

不锈钢焊条产品一览表Stainless Steel Electrodes

焊条牌号 Model	国标型号 GB Size	药皮类型 Type of Coating	焊接电源 Reference Current	主要用途 Purpose
LT·A102	E308-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于工作温度低于300℃的06Cr19Ni10及06Cr18Ni11Ti的不锈钢结构的焊接 Used for welding the corrosion resistant stainless steel structure, such as 06Cr19Ni10 and 06Cr18Ni11Ti and their working temperature should be below 300℃
LT·A132	347-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于重要耐腐蚀含钛稳定的06Cr18Ni11Ti型不锈钢的焊接 Used for welding important corrosion resistant stainless steel this contains stable Ti such as 06Cr18Ni11Ti.
LT·A302	E309-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于06Cr24Ni13类型不锈钢、异种钢、高铬钢、高锰钢等结构焊接 Used in similar type stainless steel, dissimilar stainless steel and high chromium steel and high manganese steel such as 06Cr24Ni13

LT·A102

符合GB/T 983 E308-16 AWS A5.4 E308-16 ISO 3581-A-E(19 9) R 3 2 ISO 3581-B-ES 308-16
Conform to Standard GB/T 983 E308-16 AWS A5.4 E308-16 ISO 3581-A-E(19 9) R 3 2 ISO 3581-B-ES 308-16

说明：钛钙型药皮的Cr19Ni10不锈钢焊条。熔敷金属具有良好的力学性能及抗晶间腐蚀性能。有优良的焊接工艺性能和抗气孔性能，药皮强度高。可交直流两用。

用途：用于焊接工作温度低于300℃的耐腐蚀的06Cr19Ni10及06Cr18Ni11Ti的不锈钢结构。

Specification: LT·A102 is a kind of Titanium calcium type coating Cr19Ni10 stainless steel electrode. The deposited metal has good mechanical properties and inter granular corrosion resistance. It has good welding performance and porosity resistance. Heat resistance coating and crack resistance. AC/DC both can be applied.

Purpose: Used for welding the corrosion resistant stainless steel structure, such as 06Cr19Ni10 and 06Cr18Ni11Ti and their working temperature should be below 300℃

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.08	0.50~2.50	≤1.00	≤0.030	≤0.040	18.0~21.0	9.0~11.0	≤0.75	≤0.75
例值 General Result	0.041	1.35	0.69	0.008	0.022	19.5	9.6	0.064	0.10

熔敷金属力学性能Mechanical Properties of Deposited Metal

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥550	30
例值 General Result	600	42

参考电流(AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径(mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流(A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项:

1.焊前焊条须经300℃烘焙1h。2.尽可能采用直流电源，电流不宜过大。

Notes:

1.The electrode must be preheated at the temperature of 300° C for 1 hour. Preheat the rod whenever it is used
2.Preferred DC power supply, electric current should not be high.

LT·A132

符合GB/T 983 E347-16 AWS A5.4 E347-16 ISO 3581-A-E(19 9Nb) R 3 2 ISO 3581-B-ES 347-16
Conform to Standard GB/T 983 E347-16 AWS A5.4 E347-16 ISO 3581-A-E(19 9Nb) R 3 2 ISO 3581-B-ES 347-16

说明：钛钙型药皮含铌稳定剂的Cr19Ni10Nb不锈钢焊条，具有优良的抗晶间腐蚀性能和良好的力学性能。有优良的焊接工艺性能和抗气孔性能，药皮不易发红、药皮强度高。可交直流两用。

用途：用于焊接重要的耐腐蚀含Ti稳定剂的06Cr18Ni11Ti型不锈钢。

Specification: LT·A132 is a kind of Titanium calcium type coating Cr19Ni10Nb which contains the Nb stabilizing property. It has good mechanical properties and inter granular corrosion resistance. Good welding performance and porosity resistance. Heat resistance coating and crack resistance. AC/DC both can be applied.

Purpose: Used for welding important corrosion resistant stainless steel this contains stable Ti such as 06Cr18Ni11Ti.

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb+Ta
标准值 Guarantee Value	≤0.08	0.50~2.50	≤1.00	≤0.030	≤0.040	18.0~21.0	9.0~11.0	≤0.75	≤0.75	8×C~1.00
例值 General Result	0.045	1.68	0.76	0.008	0.021	19.80	9.70	0.066	0.105	0.45

熔敷金属力学性能Mechanical Properties of Deposited Metal

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥520	≥25
例值 General Result	630	41

参考电流(AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径(mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流(A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项:

1.焊前焊条须经300℃烘焙1h。2.尽可能采用直流电源，电流不宜过大。

Notes:

1.The electrode must be preheated at the temperature of 300° C for 1 hour. Preheat the rod whenever it is used
2.Preferred DC power supply, electric current should not be high.

LT·A302

符合GB/T 983 E309-16 AWS A5.4 E309-16 ISO 3581-A-E(22 12) R 3 2 ISO 3581-B-ES 309-16
Conform to Standard GB/T 983 E309-16 AWS A5.4 E309-16 ISO 3581-A-E(22 12) R 3 2 ISO 3581-B-ES 309-16

说明：钛钙型药皮的Cr23Ni13不锈钢焊条，熔敷金属具有良好的抗裂性能及抗氧化性能。可交直流两用，有良好的操作工艺性能。

用途：用于焊接相同类型的不锈钢、不锈钢衬里、异种钢(Cr19Ni9同低碳钢)以及高铬钢、高锰钢。

Specification: LT·A302 is a calcium-titanium coated, Cr23Ni13 stainless steel electrode. The deposited metal has good crack-resistance and oxidation resistance. The electrode can operate on AC/DC. It is easy to operate.

Purpose: It is used in similar type stainless steel, dissimilar stainless steel and high chromium steel and high manganese steel.

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.15	0.50~2.50	≤1.00	≤0.030	≤0.040	22.0~25.0	12.0~14.0	≤0.75	≤0.75
例值 General Result	0.055	1.25	0.65	0.009	0.021	24.25	12.52	0.30	0.10

熔敷金属力学性能Mechanical Properties of Deposited Metal

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥550	≥25
例值 General Result	590	38

参考电流(AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径(mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流(A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项:

1.焊前焊条须经300℃烘焙1h。2.焊前必须对焊件进行油污、水分处理。

Notes:

1.The electrode must be preheated at the temperature of 300° C for 1 hour.
2.The impurities such as rust, oil stains and moisture must be cleared off of the work piece.