

药芯气保护焊丝一览表 Gas Shielded Flux-Cored Welding Wires

类别 Types	焊丝牌号 Model of Wires	型号 Model			主要用途 Purpose
		GB	AWS	JIS	
低合金钢气体 保护药芯 焊丝 Co. gas shielded flux-cored wires for low-carbon steel and high- strength structural steel	LT · E501	T492T1-1C1M21A	E71T-1	T492T1-1CA	低碳钢及相应强度低合金结构钢焊接 Used for welding low-carbon steel and some low-alloy steel structures.
	LT · E501Ni	E491T1-Ni1C	E71T1-C1A4-Ni	T493T1-1CA-N2	低温钢和低合金结构钢的焊接 Welding of low-temperature steel and low-alloy steel structures.
	LT · E711	T492T1-1C1M21A	E71T-1	T492T1-1CA	低碳钢及相同强度低合金结构钢焊接 Used for welding low-carbon steel and some low-alloy steel structures.
不锈钢药芯焊丝 Stainless steel flux-cored wire	LT · 308L	E308LT1-1	E308LT1-1		用于焊接工作温度低于300°C的耐腐蚀的06Cr19Ni10, 07Cr19Ni11Ti的不锈钢结构 Used for welding corrosion-resistant 06Cr19Ni10, 07Cr19Ni11Ti stainless steel structures and the working temperature should be below 300°C.
	LT · 309L	E309LT1-1	E309LT1-1		用于相同类型的不锈钢结构及复合铜、异种钢等构件, 也可用于过渡层堆焊 Used for the same types of stainless steel structure, composite steel, dissimilar steel and other components, it can also be used for transition surfacing.
自保护药芯焊丝 Self-shielded flux-cored wire	LT · E71T-GS	E501T11-G	E71T11-AZ-CS3		细直径自保护药芯焊丝, 用于多种碳钢母材(主要是薄板和镀锌板)全位置半自动焊接 Small diameter self-shielded flux-cored wire, used for semi-automatic welding of various carbon steel base materials (mainly sheet and galvanized sheet) in full position.

LT · E501

符合GB/T 10045 T492T1-1C1M21A 相当AWS A5.36 E71T-1C 相当JIS Z3313 E492T1-1CA
相当ISO 17632-B-T492T1-1CA

Conform to Standard :GB/T 10045 T492T1-1C1M21A Equivalent to : AWS A5.36 E71T-1C JIS Z3313 E492T1-1CA ISO 17632-B-T492T1-1CA

说明: LT · E501为氧化钛型气体保护药芯焊丝, 焊接工艺性能优良, 电弧柔和稳定, 飞溅小, 脱渣容易, 焊缝成形美观。
适用于平焊和横焊, 可进行全位置焊接, 焊接效率高。焊缝金属经微量元素碳化物处理, 低温韧性优良, 抗裂性好, 内在质量稳定可靠。

用途: 适用于造船、机械制造、石油机械、化工机械、起重机械等碳钢、低合金结构钢的焊接。

Specification: LT · E501 is a kind of titanium oxide gas shielded flux-cored wire, It has excellent welding performance, soft and stable arc, lower spatters, good slag detach ability and beautiful appearance of weld, suitable for all-position welding. It has high welding efficiency. The weld metal has been given toughening treatment by micro-elements, so it has excellent low temperature toughness, good crack-resistance, stable and reliable inherent quality.

Purpose: Most widely used for welding some key structures like shipbuilding, mechanical manufacture, petroleum machinery, chemical machinery, hoisting machinery etc.

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

项目 Test Item	C	Mn	Si	S	P
标准值 Guarantee Value	≤0.18	≤1.75	≤0.90	≤0.030	≤0.030
例值 General Result	0.05	1.36	0.41	0.008	0.012

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

试验项目 Test Item	R _m (MPa)	R _{el} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
标准值 Guarantee Value	≥480	≥400	≥22	≥27
例值 General Result	560	480	28	145

熔敷金属扩散氢含量(热导法): ≤10ml/100g Diffusion hydrogen content of the deposited metal (Mercury Method): ≤10ml/100g

X射线探伤要求: II级 X-Ray Radiographic Test Requirements: Grade II

参考范围(DC⁺) Reference Current (DC⁺)

焊丝直径 (mm) Size (mm)	Φ1.0	Φ1.2	Φ1.4	Φ1.6	
电流 范围 (A) Current Range (A)	平焊 Flat Position	120-250	120-300	150-400	180-450
	向上立焊、仰焊 Vertical Upward welding/Overhead position	120-210	120-260	150-270	180-280
	向下立焊 Vertical Downward welding/Overhead position	200-250	200-300	220-300	250-300
	横焊 Horizontal Welding	120-230	120-280	150-320	180-350

注意事项: 1.施焊工作前应除油、除锈处理。2.焊接时, 气体流量一般在20-25L/min。3.药芯焊丝焊接时, 干伸长度应为15-25mm。4.焊丝库房的湿度应保持在小于60%
5.非真空包装焊丝存放时间不宜超过半年, 真空包装焊丝存放时间不宜超过一年。

1.Adopt degreasing and rust cleaning process before operate.2.Shielding gas flow: 20-25L/min when welding.3.Extension: 15-25mm.4.The humidity of welding wire storage should be less than 60% 5.Storage period: Vacuum packaging less than 1 Year, other packaging less than half year.

LT · E501Ni

符合GB/T 17493 E491T1-Ni1C 相当AWS A5.36 E71T1-C1A4-Ni1 相当JIS Z3313 T493T1-1CA-N2
相当ISO 17632-B-T493T1-1CA-N2

Conform to Standard :GB/T 17493 E491T1-Ni1C Equivalent to : AWS A5.36 E71T1-C1A4-Ni1 JIS Z3313 T493T1-1CA-N2 ISO 17632-B-T493T1-1CA-N2

说明: LT · E501Ni为氧化钛型气体保护药芯焊丝, 焊接工艺性能优良, 电弧柔和稳定, 飞溅小, 脱渣容易, 焊缝成形美观。
适用于平焊和横焊, 可进行全位置焊接, 焊接效率高。熔敷金属经微量元素碳化物处理, 具有优良的低温韧性, 抗裂性好。

用途: 适用于造船、机械制造、石油机械、化工机械、起重机械等碳钢、低合金结构钢的焊接。

Specification: LT · E501Ni is a kind of titanium oxide gas shielded flux-cored wire, It has excellent welding performance, soft and stable arc, lower spatters, good slag detach ability and beautiful appearance of weld, suitable for all-position welding. It has high welding efficiency. The weld metal has been given toughening treatment by micro-elements, so it has excellent low temperature toughness, good crack-resistance, stable and reliable inherent quality.

Purpose: Most widely used for welding some key structures like shipbuilding, mechanical manufacture, petroleum machinery, chemical machinery, hoisting machinery etc.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.12	≤1.50	≤0.80	≤0.030	≤0.030	0.80-1.10	≤0.15	≤0.35	≤0.05
例值 General Result	0.04	1.28	0.38	0.006	0.011	0.90			

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

试验项目 Test Item	R _m (MPa)	R _{el} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -30°C	-40°C
标准值 Guarantee Value	490-620	≥400	≥20	≥27	
例值 General Result	570	510	27	135	120

熔敷金属扩散氢含量(热导法): ≤10ml/100g Diffusion hydrogen content of the deposited metal (Mercury Method): ≤10ml/100g

参考范围(DC⁺) Reference Current (DC⁺)

焊丝直径 (mm) Size (mm)	Φ1.0	Φ1.2	Φ1.4	Φ1.6	
电流 范围 (A) Current Range (A)	平焊 Flat Position	120-250	120-300	150-400	180-450
	向上立焊、仰焊 Vertical Upward welding/Overhead position	120-210	120-260	150-270	180-280
	向下立焊 Vertical Downward welding/Overhead position	200-250	200-300	220-300	250-300
	横焊 Horizontal Welding	120-230	120-280	150-320	180-350

注意事项: 1.施焊工作前应除油、除锈处理。2.焊接时, 气体流量一般在20-25L/min。3.药芯焊丝焊接时, 干伸长度应为15-25mm。4.焊丝库房的湿度应保持在小于60%
5.非真空包装焊丝存放时间不宜超过半年, 真空包装焊丝存放时间不宜超过一年。

1.Adopt degreasing and rust cleaning process before operate.2.Shielding gas flow: 20-25L/min when welding.3.Extension: 15-25mm.4.The humidity of welding wire storage should be less than 60% 5.Storage period: Vacuum packaging less than 1 Year, other packaging less than half year.

LT · E711

符合GB/T 10045 T492T1-1C1M21A 相当AWS A5.36 E71T-1C 相当JIS Z3313 E492T1-1CA
相当ISO 17632-B-T 492T1-1CA

Conform to Standard :GB/T 10045 T492T1-1C1M21A Equivalent to : AWS A5.36 E71T-1C JIS Z3313 E492T1-1CA ISO 17632-B-T492T1-1CA

说明: LT · E711为氧化钛型气体保护药芯焊丝, 焊接工艺性能优良, 电弧柔和稳定, 飞溅小, 脱渣容易, 焊缝成形美观。
适用于平焊和横焊, 可进行全位置焊接, 焊接效率高。熔敷金属经微量元素碳化物处理, 低温韧性优良, 抗裂性好, 内在质量稳定可靠。

用途: 适用于造船、机械制造、石油机械、化工机械、起重机械等碳钢、低合金结构钢的焊接。

Specification: LT · E711 is a kind of titanium oxide type gas-shielded flux-cored welding wire for low carbon steel and 490MPa high strength steel. It has excellent welding performance, soft and stable arc, lower spatters, good slag detachability and beautiful appearance of weld; suitable for all-position welding. It has high welding efficiency. The weld metal has been given toughening treatment by microelements, so it has excellent low temperature toughness, good crack-resistance, stable and reliable inherent quality.

Purpose: Most widely used for welding some key structures like shipbuilding, mechanical manufacture, petroleum machinery, chemical machinery, hoisting machinery

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

项目 Test Item	C	Mn	Si	S	P
标准值 Guarantee Value	≤0.18	≤1.75	≤0.90	≤0.030	≤0.030
例值 General Result	0.05	1.28	0.39	0.010	0.016

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

试验项目 Test Item	R _m (MPa)	R _{el} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
标准值 Guarantee Value	≥480	≥400	≥22	≥27
例值 General Result	550	470	27	115

熔敷金属扩散氢含量(热导法): ≤10ml/100g Diffusion hydrogen content of the deposited metal (Mercury Method): ≤10ml/100g

X射线探伤要求: II级 X-Ray Radiographic Test Requirements: Grade II

参考范围(DC⁺) Reference Current (DC⁺)

焊丝直径 (mm) Size (mm)	Φ1.0	Φ1.2	Φ1.4	Φ1.6	
电流 范围 (A) Current Range (A)	平焊 Flat Position	120-250	120-300	150-400	180-450
	向上立焊、仰焊 Vertical Upward welding/Overhead position	120-210	120-260	150-270	180-280
	向下立焊 Vertical Downward welding/Overhead position	200-250	200-300	220-300	250-300
	横焊 Horizontal Welding	120-230	120-280	150-320	180-350

注意事项: 1.施焊工作前应除油、除锈处理。2.焊接时, 气体流量一般在20-25L/min。3.药芯焊丝焊接时, 干伸长度应为15-25mm。4.焊丝库房的湿度应保持在小于60%
5.非真空包装焊丝存放时间不宜超过半年, 真空包装焊丝存放时间不宜超过一年。

1.Adopt degreasing and rust cleaning process before operate.2.Shielding gas flow: 20-25L/min when welding.3.Extension: 15-25mm.4.The humidity of welding wire storage should be less than 60% 5.Storage period: Vacuum packaging less than 1 Year, other packaging less than half year.

LT · 308L

符合GB/T 17853 E308LT1-1 AWS A5.22 E308LT1-1

Conform to Standard :GB/T 17853 E308LT1-1 AWS A5.22 E308LT1-1

说明: LT · 308L是一种CO₂气体保护不锈钢药芯焊丝, 电弧柔和稳定, 飞溅少, 成形美观, 脱渣容易, 具有良好的焊接工艺性能, 可进行全位置焊接, 熔敷金属具有良好的力学性能及抗晶间腐蚀性。

用途: 用于焊接工作温度低于300°C的耐腐蚀的06Cr19Ni10, 07Cr19Ni11Ti的不锈钢结构。用于301,302,304,304L,308,308L等不锈钢材料的焊接

Specification: LT · 308L is a kind of gas shielded stainless steel flux cored wire, soft and stable arc, lower spatter, beautiful appearance, easy to slag removal, it has good welding performance and all position welding. The deposited metal has excellent mechanical properties and intercrystalline corrosion-resistance.

Purpose: Used for welding corrosion-resistant 06Cr19Ni10, 07Cr19Ni11Ti stainless steel structures and the working temperature should be below 300°C. It is used for welding 301,302,304,301L, 308,308L and other stainless steel materials.

保护气体: CO₂ Shielding Gas: CO₂

熔敷金属化学成分(%) (保护气体: CO₂) Chemical Composition of Deposited Metal (%) (Shielding Gas: CO₂)

项目 Test Item	C	Mn	Si	Ni	Cr	S	P
标准值 Guarantee Value	≤0.04	0.50-2.50	≤1.00	9.0-11.0	18.0-21.0	≤0.030	≤0.030
例值 General Result	0.029	1.40	0.36	10.3	19.33	0.003	0.023

熔敷金属力学性能 (保护气体: CO₂) Mechanical Properties of Deposited Metal (Shielding Gas: CO₂)

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥520	≥35
例值 General Result	550	43.5

供货规格: Φ1.2mm Φ1.4mm Φ1.6mm Specification of supply: Φ1.2mm Φ1.4mm Φ1.6mm

LT · 309L

符合GB/T 17853 E309LT1-1 AWS A5.22 E309LT1-1

Conform to Standard :GB/T 17853 E309LT1-1 AWS A5.22 E309LT1-1

说明: LT · 309L是一种CO₂气体保护不锈钢药芯焊丝, 电弧柔和稳定, 飞溅少, 成形美观, 脱渣容易, 具有良好的焊接工艺性能, 可进行全位置焊接, 熔敷金属具有良好的力学性能。

用途: 用于合成纤维、石油化工等设备制造的相同类型的不锈钢结构及复合铜、异种钢等构件, 也可用于核反应堆、压力容器内壁上过渡层堆焊和塔内构件焊接。

Specification: LT · 309L is a kind of CO₂ gas shielded stainless steel flux cored wire, soft and stable arc, lower spatter, beautiful appearance, easy slag removal, it has good welding performance and all position welding. The deposited metal has excellent crack resistance.

Purpose: can be used for welding petrochemical and other manufacturing equipment, chemical composition of the same type of stainless steel structure and composite steel, steel and other components. Can also be used for wall welding of nuclear reactor, pressure vessel, transition layer surfacing and internals of oil refining equipment.

保护气体: CO₂ Shielding Gas: CO₂

熔敷金属化学成分(%) (保护气体: CO₂) Chemical Composition of Deposited Metal (%) (Shielding Gas: CO₂)

项目 Test Item	C	Mn	Si	Ni	Cr	S	P
标准值 Guarantee Value	≤0.04	0.50-2.50	≤1.00	12.0-14.0	22.0-25.0	≤0.030	≤0.040
例值 General Result	0.035	1.25	0.58	12.4	24.15	0.004	0.023

熔敷金属力学性能 (保护气体: CO₂) Mechanical Properties of Deposited Metal (Shielding Gas: CO₂)

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥520	≥25
例值 General Result	560	41.5

供货规格: Φ1.2mm Φ1.4mm Φ1.6mm Specification of supply: Φ1.2mm Φ1.4mm Φ1.6mm

LT · E71T-GS

符合GB/T 17493-2008 E501T11-G AWS A5.36 E71T11-AZ-CS3

Conform to Standard :GB/T 17493-2008 E501T11-G AWS A5.36 E71T11-AZ-CS3

说明: LT · E71T-GS为细直径自保护药芯焊丝, 采用直流正接, 电弧柔和稳定, 飞溅小, 成形美观, 脱渣性好, 烟尘量小, 操作简便, 具有良好的焊接操作工艺性。

用途: 用于多种碳钢母材(主要是薄板和镀锌板)全位置半自动焊接, 适用于家庭式便捷操作。

Specification: LT · 71T-GS It is a small diameter self-shielded flux-cored wire with direct current connection. Soft and stable arc, small splash, beautiful forming, easy slag removal, small amount of spatter, easy operation, with good welding operation performance.

Purpose: Used for many kinds of carbon steel base material (Mainly thin plate and galvanized plate), Full position semi-automatic welding, suitable for family type operation.

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

项目 Test Item	C	Mn	Si	S	P	Al
标准值 Guarantee Value	≤0.30	≤1.75	≤0.60	≤0.030	≤0.030	≤1.80
例值 General Result	0.22	0.62	0.23	0.007	0.008	1.42

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

试验项目 Test Item	R _m (MPa)	R _{el} /R _{p0.2} (MPa)	A(%)
标准值 Guarantee Value	480-655	≥400	≥20
例值 General Result	620	450	23

参考范围(DC⁺) Reference Current (DC⁺)

焊丝直径 (mm)	焊接电流 (A)	焊接电压 (V)
Φ0.8	60-130	14-21
Φ0.9	60-150	15-22
Φ1.0	60-150	15-22

供货规格: Φ0.8mm Φ0.9mm Φ1.0mm Specification of supply: Φ1.2mm Φ1.4mm Φ1.6mm

供货包装: 1.塑料盘, 净重1kg/盘, 10盘/箱 2.其他包装协议 Supply the packing: 1.Plastic tray, Net Weight:1kg/coil, 10coil/box 2.Other packaging