不锈钢焊丝

本公司生产的不锈钢焊丝，对原材料的材质要求相当高，通过精益的制造，完全能够满足客户的要求，并以其高质量、及高稳定焊接性能被众多造船、化工、炼油、汽车、不锈钢电焊条等企业采用。对于不锈钢焊接：MIG、TIG、SUB，本公司可根据客户要求生产不同规格，材质的不锈钢焊丝及焊接用不锈钢直条，并满足客户的不同包装要求。

Stainless steel welding wires

We use only very high quality materials and very tight process control in the production of stainless steel welding wires. End products meet end users' critical demand and are widely used in the industries of shipment, petrochemical, refinery and automotive. Specifications and package can be adjusted in accordance with customers' special requirement.

牌号 Brand	AWS A5.9-93	GB/T 17854-99 (YB/T 5092-96)	JIS Z3321-99	熔敷金属机械性能 Mechanical properties of deposited metal		焊丝化学成份一例（%） Typical Welding wire chemical composition(%)							性能与用途 Features and Applications
				抗拉强度 Tensile strength (MPa)	延伸率 Elongation δ5(%)	C	Si	Mn	Cr	Ni	Mo	其他 other	
YH-307	ER307	-	-	612	43	0.070	0.47	3.95	20.40	9.65	-	-	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 Welding seam strength can be controlled. Primarily used for welding of austenitic manganese steel forgings and castings, and austenitic carbon steel forgings and castings with outstanding crack resistance.Applicable to the protection of gas:Ar
YH-308	ER308	H0Cr21Ni10	Y308	607	41	0.040	0.34	1.82	20.13	9.50	-	-	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%02体保护焊接。 apply to the high binding conditions or fully austenitic metal cladding where a stable arc, good welding properties of Ar +0.5-2% O2 gas shielded welding.
YH-308L	ER308L	H00Cr21Ni10	Y308L	578	42	0.024	0.42	1.65	20.10	10.33	-	-	18Cr—8Ni钢用，焊接SUS304L比MIG308更耐腐蚀 Primarily used for welding of 18Cr-8Ni steels. The welding wires will have more outstanding resistance than MIG308, if they are used for welding of SUS304L.
YH-309	ER309	H1Cr24Ni13	Y309	607	40	0.083	0.42	1.65	23.83	13.13	-	-	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。 used for dissimilar metal welding, such as mild steel and Cr-Mo steel used for welding, welding SUS309S, SCS17, such as heat, corrosive, and arc stability, excellent welding performance, Ar +0.5-2% O2 gas shielded welding; similar to components used in welding of forgings and castings; used to connect 304 profiles with steel; 304 for the welding of complex composite layers of steel for carbon steel shell-side and in the lining of welded stainless steel sheet.
YH-309L	ER309L	H00Cr24Ni13	Y309L	558	43	0.023	0.39	1.98	23.83	12.90	-	-	
YH-309LSi	ER309LSi	-	-	557	32	0.022	0.87	1.55	24.10	13.00	-	-	高Cr—低C—22Cr—12Ni钢用，其它同MIG309L Primarily used for welding of high silicon,low carbon,22Cr-12Ni steels.
YH-310	ER310	H1Cr26Ni21	Y310	607	41	0.086	0.40	2.01	27.40	21.80	-	-	25Cr—20Ni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℃以下的输气系统部件。 25Cr-20Ni steel, such as more suitable for a variety of MIG309L metal welding and self-rigid high-alloy steel and high carbon steel connections steel welding dissimilar components used and the furnace temperature below 950 ℃ gas system components
YH-316	ER316	H0Cr19Ni12Mo2	Y316	578	38	0.050	0.6	1.78	19.61	12.50	2.30	-	10Cr—12Ni—2.5Mo(SUS316)钢的焊接用以及工作温度600~750℃的化工、炼油热交换器管子、炉用管道。 10Cr-12Ni-2 5Mo (SUS316) used for welding steel, as well as operating Temperature of 600 ~ 750 chemical, oil refining tube heat exchangers, furnace tubes Peter.
YH-316L	ER316L	H00Cr19Ni12Mo2	Y316L	558	40	0.025	0.42	1.91	19.10	12.58	2.57	-	10Cr—12Ni—2.5Mo(SUS316)钢的焊接用以及工作温度600~750℃的化工、炼油热交换器管子、炉用管道。 10Cr-12Ni-2 5Mo (SUS316) used for welding steel, as well as operating Temperature of 600 ~ 750 chemical, oil refining tube heat exchangers, furnace tubes Peter.

铝焊丝

我们不仅采购质量优良的原材料，而且严格执行进厂检验，并不松懈的管理生产过程。结果是我们能够向客户提供洁净，均匀的铝焊丝。下列各种铝质焊丝都拥有优良的焊接性能，电弧稳定、飞溅少且小，焊缝成型良好，熔敷效率高。

Aluminium & Aluminium alloy welding Wires

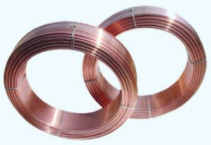
We use only high quality raw materials, check tightly against specification, and process through well controlled squences to produce clean and even Aluminium consumables for quality weld. All of below listed offer excellent welding performance, stable electric arc, little spatters, good welding seam forming and high deposition efficiency.

类别 Product	牌号 BRAND	标准及钢号 Standards and steel grade		Gauge Φ(mm)	焊丝化学成份（%） Welding wire Chemical Composition (%)									性能与用途 Application
		GB	AWS		Cu	Si	Fe	Mn	Mg	Cr	Zn	Ti	Al	
纯铝 Pure aluminum	YH-301	S301	ER1100	0.8-5.0	0.05～0.20	≤1.0	-	≤0.05	-	-	≤0.10	-	≥99.5	塑性好，耐蚀纯铝气焊或氩弧焊用 Good plasticity, primarily used for gas welding and argon-arc welding of corrosion-resisting pure aluminum.
铝合金 Corrosionresisting aluminum alloy	YH-331	S331	ER5183	0.8-5.0	≤0.10	≤0.40	≤0.40	0.05~1.00	4.3~5.2	0.05~0.25	≤ 0.25	≤0.15	Rem	强度高，耐蚀性，可焊性及塑性好，铝合金气焊或氩弧焊用 High strength, good corrosion resistance, primarily used for argon-arc welding of aluminum alloy.
	YH-5356	S5356	ER5356	0.8-5.0	≤0.10	≤0.25	≤0.40	0.05~0.20	4.5~5.5	0.05~0.20	≤0.10	0.06~0.20	Rem	耐蚀性好，强度高，通用性较好，铝合金氩弧焊用，特别适用于5083材料的焊接 Outstanding corrosion resistance, high strength, exceptional versatility, primarily used for argon-arc welding of aluminum alloy, especially for 5083 aluminum alloy.
	YH-311	S311	ER4043	0.8-5.0	≤0.30	4.5~6.0	≤0.80	≤0.05	≤0.05	-	≤0.10	≤0.20	Rem	耐蚀性好，通用性大，铝合气焊可氩弧焊用，不宜用于高镁合金焊接，用在4043材料的焊接效果更好 Outstanding corrosion resistance, exceptional versatility, primarily used for gas welding and MIG welding of aluminum alloy, especially good for 4043 aluminum alloy. Not recommended to use for welding of magnesium alloy.

碳钢埋弧焊丝

碳钢埋弧焊丝配用相应的焊剂可获得具有优良机械性能的金属焊接。具有生产效率高、焊接质量稳定、可靠等一系列的优点。

该系列焊丝主要适用于焊接各种低碳钢和低合金钢结构。如锅炉、核电站、化工容器、桥梁、船舶、压力容器等。



Carbon steel submerged arc welding wires

Carbon steel submerged arc welding wires are used with corresponding flux to get produce excellent seam. They have a series of advantages, such as high efficiency, stable welding quality, high depositing efficiency etc.

This series of welding wires can be used to welding important low carbon steel and low alloy steel structure , such as boilers, nuclear stations, chemical containers, ships, pressure vessels, etc.

牌号 Brand	标准及钢号 Standards and steel grade			Gauge Φ(mm)	焊丝化学成份(%) Welding wire chemical composition (%)								熔敷金属机械性能 Mechanical properties of deposited metal				性能与用途 Application
	GB	AWS	DIN/BS		C	Mn	Si	P	S	Cr	Ni	Cu	屈服强度 Yield Strength σs(Mpa)	抗拉强度 Tensile Strength σb(Mpa)	延伸率 Elongation δs(%)	V型冲击功 Akv impact J(℃)	
YH08A	H08A	EL8	S1	1.6-5.0	≤0.10	0.30-0.55	≤0.03	≤0.030	≤0.030	≤0.20	≤0.30	≤0.20	≥320	410-550	≥22	≥34(-20)	用于碳钢及低合金钢的焊接 Used to weld mild alloy steel like 09Mn、16Mn 、16MnCu etc.
YH08MnA	H08MnA	EM12	S2	1.6-5.0	≤0.10	0.80-1.10	≤0.07	≤0.030	≤0.030	≤0.20	≤0.30	≤0.20	≥320	410-550	≥22	≥34(0)	配合焊剂用于碳钢和强度级别低的合金钢如16Mn等制造的锅炉、压力容器的埋弧自动焊。 Tie in with the flux intensity for carbon steel and low-level such as 16 Mn alloy steel manufacturing, such as boilers, pressure vessels of the submerged arc welding.
YH08MnA	H08MnA	EM12K		1.6-5.0	0.05-0.15	0.80-1.25	0.10-0.35	≤0.030	≤0.030	≤0.20	≤0.30	≤0.20	≥320	410-550	≥22	≥ 34(0)	用于碳钢及相应级别的低合金钢结构的焊接 For carbon steel and low alloy steel structures of relevant strength grade
YH08Mn2SiA	H08Mn2SiA	-		1.6-5.0	≤0.11	1.80-2.10	0.65-0.95	≤0.030	≤0.030	≤0.20	≤0.30	≤0.20	≥372	480-600	≥22	≥47(ambient)	用于焊接低碳钢和低合金钢结构。配合SJ101、HJ251。 Used to welding mild steel or low alloy steel structure.Flux HJ260,SJ101,HJ251etc.
YH10Mn2	H10Mn2	EH14		1.6-5.0	≤0.12	1.50-1.90	≤0.07	≤0.035	≤0.035	≤0.20	≤0.30	≤0.20	≥420	410-550	≥22	≥34(-20)	用于碳钢和低合金钢如16Mn、14MnNb钢结构件的埋弧自动焊。 Used to automatically submerged arc welding for mild steel and low alloy steel like 16Mn, 14Mn Nb steel structrures.
YH10MnSi	H10MnSi	EM13K		1.6-5.0	≤0.14	0.80-1.10	0.60-0.90	≤0.035	≤0.035	≤0.20	≤0.30	0.20	≥320	410-550	≥22	≥ 27(0)	用于焊接重要的低碳钢及低合金钢结构的焊接如锅炉核电站容器、压力容器等 Important for the welding of low carbon steel and low alloy steel welded structure, such as boiler pressure vessel, such as nuclear power plant containers

药芯焊丝

"大运河"牌药芯焊丝包括气体保护药芯焊丝及自保护药芯焊丝两大类十多余个品种，应用于船舶、机械、建筑、钢结构、车辆、桥梁等多个领域。

Flux cored welding wire

Flux cored wire has been are designed to get a good usability in all position for wide range of welding currents,with its quiet and smooth arc, its slag detachability is very good.

Suitable for machinery,shipbuilding,bridges vehicle,architecture etc.

牌号 Brand	标准及钢号 Standards and steel grade		Gauge Φ(mm)	熔敷金属化学成份典型值 Typical chemical composition of All-weld-metal											熔敷金属机械性能典型值 Typical mechanical properties of All-weld-metal				性能与用途 Application
	GB	AWS		C	Mn	Si	P	S	Cr	Ni	Mo	V	Cu	Al	屈服强度 Yield Strength σs(Mpa)	抗拉强度 Tensile Strength σb(Mpa)	延伸率 Elongation δs(%)	V型冲击功 Akv impact J(℃)	
YHE71T-1	E501T-1	E71T-1	0.8-1.6	0.03	1.26	0.51	0.010	0.011	0.12	0.25	0.18	0.05	0.21	-	545	572	28	70(-20)	YHE71T--1是一种用CO2气体作为保护气体的钛型全方位的焊接药芯焊丝。具有优良的焊接工艺性能，电弧柔和稳定，飞溅少，烟尘低，焊道成型美观，脱渣容易，用于造船，钢结构，桥梁，建筑，机械和车辆等焊接。 Used for high efficiency welding in all positions with excellent welding performance such as warming electric arc,little spatters,beautiful seam forming,and easily moved slag,suitable for bridge, steel structure,architecture, machinery,vehicle etc.
YHE71T-GS	E501T-GS	E71T-GS	0.8-1.6	0.26	0.91	0.50	0.016	0.014	-	-	-	-	-	0.19	495	563	25	28(-40)	自保护药芯焊丝，能进行全方位焊接，适用于重要的低碳钢及低合金钢的焊接，可广泛应用于薄板单道焊，搭接，角接，对对接焊，也用于对冲击击任性没有要求的半自动焊接。 Self-shielded flux cored wire is used for important low carbon steel and low alloy steel in all position.Suitable for single pass welding of thin plate,fillet welding,butt welding and semi-automatic welding that impact tenacity is not applicable.
YHE71TNi	E501T-1L	E71T-1J	0.8-1.6	0.05	1.30	0.45	0.015	0.010	-	0.40	-	-	-	-	500	570	28	100(-30)	具有优良的焊接工艺性能，电弧柔和稳定，飞溅少，烟尘低，焊道成型美观，脱渣容易，用于船体，海洋平台，容器，管道等的焊接。 Used for high efficiency weding in all positions with excellent welding performance such as warming electric arc,little spatters,beautiful seam forming and easily moved slag,suitable for ship making,ocean platform, vehicle and pipes etc.
YH811Ni 2	E551T-Ni2	E81T1-Ni2	0.8-1.6	0.08	1.25	0.80	0.015	0.010	-	2.0	-	-	-	-	540	620	25	60(-40)	具有优良的焊接工艺性能，电弧柔和稳定，飞溅少，烟尘低，焊道成型美观，脱渣容易，用于590Mpa级高强度钢之机器结构物，钢结构，桥梁，储槽及管道，铁路车辆，土建设备等的焊接。 Used for high efficiency weding in all positions with excellent welding performance such as warming electric arc,little spatters,beautiful seam forming and easily moved slag,suitable for welding of 590Ma high strength steel,steel structure,bridge,steel pipes,railway vehicle, and construction equipment etc.

CO2气体保护焊丝

CO2气体保护焊丝具有良好的工艺性能，熔化速度快，熔敷效率高，电弧飞溅极小，焊缝均匀美观，适合于全位置的焊接。

该系列焊丝主要适用于焊接低碳钢和低合金钢结构，如船舶、车辆、桥梁、工程机械、锅炉、建筑等。

CO2 gas shielding welding wires

Copper coated gas shielding welding wire is suitable for 100% CO2 or argon & CO2 mixed gas protective welding with excellent mechanical performance such as fast melting rate, high depositing efficiency, stable arc, little spatter, beautiful seam. Suitable for all-position welding work.

The series of welding wires can be used to welding low carbon steel and low alloyed steel structure, such as ships, vehicles, bridges, boilers and buidings construction machine,rail way construction.

This series of welding wires has different kinds of packing,such as different types of plastic spools,metal spools and pail packages and straightened wire in plastic tube.

牌号 Brand	标准及钢号 Standards and steel grade			Gauge Φ(mm)	焊丝化学成份(%) Welding wire chemical composition (%)										熔敷金属机械性能 Mechanical properties of deposited metal					性能与用途 Application
	GB	AWS	DIN		C	Mn	Si	P	S	Cr	Ni	Mo	Ti	Cu	屈服强度 Yield Strength σs(Mpa)	抗拉强度 Tensile Strength σb(Mpa)	延伸率 Elongation δ5(%)	V型冲击功 Akv impact J(℃)	保护气体 Shielded gas	
YH49-1	ER49-1	-		0.8-1.6	≤0.11	1.80-2.10	0.65-0.95	≤ 0.030	≤0.030	≤0.20	≤ 0.30	-		≤ 0.50	≥ 372	≥ 490	≥ 20	≥ 47 (room temperature)	CO2	适用于船舶用钢（A32、E32、D32、A36、E36、D36）及强度为490N/mm2级的普通低碳钢，低合金钢16Mn、15Mn等制造的船用锅炉、船用管道、船用齿轮、甲板、集装箱的CO2气体保护半自动和自动焊接。 Used to welding steel for ship building(A32、E32、D32、A36、E36、D36)and mild steel products with strength at 490N/mm2 degree,such as mild alloy steel 16Mn 、15Mn ect to produce furnace,tubes for vessel,containec building etc.etc.
YH50-3	ER50-3	ER70S-3		0.8-1.6	0.06-0.15	0.90-1.40	0.45-0.75	≤ 0.025	≤ 0.035	-	-	-	-	≤ 0.50	≥ 420	≥ 500	≥ 22	≥27(-20)	Ar+CO2	490 N/mm2级高张力钢用，高速薄板焊接，通常被用于35，45，号钢 490 N/mm2 grade high tension steel, high-speed sheet metal welding, often used in steel35,45.
YH50-6 (G3Si1)	ER50-6	ER70S-6	SG2	0.8-1.6	0.06-0.15	1.40-1.85	0.80-1.15	≤0.025	≤0.035	-	-	-	-	≤0.50	≥ 420	≥ 500	≥ 22	≥27(-30)	Ar+CO2	适用于船舶用钢（A，B，D，E，A36，D36，E36）和相同等级强度的低合金钢重要结构的焊接，如集装箱，车辆，建筑机械的气体保护半自动和自动焊接 Apply to ships of steel(A, B, D, E, A36, D36, E36) and at the same level of intensity of low-alloy steel welding important structures. Such as containers, vehicles, construction machinery, semi-automatic and automatic gas shielded welding
YH50-6 (G4Si1)	ER50-6	ER70S-6	SG3	0.8-1.6	0.06-0.14	1.60-1.90	0.80-1.20	≤0.025	≤0.025	-	-	-	-	≤0.50	≥ 420	≥ 500	≥ 20	≥47(-20)	Ar+CO2	
YH-60	-	-		1.2-5.0	≤ 0.12	1.40-1.80	0.50-0.80	≤ 0.025	≤0.020	≤0.45	-	≤0.30	0.012	≤0.20	≥ 450	≥ 570	≥ 19	≥27(-20)	CO2	适用于焊接煤矿机械，重工机械，石油管道等。 Used to coal machinery and heavy machinery for welding,oil pipelines etc.
YH-70	-	-		1.2-5.0	0.07	1.56	0.55	0.012	0.003	0.07	0.94	-	0.012	0.15	≥ 530	≥ 650	≥ 20	≥ 40(-30)	CO2	适用于焊接煤矿机械，重工机械，石油管道等。 Used to coal machinery and heavy machinery for welding,oil pipelines etc.

不锈钢焊丝
Stainless steel welding wires

牌号 Brand	AWS A5.9-93	GB/T 17854-99 (YB/T 5092-96)	JIS Z3321-99	熔敷金属机械性能 Mechanical properties of deposited metal		焊丝化学成份一例 (%) Typical Welding wire chemical composition(%)							性能与用途 Features and Applications
				抗拉强度 Tensile strength (MPa)	延伸率 Elongation δ5(%)	C	Si	Mn	Cr	Ni	Mo	其它 Other	
YH-316LSi	ER316LSi	-	-	562	31	0.021	0.77	1.95	19.2	13.45	2.58	-	高Si—低C—18Cr—12Ni+2.5MO钢用，其它同MIG316L Primarily used for welding of high silicon, low carbon, 18Cr-12Ni-2.5Mo steels.
YH-317	ER317	H0Cr19Ni14Mo3	Y317	598	42	0.048	0.45	1.86	19.41	14.23	3.51	-	18Cr—12Ni—3 5Mo钢用，Mo含量较高，对硫酸、亚硫酸等非氧化性及有机酸有优良的耐腐蚀性，其耐腐蚀及耐热性甚佳，适用重要化学容器的焊接 Primarily used for welding of 18Cr-12Ni-3.5Mo steels. With outstanding resistance to sulphuric acid, sulphurous acid and other organic acids, exceptional resistance to pitting corrosion and heat, the welding wires are especially suitable for welding of chemical containers.
YH-317L	ER317L	H00Cr19Ni14Mo3	Y317L	568	42	0.023	0.40	1.76	19.60	13.68	3.63	-	低C—18Cr—12Ni—3 .5Mo钢用，低碳高钼，防止粒间腐蚀，焊接后免热处理，高温强度大，为抗硫酸，亚硫酸及有机酸的抗蚀专用焊丝 Primarily used for welding of low carbon 18Cr-12Ni-3.5Mo steels, low carbon and high molybdenum steels. The welding wires can avoid intergranular corrosion. Finished welded parts can free heat treatment. The welding wires have high-temperature strength and outstanding resistance to sulphuric acid, sulphurous acid and other organic acids .
YH-321	ER321	H0Cr20Ni10Ti	Y321	562	39	0.062	0.49	1.74	19.50	9.57	-	Ti:0.82	20Cr—10Ni—Ti钢用，由于Ti的加入，大大提高了抗晶间腐蚀力 Primarily used for welding of 20Cr-10Ni-Ti steels. Thanks to Ti added, the welding wires have greatly increased resistance to intercrystalline corrosion.
YH-347	ER347	H0Cr20Ni10Nb	Y347	627	41	0.030	0.41	1.61	20.37	9.90	-	Nb:0.80	18Cr—9Ni—Ti钢用，添加Nb使其熔敷金属抗粒间腐蚀性增加，高温强度好，特别适用于耐热钢的焊接 Primarily used for welding of 18Cr-9Ni-Ti steels. Thanks to Nb added, the welding wires have greatly increased resistance to intereranular corrosion and outstanding high-temperature strength. especially suitable for welding of high temperature resisting steels.
YH-410	ER410	H1Cr13	Y410	510	25	0.100	0.45	0.43	11.81	0.17	-	-	13Cr钢用，熔敷金属为13Cr，硬化性大，在高温下有优异的耐氧化性，和耐用腐蚀性，适用于ALS1410或420的焊接 Primarily used for welding of 13Cr steels. Deposited metals are 13Cr with large harden ability. Thanks to outstanding resistance to oxidation and corrosion at high temperature. the welding wires are especially suitable for welding of AIS1410 or 420
YH-430	ER430	H1Cr17	Y430	585	36	0.083	0.39	0.46	16.37	0.20	-	-	17Cr钢用，特别适用于硝酸容器之焊接 Primarily used for welding of 17Cr steels, especially suitable for welding of nitric acid containers.
YH-502	ER502	H1Cr5Mo	-	608	34	0.084	0.42	0.53	5.60	0.37	0.59	-	1Cr5Mo钢用，通常用于管道与管道的焊接，其具有空冷淬硬的特性，焊接时要求预热及焊后热处理 Primarily used for welding of 1Cr5Mo steels, suitable for welding among pipes. Pre-heating and post-heating for welding are required.