

## 埋弧、TIG焊丝一览表Submerged Arc、TIG Welding Wires

类别 Types	焊丝牌号 Model of Wires	型号 Model		主要用途 Purpose
		GB	AWS	
埋弧焊丝 Submerged Arc Welding Wire	LT·H08A	H08A	E18	焊接低碳钢及某些低合金钢结构 Used for welding low-carbon steel and some low-alloy steel structures.
	LT·H08MnA	H08MnA	EM12	适用于碳钢及低合金钢结构的焊接 Used for welding carbon steel and some low-alloy steel structures.
	LT·H10Mn2	H10Mn2	EH14	适用于碳钢及低合金钢结构的焊接 Used for welding carbon steel and some low-alloy steel structures.
	LT·H10MnSi	H10MnSi	EM13K	焊接重要的低碳钢和低合金钢结构 Used for welding low-carbon steel and low-alloy steel
氩弧焊丝 TIG Welding Wire	LT·ER49-1	ER49-1		焊接低碳钢 Used for welding low-carbon steel
	LT·TIG50	ER50-6	ER70S-6	焊接低碳钢及低合金钢结构 Used for welding low-carbon steel and low-alloy steel structures.

## LT·H08A

符合GB/T 5293 H08A 相当AWS E18 ISO 14171-B-SU11

Conform to Standard :GB/T 5293 H08A Equivalent to : AWS E18 ISO 14171-B-SU11

说明：低锰低硅型焊丝，与高锰、硅的焊剂相匹配，对母材上的锈迹不敏感，焊道成形及脱渣性能优良，是目前国内用量最大的埋弧焊丝。单、双极，交、直流焊接均可。

用途：与烧结型焊剂301、501配合，420MPa抗拉强度等级母材的高速焊接及填充焊接均可。

**Specification:**It is a kind of low manganese-silicon type welding wire, matches with high-manganese, and high-silicon welding flux, Insensitive to rust on the base metal. It has excellent bead molding and slag detach ability and has the largest consumption of submerged arc welding wires in the domestic. The wire can be applied single or dual feeding with AC/DC.

**Purpose:** Using with sintered flux LT·SJ301 and 501, it can be applied both for high-speed welding steel plate of tensile strength 420MPa and filling welding

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.10	0.30~0.60	≤0.03	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
例值 General Result	0.060	0.45	0.012	0.014	0.020	0.017	0.022	0.113

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

试验项目 Test Item 配合焊剂 Flux	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) -20°C
LT·SJ301	415-550	≥330	≥22	≥27

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0

## LT·H08MnA

符合GB/T 5293 H08MnA 相当AWS EM12 ISO 14171-B-SU22

Conform to Standard :GB/T 5293 H08MnA Equivalent to : AWS EM12 ISO 14171-B-SU22

说明：中锰低硅型焊丝，与中锰、硅的焊剂相匹配，对母材上的锈迹不敏感，焊道成形及脱渣性能优良。单、双极，交、直流焊接均可。

用途：与烧结型焊剂101配合，420MPa抗拉强度等级母材的高速焊接及填充焊接均可。

**Specification:**It is a kind of medium manganese-low silicon type welding wire, matches with medium-manganese and medium-silicon welding flux, Insensitive to rust on the base metal. It has excellent bead molding and slag detach ability. The wire can be applied single or dual feeding with AC/DC.

**Purpose:** Using with sintered flux LT·SJ101, it can be applied both for high-speed welding steel plate of tensile strength 420MPa and filling welding

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.10	0.80~1.10	≤0.07	≤0.030	≤0.030	≤0.020	≤0.030	≤0.35
例值 General Result	0.066	0.96	0.038	0.007	0.010	0.027	0.011	0.110

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

试验项目 Test Item 配合焊剂 Flux	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) -20°C
LT·SJ101	415-550	≥330	≥22	≥27

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0

## LT·H10Mn2

符合GB/T 5293 H10Mn2 相当AWS EH14 ISO 14171-B-SU33

Conform to Standard :GB/T 5293 H10Mn2 Equivalent to : AWS EH14 ISO 14171-B-SU33

说明：高锰型焊丝，与低锰、硅的焊剂相匹配，对母材上的锈迹不敏感，焊道成形及脱渣性能优良。单、双极，交、直流焊接均可。

用途：与烧结型焊剂101配合，490MPa抗拉强度等级母材的高速焊接及填充焊接均可。具有非常稳定的熔敷金属力学性能。

**Specification:** It is a kind of high-manganese type welding wire. It matches with low-manganese and low-silicon type welding flux. Insensitive to the rust on the base metal. It has excellent bead molding and slag detach ability. The wire can be applied single or dual feeding with AC/DC.

**Purpose:** Using with sintered flux LT·SJ101, it can be applied both for high-speed welding steel plate of tensile strength 490MPa and filling welding. Mechanical properties of deposited metal is very stable.

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.12	1.50~1.90	≤0.070	≤0.035	≤0.035	≤0.20	≤0.30	≤0.35
例值 General Result	0.066	1.62	0.011	0.011	0.011	0.013	0.007	0.12

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

试验项目 Test Item 配合焊剂 Flux	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) -20°C	-40°C
LT·SJ101	490-650	≥400	≥22		≥27

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0

## LT·H10MnSi

符合GB/T 5293 H10MnSi 相当AWS EM13K ISO 14171-B-SU25

Conform to Standard :GB/T 5293 H10MnSi Equivalent to : AWS EM13K ISO 14171-B-SU25

说明：锰、硅含量适中，与低锰、硅的焊剂相匹配，对母材上的锈迹不敏感，焊道成形及脱渣性能优良。焊接效率高。

用途：与烧结型焊剂101配合，420MPa抗拉强度等级母材的高速焊接及填充焊接均可。多用于锅炉、压力容器、桥梁、船舶等工程的焊接。

**Specification:**It is a kind of welding wire with appropriate manganese and silicon content. It matches with low-manganese and low-silicon type welding flux, Insensitive to the rust on the base metal. It has excellent bead molding, excellent slag detach ability.

**Purpose:** Using with sintered flux LT·SJ101, it can be applied both for high-speed welding steel plate of tensile strength 420MPa and filling welding. It is widely used for welding boiler, pressure vessels, bridges, shipbuilding etc.

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.14	0.80~1.10	0.60~0.90	≤0.035	≤0.035	≤0.20	≤0.30	≤0.35
例值 General Result	0.089	0.98	0.67	0.023	0.032	0.015	0.034	0.11

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

试验项目 Test Item 配合焊剂 Flux	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) -20°C
LT·SJ101	415-550	≥330	≥22	≥27

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0

## LT·ER49-1

符合GB/T 8110 ER49-1

Conform to Standard :GB/T 8110 ER49-1

说明：LT·ER49-1是碳钢氩弧焊丝，具有优良的塑形、韧性和抗裂性能。

用途：适于碳钢及500MPa级结构钢的焊接。

**Specification:** LT·ER49-1 is a kind of carbon steel argon arc welding wire, with an excellent performance of shaping, toughness and crack resistance.

**Purpose:** Used for welding carbon steel and suitable for welding 500MPa high strength steel structures.

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Cu
标准值 Guarantee Value	≤0.11	1.80~2.10	0.65~0.95	≤0.030	≤0.030	≤0.030	≤0.020	≤0.50
例值 General Result	0.063	1.93	0.79	0.010	0.015	0.007	0.015	0.112

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

试验项目 Test Item	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) 常温
标准值 Guarantee Value	≥490	≥372	≥20	≥47
例值 General Result	550	455	78	148、159、147

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ1.6	Φ2.0	Φ2.5	Φ3.0

## LT·TIG50

符合GB/T 8110 ER50-6 相当AWS A5.18 ER70S-6

Conform to Standard :GB/T 8110 ER50-6 Equivalent to : AWS A5.18-ER70S-6

说明：LT·TIG50是碳钢氩弧焊丝，具有优良的塑形、韧性和抗裂性能，尤其低温冲击韧性较高。

用途：用于各种位置的管道手工钨极氩弧焊打底及弧焊，都能获得满意的焊接接头。可焊接碳钢和某些低合金钢。

**Specification:** LT·TIG50 is a kind of carbon steel argon arc welding wire, with an excellent performance of shaping, toughness and crack resistance. The bead has a high impact toughness in low temperature

**Purpose:** Used for manual tungsten argon arc welding backing and arc welding of pipeline in various positions. And used for welding low-carbon steel and low-alloy steel structures.

焊丝化学成分(%) Chemical Composition of Welding Wires (%)

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
标准值 Guarantee Value	0.06~0.15	1.40~1.85	0.80~1.15	≤0.025	≤0.025	≤0.15	≤0.15	≤0.15	≤0.03	≤0.50
例值 General Result	0.08	1.49	0.84	0.018	0.018	0.019	0.032	0.004	0.007	0.15

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

试验项目 Test Item	R <sub>m</sub> (MPa)	R <sub>eL</sub> /R <sub>p0.2</sub> (MPa)	A(%)	KV <sub>2</sub> (J) -30°C
标准值 Guarantee Value	≥490	≥420	≥22	≥27
例值 General Result	546	467	27	116

焊丝规格Size of Welding Wires

焊丝直径 (mm) Size (mm)	Φ1.0	Φ1.2	Φ1.6	Φ2.0	Φ2.5	Φ3.0