc

Application: Welding of carbon steel, low alloy steel with 500MPa grade structures, especially suitable for steel sheet welding and high speed welding.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	钛 (Ti)	铜 (Cu)
0.07-0.11	1.40-1.80	0.50-0.80	0.12-0.25	≤0.50

--熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥500	≥440	≥22	≥27
一般结果 Tested	593	520	26	41

X射线探伤: I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas: 80% Ar + 20% CO₂ or totally CO₂ with 20 L/min gas flow

ER80S-G

符合: GB/T ER55-G
相当: AWS A5.28 ER80S-G

低合金钢气体保护焊丝 Low Alloy Steel Gas Shielded Welding Wire

说明: ER80S-G是低合金钢气体保护焊丝,具有融敷效率高,焊接速度快,焊弧稳定飞溅小,抗蠕变性能良好等优良的焊接性能。

用途: 用于 550Mpa-600Mpa强度级别的高钢结构焊接。例如桥梁,压力容器,锅炉等。

Description: ER80S-G is a low alloyed steel gas shielded welding wire.it has good welding performance e.g.good melting efficiency,high welding speed,stable arc with little splatter,good creep resistance etc.

Application: welding of 500Mpa-600Mpa grade high tensile steel structures,such as bridges,pressure vessel,boiler etc.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	钼 (Mo)	铬 (Cr)
0.06-0.14	1.00-1.60	0.50-0.90	0.45-0.65	0.90-1.50

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	550-690	≥500	≥20	≥27
一般结果 Tested	675	570	24	115

X射线探伤: I级 X-ray radiographic inspection: I grade

Welding Gas: CO₂; 75%-95% Ar + Rest CO₂ at the speed 20-25 liter per minute

符合: GB H08A

相当: JISYGW12/ DIN S1

埋弧焊丝

Submerged Arc Welding Wire

说明: H08A 是镀铜碳素结构钢焊丝, 配合相应焊剂进行埋弧自动焊, 焊缝金属具有优良的力学性能.具有融敷效率高, 融敷金属有良好的力学性能。

用途: 配合相应焊剂用于碳钢 (如 Q235、Q195) 和强度级别较低的合金钢如 09Mn2, 16Mn, 16MnCu等埋弧自动焊。

Description: H08A is a carbon steel type solid submerged arc welding wire copper coating . it can get good mechanical seam with corresponding flux by automatic/machanzied welding, it can provides high depositing efficiency , works smoothly,deposited metal have good mechanical properties etc.

Application: welding of general carbon steel structure with suitable fluxes,to attain target metal composition.Such as boilers , containers , bridges , ships , pressure / chemical containers ,nuclear stations,typical carbon steel :(Q235 Q195) typical low alloyed steel (09Mn2,16Mn,16MnCu) etc

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	0.30-0.60	≤0.10	≤0.030	≤0.030

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	410-550	≥330	≥22	≥27
一般结果 Tested	508	379	30	88

X射线探伤: I级 X-ray radiographic inspection: I grade

典型配合焊剂 Typical Flux : F6A0-EL12 GB/T F4A2-H08A

符合：GB H08MnMoA
相当：EN756S2Mo /JISYS-M3

高强度埋弧焊丝 High Tensile Strength Submerged Arc Welding Wire

说明：H08MnMoA 是中锰钼合金系的低合金钢结构埋弧焊丝，配合相应焊剂进行埋弧自动焊，焊缝金属具有优良的力学性能。

用途：配合相应焊剂用于碳钢和强度级别 600Mpa 强度级别的合金钢等埋弧自动焊。

Description: H08MnMoA is a Mn-Mo type solid submerged arc welding wire.it can get good mechanical seam with corresponding flux by auto welding, provides high depositing efficiency, deposited metal have good mechanical properties etc.

Application: welding of general carbon steel structure and 600Mpa grade alloyed steel structures with suitable fluxes, to attain target metal composition. Such as 15MnVN, 15MnVNR, 15MnTiRe and pipeliner Series X60, X65 etc

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	钼 (Mo)	铜 (Cu)
0.05-0.17	0.75-1.25	≤0.20	0.45-0.65	≤0.35

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	550-690	≥490	≥22	≥27
一般结果 Tested	663	538	26	76

X射线探伤: I级 X-ray radiographic inspection: I grade

使用方法 Usage : clear impurity such as grease ,rust and water before welding; keep flux dry at 350℃ in one hour before welding, in order to avoid gas porosity

符合: GB/T H13CrMoA
相当: EN12070 SCrMo1

耐热钢埋弧焊丝

Heat Resistant Submerged Arc Welding Wire

说明: H13CrMoA 是低合金耐热钢埋弧焊丝, 配合相应焊剂进行埋弧自动焊, 具有冲击韧度高, 抗热裂, 抗氧化性强等性能。

用途: 配合相应焊剂用于耐热钢 (如15CrMo,20CrMo) 等。多用于高温压力容器及管道等焊接。

Description: H13CrMoA is a low alloy steel heat resistant submerged arc welding wire. it can get high impact toughness and excellent resistance against heat crack and oxidation,with corresponding flux by automatic/machanized welding.

Application: welding of heat resistant steel structure fabricated by 1.2Cr-0.5Mo, with suitable fluxes such as 15CrMo ,20CrMo.Widely used for pressure vessels and pipes in high-temperature environment.

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	钼 (Mo)
0.07-0.15	0.45-1.00	0.05-0.30	1.00-1.75	0.40-0.65

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥550	≥450	≥22	≥27
一般结果 Tested	621	492	25	140

X射线探伤: I级 X-ray radiographic inspection: I grade

典型配合焊剂 Typical Flux :AWS A5.23 E7P6-EH14

ER308L

符合: GB H03Cr21Ni10Si

相当: AWS A 5.9ER308L

不锈钢埋弧焊丝

Stainless Steel Submerged Arc Welding Wire

说明: ER308L是不锈钢埋弧焊丝, 配合相应焊剂埋弧自动焊, 焊缝金属具有优良的耐腐蚀性能。

用途: 配合相应焊剂用于不锈钢结构 (如 304L308L) 等埋弧自动焊。

Description: ER308L is a super low carbon type stainless steel solid submerged arc welding wire .it can get good corrosion resistance with corresponding flux by automatic/machanized welding.

Application: welding of Cr18-Ni8 grade stainless steel structure with suitable fluxes,.Such as 304L 308L

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铬 (Cr)	镍 (Ni)
≤0.03	1.0-2.5	0.3-0.65	19.5-22.5	9.0-11.0

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥550	-	≥30	-
一般结果 Tested	580	-	43	-

X射线探伤: I级 X-ray radiographic inspection: I grade

典型配合焊剂 Typical Flux : F6AZ-EL12 GB/T F4A0-H08A

ER70S-3

符合: GB ER50-3

相当: YGW16

氩弧焊丝

Argon Arc Welding Wire

说明: ER50-3是碳钢钨极氩弧焊丝,具有优良的塑性,韧性和抗裂性能和低温冲击抗裂性能。

用途: 适用于碳钢及 500 MPa 级低合金打底焊接(如车辆、桥梁、建筑,造船,压力容器,管道钢结构的焊接)。

Description: ER50-3 is a carbon steel type argon tungsten-arc welding wire,with TIG/GTAW welding process shielded by Argon gas,it provides good plasticity,toughness, crack resistance especially in low- temperature impact crack performance.

Application: suitable for carbon steel structures at 500MPa grade ,such as repairs on mild steel and low alloy steel,sheet metal ,pipes and tubing,small diameter spare-parts,root pass welding etc.

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
0.06-0.15	0.90-1.40	0.45-0.75	≤0.025	≤0.025

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥500	≥420	≥20	≥27
一般结果 Tested	560	4650	26	33

X射线探伤: I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas : Ar

Instructions: shielding gas speed at 20-25 liter per minute

Impurities on base metal surface should be cleaned before welding

E71T-1

符合: GB YJ502(Q)
相当: JISYFW-C50DR

药芯焊丝 Flux-Cored Welding Wire

说明: YJ502(Q)是钙钛型金红石型气体保护药芯焊丝, 采用二氧化碳或富氩气体焊接, 具有融敷效率高, 电弧稳定, 飞溅小, 焊缝成型美观, 可全位置施焊等工艺性能。

用途: 适用于碳钢及 500MPa 级低合金的单道及多道焊接 (如车辆、桥梁、建筑, 造船, 压力容器, 管道钢结构的焊接)。

Description: YJ502(Q) is a titanium-calcium rutile type gas shielded tubular welding wire. It can provides good performance of high melting efficiency, stable arc, weld forming beautiful, little splash

Application: widely used for low carbon steel structures and important low alloy steel with a tensile at 500Mpa, such as bridge, ship-building, machinery, metallurgy and ocean projects etc

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	硫 (S)	磷 (P)
≤0.12	0.50-1.85	0.30-0.90	≤0.030	≤0.030

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	550-690	≥470	≥26	≥27
一般结果 Tested	575	537	33	120

X射线探伤: I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas: totally CO₂; 75%-95% Ar + Rest CO₂; 95% Ar + Rest O₂

E71T-GS

符合: GB/T E501T-GS

相当: AWS E71T-GS

自保护药芯焊丝 Self Shielded Flux-Cored Welding Wire

说明: E71T-GS 是碳钢用自保护药芯焊丝, 具有电弧稳定, 飞溅小, 焊缝成型美观, 可全位置施焊等工艺性能。

用途: 适用于镀锌板、轻型结构等碳钢结构的焊接, 特别是平焊位置上的单道坡口焊和薄板金属上的角缝焊接

Description: E71T-GS is a self protected flux-cored welding wire for carbon steel structure application. It can weld in all position and provide excellent welding performance such as stable arc, fewer spatters, beautiful appearance, easy slag removal.

Application: Welding of carbon steel structures e.g. galvanized sheet, light structures element. Typically used for single pass groove weld in flat welding position, and fillet weld in sheet metal

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	铝 (Al)	硫 (S)
≤0.25	0.50-2.50	≤0.10	9.0-11.0	≤0.01

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30℃
保证值 Guaranteed	≥550	≥470	≥35	≥27
一般结果 Tested	600	490	39	120

X射线探伤: I级 X-ray radiographic inspection: I grade

参考电流 Recommended current:

焊条直径 (mm) Wire diameter	0.8	0.9	1.0	1.2
焊接电流(A) Welding Current	40-110	100-130	140-180	140-180

YJ607(Q)

符合: YJ607(Q)
相当: GB 602T-5

低合金钢药芯焊丝 Low Alloy Steel Flux-Cored Welding Wire

说明: YJ607(Q)是低合金钢用药芯焊丝,具有良好的缺口冲击韧性,飞溅小,焊缝成型美观,可全位置施焊等工艺性能。

用途: 适用于 600Mpa 强度级别低合金钢结构的焊接。广泛用于桥梁,冶金,煤矿机械,石油化工等工业制造设施。

Description: YJ607(Q) is a low alloy steel flux-cored welding wire. It can weld in all position and has excellent impact toughness on gap, fewer spatters, beautiful appearance of weld etc.

Application: Used for welding 600Mpa grade low alloy steel structures, widely used for pressure container, bridges,

熔敷金属化学成分(%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	镍 (Ni)	钼 (Mo)
≤0.20	1.20-1.80	≤0.50	≤1.5	0.20-0.50

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -50℃
保证值 Guaranteed	≥590	≥540	≥17	≥27
一般结果 Tested	710	620	20	60

X射线探伤: I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas: CO₂

E308LT1-1

符合: YA308L(Q)

相当: ISO 17663 T19 9 L P C/M 2

不锈钢药芯焊丝

Stainless Steel Flux-Cored Welding Wire

说明: YA308L(Q)是钙钛型气体保护药芯焊丝,采用二氧化碳或富氩气体焊接,具有融敷效率高,电弧稳定,飞溅小,焊缝成型美观,可全位置施焊等工艺性能。

用途: 适用于焊接温度 300 °C 耐腐蚀的 0Cr19Ni9 和 0Cr19Ni11Ti 不锈钢结构

Description: YA308L(Q) is a stainless steel gas-shielded flux-cored welding wire. It has soft and stable arc, fewer spatters, beautiful appearance of weld, good slag detachability.

Application: Used for welding corrosion-resistant 0Cr19Ni9 and 0Cr19Ni11Ti stainless steel structures below 300 degree and for welding some stainless steel materials like 301, 302, 304, 304L, 308, 308L, etc

熔敷金属化学成分 (%) Chemical Composition of Weld Metal (%)

碳 (C)	锰 (Mn)	硅 (Si)	镍 (Ni)	铬 (Cr)
≤0.040	0.50-2.50	≤0.10	9.0-11.0	18.0-21.0

熔敷金属机械性能 Mechanical properties of weld metal

实验项目 Test Item	抗拉强度 Tensile Strength Mpa	屈服强度 Yield Strength Mpa	延伸率 Elongation %	冲击值 Impact value (J) -30°C
保证值 Guaranteed	≥550	≥470	≥35	≥27
一般结果 Tested	600	490	39	120

X射线探伤: I级 X-ray radiographic inspection: I grade

保护气体 Shielding Gas: 75% Ar + 25% O₂; Totally CO₂



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