

STAINLESS STEEL WIRE SERIES

不锈钢焊丝系列 ←

用途：ER307 主要用于节制焊缝强度，同时使在诸如奥氏体锰钢与碳钢锻件或铸件的异种钢焊接中具有良好的抗裂性能，适用保护气体 Ar。

符合标准：AWS：ER307

Suitable for welding structures fabricated by high tensile strength steels and dissimilar steels, e.g. armor plate, H617 steel, etc.



不锈钢焊丝 ER307

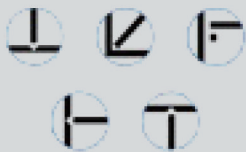
符合标准：AWS：ER307

具体参数 Specific Parameters

| 焊丝类型 Wire type | 规格 Specification | 丝盘 Wire Tray | 重量 Weight |
|--------------------|------------------|---|-------------------|
| MIG 焊丝 MIG wire | φ0.8~1.6(mm) | D100mm D200mm D300mm D270mm | 1kg 5kg 15kg 20kg |
| TIG 焊丝 TIG wire | φ1.6~5.0(mm) | 直条焊丝长度为 1 米 / 根 Straight wire length of 1metres / root | 5kg 10kg |

| 焊丝 化学成份 Wire Chemical composition (%) | C | Si | Mn | Cr | Ni | Mo | 其它 |
|--|------|------|------|-------|------|----|----|
| | 0.07 | 0.47 | 3.95 | 20.40 | 9.65 | - | - |

| 熔敷金属 机械性能 Deposited Metal Mechanical Properties | 品种 Varieties | 抗拉强度ob(Mpa) Tensile Strength | 延伸率δ5(%) Elongation |
|--|--------------|---------------------------------|------------------------|
| | ER307 | 612 | 43 |

| 注意事项 Matters needing attention | 焊接位置 Welding position |
|---|---|
| <p>焊丝进厂后必须存放在干燥环境中，不能随便打开焊丝盘的防水包装，以免焊丝锈蚀，焊接前应清除焊接面的油、锈、水分等杂质</p> <p>Wire into the plant must be stored in dry conditions, can not open the wire reel waterproof packaging, In order to avoid wire corrosion welding shall be removed , before welding surface oil, rust, water and other impurities</p> |  |

STAINLESS STEEL WIRE SERIES

不锈钢焊丝系列 ←

用途：

ER308：用于 18%Cr8%Ni 不锈钢的 Ar+0.5-2%O₂ 气体保护焊接，常用类似成分母材的焊接。

ER308L：18Cr~8Ni 钢用，焊接 SUS304L 比 MIG308 更耐腐蚀。

ER308LSi：适用于在高拘束力条件或熔敷金属完全奥氏体的地方，电弧稳定，焊接性能佳的 Ar+0.5-2%O₂ 气体保护焊接。

符合标准：

AWS: ER308 YB/T: H0Cr21Ni10 JIS:Y308

AWS: ER308L YB/T: H00Cr21Ni10 JIS:Y308L

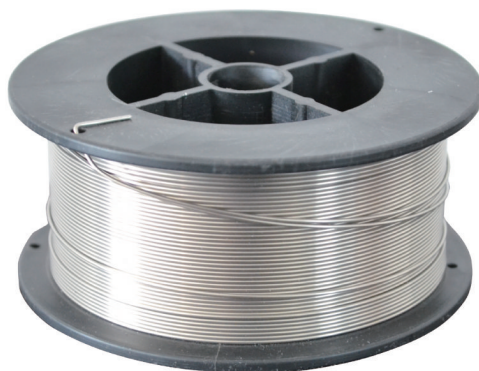
AWS: ER308LSi JIS:Y308LSi

Uses:

ER308：For Cr18Ni8, Cr18Ni12, Cr20Ni10 austenitic stainless steels, such as 301, 302 & 308, etc. especially 304.

ER308L：Suitable for extra-low carbon 00Cr19Ni10 structures. Also it could fabricat 0Cr18Ni10Ti structures, which working temperature lower than 300°C. E.g. synthetic fibre, fertilizer & chemical industrial equipment and so on.

ER308LSi：Suitable for extra-low carbon 00Cr19Ni10 stainless steels structures, which need better resistance to inter-crystal corrosion, e.g. synthetic fibre, petrochemical chemical industrial equipments.



不锈钢焊丝 ER308/ER308L/ER308LSi

符合标准 : AWS: ER308 YB/T: H0Cr21Ni10 JIS:Y308

AWS: ER308L YB/T: H00Cr21Ni10 JIS:Y308L

AWS: ER308LSi JIS:Y308LSi

具体参数 Specific Parameters

| 焊丝类型 Wire type | 规格 Specification | 丝盘 Wire Tray | 重量 Weight |
|--------------------|------------------|---|-------------------|
| MIG 焊丝 MIG wire | φ0.8~1.6(mm) | D100mm D200mm D300mm D270mm | 1kg 5kg 15kg 20kg |
| TIG 焊丝 TIG wire | φ1.6~5.0(mm) | 直条焊丝长度为 1 米 / 根 Straight wire length of 1metres / root | 5kg 10kg |

| 品种 Varieties | 熔敷金属机械性能 Deposited Metal Mechanical Properties | | 焊丝化学成份 Wire Chemical composition (%) | | | | | | |
|-----------------|---|------------------------|---|------|------|-------|-------|----|----|
| | 抗拉强度σb(Mpa) Tensile Strength | 延伸率δ5(%) Elongation | C | Si | Mn | Cr | Ni | Mo | 其它 |
| ER308 | 607 | 41 | 0.040 | 0.34 | 1.82 | 20.13 | 9.50 | - | - |
| ER308L | 578 | 42 | 0.024 | 0.42 | 1.65 | 20.10 | 10.33 | - | - |
| ER308LSi | 585 | 39 | 0.020 | 0.70 | 1.47 | 20.11 | 10.50 | - | - |

| 注意事项 Matters needing attention | 焊接位置 Welding position |
|---|-----------------------|
| <p>焊丝进厂后必须存放在干燥环境中,不能随便打开焊丝盘的防水包装,以免焊丝锈蚀,焊接前应清除焊接面的油、锈、水分等杂质</p> <p>Wire into the plant must be stored in dry conditions, can not open the wire reel waterproof packaging, In order to avoid wire corrosion welding shall be removed , before welding surface oil, rust, water and other impurities</p> | |

STAINLESS STEEL WIRE SERIES

不锈钢焊丝系列 ←

用途：

ER309/ER309L：用于异种钢焊接，如软钢与铬钼钢焊接用，焊接 SUS309S，SCS17 等，耐热、腐蚀性好，电弧稳定，焊接性能佳，Ar+0.5-2%O₂ 气体保护焊接；通常用于焊接相似成分的锻件和铸件；用于连接 304 型材与碳钢；用于焊接 304 型复合钢材的复层侧以及用于碳钢壳体里的不锈钢薄板衬里的焊接。

ER309 Lsi：高 Cr - 低 C - 22Cr - 12Ni 钢用，其他同 MIG309L。

符合标准：

AWS:ER309 YB/T:H1Cr24Ni13 JIS:Y309

AWS:ER309L YB/T:H00Cr24Ni13 JIS:Y309L

AWS:ER309LSi

Uses:

ER309/ER309L：For dissimilar steel welding, such as mild steel and chrome molybdenum steel welding, welding of SUS309S, SCS17, heat resistance, good corrosion resistance, arc stability, welding performance, Ar+0.5-2%O₂ gas shielded welding; usually used for welding of similar components forgings and castings; used for connecting the 304 section and carbon steel; welding for 304 type composite steel clad side as well as for the steel shell of stainless steel sheet lining welding.

ER309 Lsi：High Cr - low C - 22Cr - 12Ni steel, the other with MIG309L.



不锈钢焊丝 ER309/ER309L/ER309LSi

符合标准：AWS:ER309 YB/T:H1Cr24Ni13 JIS:Y309
 AWS:ER309L YB/T:H00Cr24Ni13 JIS:Y309L
 AWS:ER309LSi

具体参数 Specific Parameters

| 焊丝类型 Wire type | 规格 Specification | 丝盘 Wire Tray | 重量 Weight |
|--------------------|------------------|---|-------------------|
| MIG 焊丝 MIG wire | φ0.8~1.6(mm) | D100mm D200mm D300mm D270mm | 1kg 5kg 15kg 20kg |
| TIG 焊丝 TIG wire | φ1.6~5.0(mm) | 直条焊丝长度为 1 米 / 根 Straight wire length of 1metres / root | 5kg 10kg |

| 品种 Varieties | 熔敷金属机械性能 Deposited Metal Mechanical Properties | | 焊丝化学成份 Wire Chemical composition (%) | | | | | | |
|-----------------|---|------------------------|---|------|------|-------|-------|----|----|
| | 抗拉强度σb(Mpa) Tensile Strength | 延伸率δ5(%) Elongation | C | Si | Mn | Cr | Ni | Mo | 其它 |
| ER309 | 607 | 40 | 0.083 | 0.42 | 1.63 | 23.83 | 13.13 | - | - |
| ER309L | 588 | 43 | 0.023 | 0.39 | 1.98 | 23.88 | 12.90 | - | - |
| ER309LSi | 557 | 32 | 0.022 | 0.87 | 1.55 | 24.10 | 13.00 | - | - |

| 注意事项 Matters needing attention | 焊接位置 Welding position |
|---|-----------------------|
| <p>焊丝进厂后必须存放在干燥环境中，不能随便打开焊丝盘的防水包装，以免焊丝锈蚀，焊接前应清除焊接面的油、锈、水分等杂质</p> <p>Wire into the plant must be stored in dry conditions, can not open the wire reel waterproof packaging, In order to avoid wire corrosion welding shall be removed , before welding surface oil, rust, water and other impurities</p> | |

STAINLESS STEEL WIRE SERIES

不锈钢焊丝系列 ←

用途：

25%Cr-20%Ni 钢用，如 MIG309L 更适合各种金属焊接和自硬性高的合金钢和高碳钢的连接，异种钢材焊接用及加热炉部件、工作温度 950°C以下的输气系统部件。抗氧化温度直到 1035°C

符合标准：

AWS:ER310 YB/T:H1Cr26Ni21 JIS:Y310

Uses:

25%Cr-20%Ni steel is used, such as MIG309L more suitable for a variety of metal welding and self hardening high alloy steel and high carbon steel connections, dissimilar steel welding and heating furnace parts, working temperature below 950 DEG C gas transmission system components. Oxidation temperature until 1035 degrees

Meet the standards: :

AWS:ER310 YB/T:H1Cr26Ni21 JIS:Y310



不锈钢焊丝 ER310

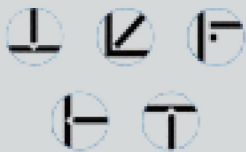
符合标准：AWS:ER310 YB/T:H1Cr26Ni21 JIS:Y310

具体参数 Specific Parameters

| 焊丝类型 Wire type | 规格 Specification | 丝盘 Wire Tray | 重量 Weight |
|--------------------|------------------|---|-------------------|
| MIG 焊丝 MIG wire | φ0.8~1.6(mm) | D100mm D200mm D300mm D270mm | 1kg 5kg 15kg 20kg |
| TIG 焊丝 TIG wire | φ1.6~5.0(mm) | 直条焊丝长度为 1 米 / 根 Straight wire length of 1metres / root | 5kg 10kg |

| 焊丝 化学成份 Wire Chemical composition (%) | C | Si | Mn | Cr | Ni | Mo | 其它 |
|--|-------|------|------|-------|-------|----|----|
| | 0.086 | 0.40 | 2.01 | 27.40 | 21.80 | - | - |

| 熔敷金属 机械性能 Deposited Metal Mechanical Properties | 品种 Varieties | 抗拉强度ob(Mpa) Tensile Strength | 延伸率δ5(%) Elongation |
|--|--------------|---------------------------------|------------------------|
| | ER310 | 607 | 41 |

| 注意事项 Matters needing attention | 焊接位置 Welding position |
|---|---|
| <p>焊丝进厂后必须存放在干燥环境中，不能随便打开焊丝盘的防水包装，以免焊丝锈蚀，焊接前应清除焊接面的油、锈、水分等杂质</p> <p>Wire into the plant must be stored in dry conditions, can not open the wire reel waterproof packaging, In order to avoid wire corrosion welding shall be removed , before welding surface oil, rust, water and other impurities</p> |  |

STAINLESS STEEL WIRE SERIES

不锈钢焊丝系列 ←

用途：

ER316/ER316L: 10Cr-12Ni-2.5Mo(SUS316) 钢的焊接用以及工作温度 600~750°C的化工、炼油热交换器管子、炉用管道。电弧稳定，焊道美观。抗氧化温度不低于 870°C。

ER316LSi：用于高 Si - 低 C - 18Cr - 12Ni - 2.5Mo 钢用，其它同 MIG316。

符合标准：

| | | |
|--------------|--------------------|-----------|
| AWS:ER316 | YB/T:H0Cr19Ni12Mo2 | JIS:Y316 |
| AWS:ER316L | YB/T:H0Cr19Ni12Mo2 | JIS:Y316L |
| AWS:ER316LSi | JIS:Y316LSi | |

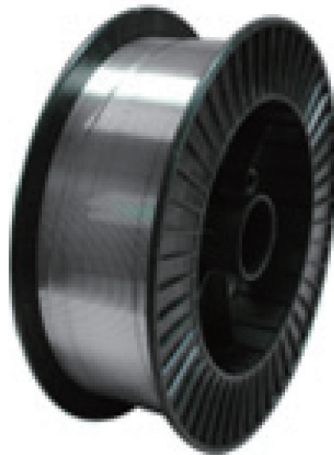
Uses:

ER316/ER316L : 10Cr-12Ni-2.5Mo (SUS316) steel welding is used and the temperature of 600~ 750 of the chemical industry, oil refining, furnace tube of heat exchanger pipe. Stable arc, weld appearance. Oxidation temperature of not lower than 870 DEG c..

ER316LSi : For the high Si - low C - 18Cr -12Ni -2.5Mo steel, the other with the MIG316.

Meet the standards: :

| | | |
|--------------|--------------------|-----------|
| AWS:ER316 | YB/T:H0Cr19Ni12Mo2 | JIS:Y316 |
| AWS:ER316L | YB/T:H0Cr19Ni12Mo2 | JIS:Y316L |
| AWS:ER316LSi | JIS:Y316LSi | |



不锈钢焊丝 ER316/ER316L/ER316LSi

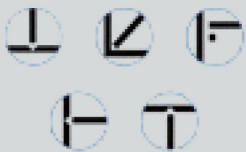
符合标准 : AWS:ER316 YB/T:H0Cr19Ni12Mo2
 AWS:ER316L YB/T:H0Cr19Ni12Mo2
 AWS:ER316LSi JIS:Y316LSi

JIS:Y316
 JIS:Y316L

具体参数 Specific Parameters

| 焊丝类型 Wire type | 规格 Specification | 丝盘 Wire Tray | 重量 Weight |
|--------------------|------------------|---|-------------------|
| MIG 焊丝 MIG wire | φ0.8~1.6(mm) | D100mm D200mm D300mm D270mm | 1kg 5kg 15kg 20kg |
| TIG 焊丝 TIG wire | φ1.6~5.0(mm) | 直条焊丝长度为 1 米 / 根 Straight wire length of 1metres / root | 5kg 10kg |

| 品种 Varieties | 熔敷金属机械性能 Deposited Metal Mechanical Properties | | 焊丝化学成份 Wire Chemical composition (%) | | | | | | |
|-----------------|---|------------------------|---|------|------|-------|-------|------|----|
| | 抗拉强度σb(Mpa) Tensile Strength | 延伸率δ5(%) Elongation | C | Si | Mn | Cr | Ni | Mo | 其它 |
| ER316 | 578 | 38 | 0.050 | 0.60 | 1.78 | 19.61 | 12.50 | 2.20 | - |
| ER316L | 590 | 40 | 0.025 | 0.42 | 1.91 | 19.10 | 12.58 | 2.57 | - |
| ER316LSi | 562 | 31 | 0.021 | 0.77 | 1.95 | 19.20 | 13.45 | 2.58 | - |

| 注意事项 Matters needing attention | 焊接位置 Welding position |
|--|---|
| <p>焊丝进厂后必须存放在干燥环境中,不能随便打开焊丝盘的防水包装,以免焊丝锈蚀,焊接前应清除焊接面的油、锈、水分等杂质</p> <p>Wire into the plant must be stored in dry conditions, can not open the wire reel waterproof packaging, in order to avoid wire corrosion welding shall be removed, before welding surface oil, rust, water and other impurities</p> |  |