

BOCAST®

博科丝特焊材

焊接材料产品手册

BOCAST WELDING MATERIAL

专业焊材 锐意创新

Welding Materials Dedicated to Innovation

诚信执行 用户至上

Integrity in Execution Customer First

技术服务 Technology: 18962025333

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本介绍书涉及的相关数据、统计资料、调查结果均来自于博科丝特焊接实验室。本手册涉及的个别用于博科丝特焊接产品描述的极限词语，仅在博科丝特焊接公司的产品范围内进行比对，不涉及于任何其他公司产品的比较，且仅面向博科丝特焊接客户作为产品使用的技术性概括指导，本介绍书内均为非标产品，具体产品外观以实际交付为准。所有设备使用前需详细阅读产品使用说明书中的安全说明。



博科丝特（上海）焊接科技有限公司

BOCAST (SHANGHAI) WELDING TECHNOLOGY CO., LTD

2025

锐意创新 特种焊材 成就卓越**专业焊材制造厂家 支持定制**

博科丝特焊接科技（江苏）有限公司，地处经济发达的长三角地区。公司是一家专业从事各类焊接材料研发、生产和销售为一体的综合型企业。是武汉科技大学焊接材料的研发转化基地。主要产品包括：不锈钢焊条、非合金钢焊条、镍及镍基焊条；药芯焊丝、实心焊丝和焊剂等。其中的高锰奥氏体低温钢焊条，填补了国内关键材料领域内产业发展的空白，被应用在 LNG 储罐及压力容器等领域。

Bocast Welding Technology (Jiangsu) Co., Ltd. is located in the economically developed Yangtze River Delta region. We are a comprehensive enterprise specializing in the research and development, production, and sales of various welding materials. We are the research and development transformation base of welding materials of Wuhan University of Science and Technology. The main products include: stainless steel electrodes, non-alloy steel electrodes, nickel and nickel-based electrodes; Flux-cored wires, solid wires and fluxes, etc. The high manganese austenitic low-temperature steel welding rod has filled the gap in the industrial development of key materials in China, and is used in LNG storage tanks, pressure vessels, etc...

**高频红外碳硫仪**

High - frequency infrared carbon - sulfur analyzer

**直读光谱仪**

Direct - reading spectrometer

**荧光光谱仪**

Fluorescence spectrometer

**维氏硬度计**

Vickers hardness tester

**拉伸试验机**

Tensile testing machine

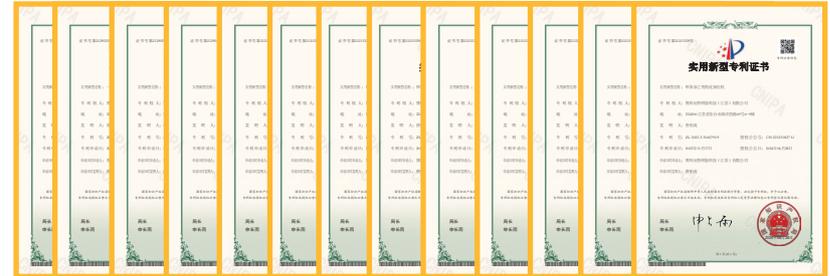
**冲击试验机**

Impact testing machine

高频红外碳硫仪

High - frequency infrared carbon - sulfur analyzer

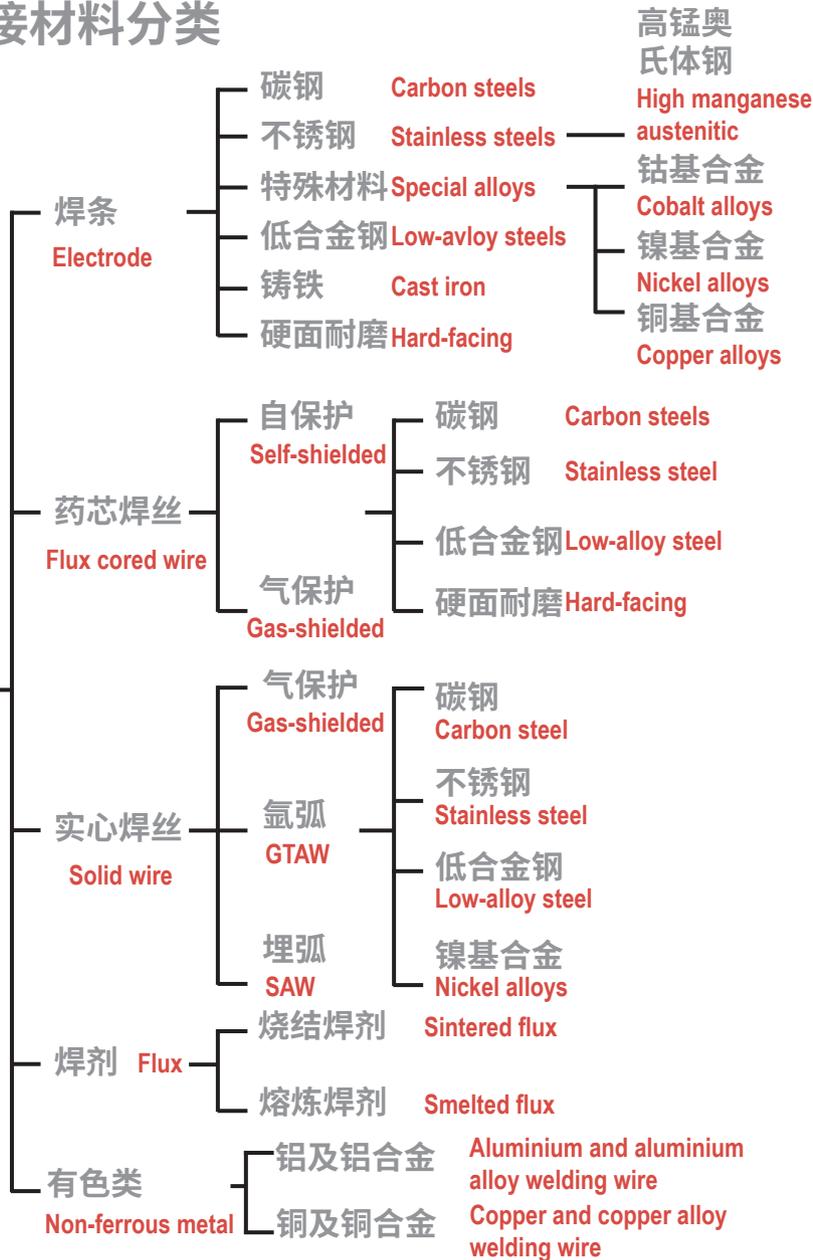
直读光谱仪
Direct - reading spectrometer荧光光谱仪
Fluorescence spectrometer维氏硬度计
Vickers hardness tester拉伸试验机
Tensile testing machine冲击试验机
Impact testing machine



Classification of Welding Materials

焊接材料分类

博科丝特焊接材料总览
Overview of Bocast Welding Materials



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List of Product Models and Standards 产品型号及标准一览表

品名	GB 规格	AWS 规格	ISO 规格	页码
高锰奥氏体钢焊条				
BC-EHMn				15
镍及镍合金焊条				
	T13814	A5.11	14172	
BC-NiCrFe-1	ENi6062	ENiCrFe-1	ENi6062	17
BC-NiCrFe-2	ENi6133	ENiCrFe-2	ENi6133	19
BC-NiCrFe-3	ENi6182	ENiCrFe-3	ENi6182	21
BC-NiCrMo-3	ENi6625	ENiCrMo-3	ENi6625	23
BC-NiCrMo-4	ENi6276	ENiCrMo-4	ENi6276	25
BC-NiCrMo-6	ENi6620	ENiCrMo-6	ENi6620	27
	T10044	A5.15	1071	
BC-Z208	EZC			29
BC-Z308	EZNi-1	ENi-CI		31
BC-Z408	EZNiFe-1	ENiFe-CI	ECNiFe-CI 1	33
BC-Z508	ECNiCu-1	ENiCu-B	E C NiCu-B	35
不锈钢焊条				
	T983	A5.4	3581	
BC-E308-16 (A102)	E308-16	E308-16	B-ES308-16	37
BC-E308-15 (A107)	E308-15	E308-15	B-ES308-15	39
BC-E308L-16 (A002)	E308L-16	E308L-16	A-E(19 9 L)R3 2	41
BC-E308L-15 (A007)	E308L-15	E308L-15	B-ES308L-15	43
BC-E309-16 (A302)	E309-16	E309-16	B-ES309-16	45
BC-E309-15 (A307)	E309-15	E309-15	B-ES309-15	47
BC-E309Mo-16 (A312)	E309Mo-16	E309Mo-16	B-ES309Mo-16	49
BC-E309LMo-16 (A042)	E309LMo-16	E309LMo-16	B-ES309LMo-16	51
BC-E309L-16 (A062)	E309L-16	E309L-16	B-ES309L-16	53
BC-E309L-15 (A067)	E309L-15	E309L-15	B-ES309L-15	55
BC-E310-16 (A402)	E310-16	E310-16	B-ES310-16	57
BC-E310-15 (A407)	E310-15	E310-15	B-ES310-15	59
BC-E310Mo-16 (A412)	E310Mo-16	E310Mo-16	B-ES310Mo-16	61

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品名	GB 规格	AWS 规格	ISO 规格	页码
不锈钢焊条				
	T983	A5.4	3581	
BC-E316-16 (A202)	E316-16	E316-16	B-ES316-16	63
BC-E316-15 (A207)	E316-15	E316-15	B-ES316-15	65
BC-E316L-16(A022)	E316L-16	E316L-16	B-ES316L-16	67
BC-E316L-15 (A027)	E316L-15	E316L-15	B-ES316L-15	69
BC-E347-16 (A132)	E347-16	E347-16	B-ES347-16	71
BC-E347-15 (A137)	E347-15	E347-15	B-ES347-15	73
BC-E347L-16	E347L-16	E347-16	B-ES347L-16	75
BC-E2209-16	E2209-16	E2209-16	B-ES2209-16	77
BC-E2594-16	E2594-16	E2594-16		79
耐热钢焊条				
	T5118	A5.5	3580	
BC-R107	E5015-1M3	E7015-A1	B-E4915-1M3	81
BC-R106Fe	E5018-1M3	E7018-A1	B-E4918-1M3	83
BC-R207	E5515-CM		B-E5515-CM	85
BC-R307	E5515-1CM	E8015-B2	B-E5515-1CM	87
BC-R306Fe	E5518-1CM	E8018-B2	B-E5518-1CM	89
BC-R317	E5515-1CMV		B-E5515-G	91
BC-R327	E5515-1CMWV		B-E5515-G	93
BC-R337	E5515-1CMVnb		B-E5515-G	95
BC-R347	E5515-2CMWVB		B-E5515-G	97
BC-R406	E6216-2C1M	E9016-B3	B-E6216-2C1M	99
BC-R407	E6215-2C1M	E9015-B3	B-E6215-2C1M	101
BC-R406Fe	E6218-2C1M	E9018-B3	B-E6218-2C1M	103
BC-R417	E5515-2CMVnb		B-E5515-G	105
BC-R717	E6215-9C1MV	E9015-B9	B-E6215-9C1MV	107
堆焊焊条				
	T984			
BC-D212	EDPCrMo-A4-03			109
BC-D256	EDMn-A-16			111
BC-D507	EDCr-A1-15			113
BC-D507Mo	EDCr-A2-15			115

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品名	GB 规格	AWS 规格	ISO 规格	页码
堆焊焊条				
	T984			
BC-D577	EDCrMn-C-15			117
BC-D608	EDZ-A1-08			119
BC-D707	EDW-A-15			121
碳钢焊条				
	T 5117	A5.1	2560	
BC-E6013(J421)	E4313	E6013	B-E4313 A	123
BC-J421Fe18	E4324		B-E4324 A	125
BC-J422	E4303		B-E4303 A	127
BC-J423(E6019)	E4319	E6019	B-E4319 A	129
BC-J424(E6020)	E4320	E6020	B-E4320 A	131
BC-J424Fe16(E6027)	E4327	E6027	B-E4327A	133
BC-J426	E4316		B-E4316 A	135
BC-J427	E4315		B-E4315 A	137
BC-J501Fe(E7014)	E5014	E7014	B-E4914 A	139
BC-J501Fe18(E7024)	E5024	E7024	B-E4924 A	141
BC-J502	E5003		B-E4903 A	143
BC-J502WCu	E5003-G			145
BC-J506(E7016)	E5016	E7016	B-E4916 A	147
BC-E7018(J506Fe)	E5018	E7018	B-E4918 A	149
BC-J506Fe16(E7028)	E5028	E7028	B-E4928 A	151
BC-J507(E7015)	E5015	E7015	B-E4915 A	153
BC-J507RH	E5015-G	E7015-G	B-E4915 -GPU	155
BC-E6010	E4310	E6010	B-E 43 10 A	157
BC-E6011	E4311	E6011		159
BC-E7010	E5010-P1	E7010-P1	B-E 49 10-P1A	161
BC-E8010	E5510-P1	E8010-P1	B-E 55 10-P1 A	163
碳钢药芯焊丝				
	T10045	A5.20	17632	
BC-E70T-1C	T49 2 T1-0 C1A	E70T-1C	B-T492T1-0C1A	165
BC-E70T-5C	T49 3 T5-0 C1A	E70T-5C	B-T493T5-0C1A	167
BC-E71T-1C	T49 2 T1-1C1 A	E71T-1C	A-T422PC11	169

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碳钢药芯焊丝				
	T10045	A5.20	17632	
BC-E71NiT-1C	T49 4 T1-1 C1 A	E71T-1C-J	A-T42 4 P C1 1	171
BC-E71T-GS	T49TG-1NS	E71T-GS	A:T3T ZV NO	173
BC-E70T-4	T49 Z T4-0 N A	E70T-4	A:T42 Z Y NO3	175
BC-E70T-7	T49 Z T7-0 N A	E70T-7	A:T42 ZY NO 3	177
	T10045	A5.29	17632	
BC-E81T1-K2C	T55 6 T1-1 C1 A-N3	E81T1-K2C	A:T46 6 1.5Ni P C1 1	179
BC-E81T1-Ni1C	T55 4 T1-1 C1 A-N2	E81T1-Ni1C	A:T46 4 1Ni P C1 1	181
不锈钢药芯焊丝				
	T 17853	A5.22	17633	
BC-E308T1-1	TS308-FC1 1	E308T1-1		183
BC-E308LT1-1	TS308L-FC1 1	E308LT1-1	A-T 19 9 L P C1 1	185
BC-E309LT1-1	TS309L-FC1 1	E309LT1-1	A-T 23 12 L P C1 1	187
BC-E309LMoT1-1	TS309LMo-FC11	E309LMoT 1-1	A:T 23 12 2LP C11	189
BC-E347T1-1	TS347-FC1 1	E347T1-1		191
BC-E347LT1-1	TS347L-FC1 1	E347T1-1	A:T19 9 Nb P C1 1	193
BC-E316T1-1	TS316-FC1 1	E316T1-1		195
BC-E316LT1-1	TS316L-FC1 1	E316LT1-1	A:T 19 12 3 L R C11	197
BC-E2209T1-1	TS2209-FC1 1	E2209T1-1	A:T22 9 3NLPC11	199
BC-E2594T1-1	TS2594-FC1 1	E2594T1-1	A:T2594NLPC11	201
堆焊药芯焊丝				
BC-D212				203
BC-D218				205
BC-D256				207
BC-D507				209
BC-D507Mo				211
BC-D517				213
BC-D688				215
BC-D707				217

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碳钢实心焊丝				
	T8110	A5.18		
BCM-49-1	ER49-1			219
BCT-49-1	ER49-1	ER70S-G		221
BCM-50-G	ER50-G	ER70S-G		223
BCT-50-G	ER50-G	ER70S-G		225
BCM-50-3	ER50-3	ER70S-3		227
BCT-50-3	ER50-3	ER70S-3		229
BCM-50-6	ER50-6	ER70S-6		231
BCT-50-6	ER50-6	ER70S-6		233
低合金钢实心焊丝				
	T 8110	A5.28		
BCM-55-B2	ER55-B2-MnV	ER80S-G		235
BCT-55-B2	ER55-B2-MnV	ER80S-G		237
BCM-55-G	ER55-G	ER80S-G		239
BCT-55-G	ER55-G	ER80S-G		241
BCM-62-G	ER62-G	ER90S-G		243
BCT-62-G	ER62-G	ER90S-G		245
不锈钢实心焊丝				
	T29713	A5.9	14343	
BCM-307·BCT-307	S307	ER307	B-SS307	247
BCM-307Si			A-G 18 8Mn	249
BCM-308·BCT-308		ER308		251
BCM-308L·BCT-308L		ER308L		253
BCM-308LSi·BCT-308LSi		ER308LSi		255
BCM-309·BCT-309		ER309		257
BCM-309L·BCT-309L		ER309L		259

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品名	GB 规格	AWS 规格	ISO 规格	页码
不锈钢实心焊丝				
	T29713	A5.9	14343	
BCM-309LSi BCM-309LSi		ER309LSi		261
BCM-310·BCT-310		ER310	B-SS310	263
BCM-316·BCT-316		ER316		265
BCM-316L·BCT-316L		ER316L		267
BCM-316LSi BCM-309LSi		ER316LSi		269
BCM-2209·BCT-2209		ER2209	B-SS2209	271
埋弧焊丝				
	T 5293	A5.17	14171	
BC-H08A	SU08A SU08E	EL12/EL8	B-SU11/A-S1	273
BC-H08MnA	SU26	EM12	B-SU22/A-S2	275
BC-H10Mn2	SU34	EH14/EL8	B-SU33/A-S4	277
BC-EM12K	SU21	EM12K	A-S2Si1	279
BC-H08MnMoA	SUM3		B-SU3M3	281
	T 12470	A5.17		
BC-13CrMoA	SU1CM3			283
BC-1CM		A5.23 EB2		285
BC-2CM		A5.23 EB3		287
烧结焊剂				
	T 5293	A5.17M		
BC-SJ101	S43A2FB-SU26 S49A4FB-SU34	F7A2-EM12 F7A4-EH14		289
BC-SJ101Q	S49A4UFB-SU34 A55A4UFB-SU4M1	F7A4-EH14		291
BC-SJ101G	S49A4UFB-SU34	F7A4-EH14		293
BC-SJ301	S39A0SC-SU08 S43A2SC-SU26			295
BC-SJ201	S49A2UAB-SU28 S49A4UAB-SU34	F7A2-EM12 F7A4-EH14		297

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产品型号及标准一览表

品名	GB 规格	AWS 规格	ISO 规格	页码
烧结焊剂				
	T 5293	A5.17M		
BC-SJ501	S43A0AR-SU08 S49A3AR-SU26	F6A0-EL8 F7A2-EM12K		299
	T 17854			
BC-SJ414N	F308-H0Cr21Ni10 F410-HCr13			301
BC-SJ102	F308-H0Cr21Ni10 F410-H1Cr13			303
熔炼焊剂				
	T 17854			
BC-HJ107	SF308AAS-S308 SF308LAAS-S308L			305
BC-HJ260	SF308AAS-S308 SF410AAS-S410			307
	T5293			
BC-HJ431	S43A0UMS-Su26			309
BC-HJ350	S49S2MS-Su34			311
铝及铝合金焊丝				
	T 10858	A5.10	18273	
BCM-AI1070 BCT-AI1070	SAI 1070(AI99.7)	ER1070	S AI 1070(AI99.7)	313
BCM-AI1100 BCT-AI1100	S A I 1 1 0 0 (A I 99.0Cu)	ER1100	S AI 1100 (AI 99.0Cu)	315
BCM-AI4043 BCT-AI4043	SAI 4043(AISi5)	ER4043	S AI 4043(AISi5)	317
BCM-AI4047 BCT-AI4047	SAI 4047(AISi12)	ER4047	SAI 4047(AISi12)	319
BCM-AI5183 BCT-AI5183	SAI 5183 [AlMg4.5Mn0.7(A)]	ER5183	S AI 5183 [AlMg4.5Mn0.7(A)]	321
BCM-AI5356 BCT-AI5356	AI5356 [AlMg5Cr(A)]	ER5356	AI5356[AlMg5Cr(A)]	323
BCM-AI5087 BCT-AI5087	AI5087 (AlMg4.5MnZr)	ER5087	AI5087 (AlMg4.5MnZr)	325

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产品型号及标准一览表

品名	GB 规格	AWS 规格	ISO 规格	页码
铝及铝合金焊丝				
	T 10858	A5.10	18273	
BCM-AI5554 BCT-AI5554	SAI 5554 (AlMg2.7Mn)	ER5554	SAI 5554 (AlMg2.7Mn)	327
BCM-AI5556 BCT-AI5556	SAI 5556 (AlMg5Mn1Ti)	ER5556	SAI 5556 (AlMg5Mn1Ti)	329
BCM-AI5556A BCT-AI5556A	AI5556A (AlMg5Mn)		AI5556A (AlMg5Mn)	331
铜及铜合金焊丝				
	T 9460	A5.7	24373	
BCM-Cu1898 BCT-Cu1898	SCu1898 (CuSn1)	ERCu	SCu1898 (CuSn1)	333
BCM-Cu6560 BCT-Cu6560	SCu6560 (CuSi3Mn)	ERCuSi-A	SCu6560 (CuSi3Mn)	335
BCM-Cu5180 BCT-Cu5180	SCu5180 (CuSn5P)	ERCuSn-A	SCu5180 (CuSn5P)	337
BCM-Cu5210 BCT-Cu5210	SCu5210 (CuSn8P)	ERCuSn-C	SCu5210 (CuSn8P)	339
BCM-Cu6100 BCT-Cu6100	SCu6100 (CuAl7)	ERCuAl-A1	SCu6100 (CuAl7)	341
BCM-Cu6180 BCT-Cu6180	SCu6180 (CuAl10Fe)	ERCuAl-A2	SCu6180 (CuAl10Fe)	343
BCM-Cu6810A BCT-Cu6810A	SCu6810A (CuZn40SnSi)			345
BCT-Cu6810	SCu6810 (CuZn40Fe1Sn1)			347
BCT-Cu4700	SCu4700 (CuZn40Sn)			349
BCM-Cu7730 BCT-Cu7730	SCu7730 (CuZn40Ni10)			351
BCM-Cu7158 BCT-Cu7158	SCu7158 (CuNi30Mn1FeTi)	ERCuNi	SCu7158 (CuNi30Mn1FeTi)	353
BCM-Cu7061 BCT-Cu7061	SCu7061 (CuNi10)		SCu7061 (CuNi10)	355

BC-EHMn

产品说明：

- 熔敷金属超低温力学性能稳定，成型性好、脱渣性好，可用于全位置焊接。
- 可用于焊接液化气体储运装置等、低温压力容器用高锰奥氏体钢板。

符合标准：

- T/SSEA 0132 EHMn16(15)

熔敷金属化学成分（质量分数）：%

	C	Cr	Mo	Mn	Si	S	P	Ni	W
标准值	≤ 0.60	≤ 5.50	≤ 5.00	18.00-26.00	≤ 0.65	≤ 0.02	≤ 0.02	≤ 9.00	≤ 4.00
例值	0.513	4.087	0.024	23.990	0.236	0.002	0.014	0.189	-

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	-196°C冲击功 KV ₂ (J)
标准值	≥ 660	≥ 400	≥ 30	≥ 41
例值	867	487	59	95

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2
焊条长度 (mm)	300	320
焊接电流 (A)	70-110	100-140

BC-EHMn

Product Description:

- The ultra-low temperature mechanical properties of deposited metal are stable, with good formability and slag removal, and can be used for all position welding.
- It can be used for welding liquefied gas storage and transportation equipment, etc., and high-manganese austenitic steel plates for cryogenic pressure vessels.

Compliant with standards:

- T/SSEA 0132 EHMn16(15)

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Cr	Mo	Mn	Si	S	P	Ni	W
Standard value	≤ 0.60	≤ 5.50	≤ 5.00	18.00-26.00	≤ 0.65	≤ 0.02	≤ 0.02	≤ 9.00	≤ 4.00
Example value	0.513	4.087	0.024	23.990	0.236	0.002	0.014	0.189	-

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength Rp0.2 (MPa)	Elongation A(%)	Impact energy at -196°C KV ₂ (J)
Standard value	≥ 660	≥ 400	≥ 30	≥ 41
Example value	867	487	59	95

Reference current:（DC⁺）

Diameter (mm)	2.5	3.2
Length (mm)	300	320
Welding current (A)	70-110	100-140

BC-NiCrFe-1

产品说明：

- 低氢钠型镍合金用焊条，名义成分（重量百分比）是 70Ni-15Cr-8Fe-3.5Mn-2.5Nb(Cb)+Ta，为镍 - 铬 - 铁系合金焊条。由于合金成分含量高，可适应低温到 980°C 的温度范围；但温度高于 820°C 时，抗氧化性和强度会有劣化。抗气孔性佳，熔敷金属的机械性能稳定。
- 用于镍 - 铬 - 铁系合金焊接，如 Inconel600 类似合金、ASTM B163 等；也可用于钢和镍基合金的异材焊接。

符合标准：

- GB/T 13814 ENi6062·AWS A5.11 ENiCrFe-1·ISO 14172: E Ni 6062

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S
标准值	≤ 0.08	≤ 3.5	≤ 0.80	13.0-17.0	≥ 62	≤ 11.0	0.5-4.0	≤ 0.02	≤ 0.015
例值	0.048	2.97	0.34	15.6	69.6	8.94	2.65	0.005	0.007

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 360	≥ 27
例值	665	435	43

参考电流：(DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	
焊条长度 (mm)	300	350	350	
焊接电流 (A)	平 / 横焊	69-95	70-115	95-145
	立 / 仰焊	55-80	65-110	80-130

BC-NiCrFe-1

Product Description:

- Welding rod for low hydrogen sodium nickel alloy, with a nominal composition (weight percentage) of 70Ni-15Cr-8Fe-3.5Mn-2.5Nb(Cb)+Ta, belonging to nickel-chromium-iron-based alloy electrodes. Due to the high content of alloying elements, it can adapt to a temperature range from low temperature to 980° C; however, when the temperature exceeds 820° C, its oxidation resistance and strength will deteriorate. It has excellent anti-porosity properties, and the mechanical properties of the deposited metal are stable.
- It is used for welding nickel-chromium-iron based alloys, such as Inconel600 similar alloys, ASTM B163, etc.; it can also be used for dissimilar material welding between steel and nickel-based alloys.

Compliant with standards:

- GB/T 13814 ENi6062·AWS A5.11 ENiCrFe-1·ISO 14172: E Ni 6062

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S
Standard value	≤ 0.08	≤ 3.5	≤ 0.80	13.0-17.0	≥ 62	≤ 11.0	0.5-4.0	≤ 0.02	≤ 0.015
Example value	0.048	2.97	0.34	15.6	69.6	8.94	2.65	0.005	0.007

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 360	≥ 27
Example value	665	435	43

Reference current：(DC⁺)

Diameter (mm)	2.5	3.2	4.0	
Length (mm)	300	350	350	
Welding current (A)	flat/horizontal welding	69-95	70-115	95-145
	vertical/overhead welding	55-80	65-110	80-130

BC-NiCrFe-2

产品说明：

- 低氢钠型镍合金用焊条，名义成分（重量百分比）是 70Ni-15Cr-8Fe-2Mn-2Nb+Ta-1.5Mo，为镍 - 铬 - 铁系合金焊条。母材可以是锻造或铸造的（可焊级），可适应低温到 980°C 的温度范围；但温度高于 820°C 时，抗氧化性和强度会有劣化。抗气孔性佳，熔敷金属的机械性能稳定，并具有优异的低温冲击及耐高温氧化性能。
- 用于镍 - 铬 - 铁系合金焊接，如 Incoloy800、800H 合金，Inconel600、601 合金，ASTM B163 等；也可用于 9%Ni 钢和各种异种金属接头的异材焊接及抗蠕变焊接的接头。0 类似合金、ASTM B163 等；也可用于钢和镍基合金的异材焊接。

符合标准：

- GB/T 13814 ENi6133·AWS A5.11 ENiCrFe-2·ISO 14172: E Ni 6133

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S	Mo
标准值	≤ 0.10	1.0-3.5	≤ 0.80	13.0-17.0	≥ 62	≤ 12.0	0.5-3.0	≤ 0.02	≤ 0.015	0.5-3.0
例值	0.036	3.19	0.48	14.6	70.8	7.04	1.67	0.009	0.003	1.63

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 360	≥ 27
例值	660	430	44

参考电流：（DC⁺）

焊条直径 (mm)		2.5	3.2	4.0
焊条长度 (mm)		300	350	350
焊接电流 (A)	平 / 横焊	69-95	70-115	95-145
	立 / 仰焊	55-80	65-110	80-130

BC-NiCrFe-2

Product Description:

- Welding rod for low hydrogen sodium nickel alloy, with a nominal composition (weight percentage) of 70Ni-15Cr-8Fe-2Mn-2Nb+Ta-1.5Mo, belonging to nickel-chromium-iron-based alloy electrodes. The base metal can be forged or cast (weldable grade), and it can adapt to a temperature range from low temperature to 980° C; however, when the temperature exceeds 820° C, the oxidation resistance and strength will deteriorate. It has excellent anti-porosity properties, stable mechanical properties of the deposited metal, and outstanding low-temperature impact and high-temperature oxidation resistance.
- It is used for welding nickel-chromium-iron based alloys, such as Incoloy 800, 800H alloys, Inconel 600, 601 alloys, ASTM B163, etc.; it can also be used for dissimilar metal welding of 9% Ni steel and various dissimilar metal joints, as well as creep-resistant welded joints.

Compliant with standards:

- GB/T 13814 ENi6133·AWS A5.11 ENiCrFe-2·ISO 14172: E Ni 6133

Chemical Composition of Deposition Metal (Mass Fraction):%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S	Mo
Standard value	≤ 0.10	1.0-3.5	≤ 0.80	13.0-17.0	≥ 62	≤ 12.0	0.5-3.0	≤ 0.02	≤ 0.015	0.5-3.0
Example value	0.036	3.19	0.48	14.6	70.8	7.04	1.67	0.009	0.003	1.63

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 360	≥ 27
Example value	660	430	44

Reference current:（DC⁺）

Diameter (mm)		2.5	3.2	4.0
Length (mm)		300	350	350
Welding current (A)	flat/horizontal welding	69-95	70-115	95-145
	vertical/overhead welding	55-80	65-110	80-130

BC-NiCrFe-3(Ni307-3)

产品说明：

- 低氢钠型镍合金用焊条，名义成分（重量百分比）是 65Ni-15Cr-8Fe-7.5Mn-2Nb+Ta，为镍 - 铬 - 铁系合金焊条。由于合金成分含量高，具有较高的高温强度和抗氧化能力可适应从低温到 480°C 的温度范围；抗气孔性佳，熔敷金属的机械性能稳定。
- 适用于镍 - 铬 - 铁系合金焊接，如 Inconel600 等类似合金；当比较高的锰含量为无害时，可用于钢的表面堆焊；可用于钢于其他镍基合金的异材焊接。

符合标准：

- GB/T 13814 ENi6182·AWS A5.11 ENiCrFe-3·ISO 14172: E Ni 6182

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S
标准值	≤ 0.1	5.0-10.0	≤ 1.0	13.0-17.0	≥ 60.0	≤ 10	1.0-3.5	≤ 0.020	≤ 0.015
例值	0.046	7.60	0.45	15.7	69.4	3.56	1.76	0.005	0.004

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 360	≥ 27
例值	650	410	40

参考电流：(DC⁺)

焊条直径 (mm)		2.5	3.2	4.0
焊条长度 (mm)		300	350	350
焊接电流 (A)	平 / 横焊	69-95	70-115	95-145
	立 / 仰焊	55-80	65-110	80-130

BC-NiCrFe-3(Ni307-3)

Product Description:

- Welding rod for low hydrogen sodium nickel alloy, with a nominal composition (by weight percentage) of 65Ni-15Cr-8Fe-7.5Mn-2Nb+Ta, belonging to nickel-chromium-iron-based alloy electrodes. Due to the high content of alloying elements, it has high high-temperature strength and oxidation resistance, and can adapt to a temperature range from low temperature to 480° C; it has excellent anti-porosity properties, and the mechanical properties of the deposited metal are stable.
- Suitable for welding nickel-chromium-iron based alloys, such as Inconel 600 and similar alloys; when the relatively high manganese content is harmless, it can be used for surfacing on steel; and can be used for dissimilar metal welding between steel and other nickel-based alloys.

Compliant with standards:

- GB/T 13814 ENi6182·AWS A5.11 ENiCrFe-3·ISO 14172: E Ni 6182

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	P	S
Standard value	≤ 0.1	5.0-10.0	≤ 1.0	13.0-17.0	≥ 60.0	≤ 10	1.0-3.5	≤ 0.020	≤ 0.015
Example value	0.046	7.60	0.45	15.7	69.4	3.56	1.76	0.005	0.004

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 360	≥ 27
Example value	650	410	40

Reference current：(DC⁺)

Diameter (mm)		2.5	3.2	4.0
Length (mm)		300	350	350
Welding current (A)	flat/horizontal welding	69-95	70-115	95-145
	vertical/overhead welding	55-80	65-110	80-130

BC-NiCrMo-3 (Ni327-3)

产品说明：

- 低氢钠型镍合金用焊条，名义成分（重量百分数）是 60Ni-22Cr-9Mo-Fe-3.5Nb+Ta，为镍-铬-钼系合金焊条；由于合金成分含量高，可适应从低温到 540°C 的温度范围；在室温及高温下具有较高的强度及耐蚀能力，包括耐点蚀、裂隙腐蚀及多硫酸性介质中的应力腐蚀。
- 适用于镍-铬-钼系合金，如：Inconel601/625、ASTMB443、Allony20、Incoloy800、800H、825，也可用于 Ni9% 钢的焊接；以及钢的表面堆焊和钢与镍基合金的异材焊接。

符合标准：

- GB/T 13814 ENi6625·AWS A5.11 ENiCrMo-3·ISO 14172: E Ni 6625

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	Mo	P	S
标准值	≤ 0.1	≤ 2.0	≤ 0.8	20.0-23.0	≥ 55.0	≤ 7.0	3.0-4.2	8.0-10.0	≤ 0.02	≤ 0.015
例值	0.052	0.7	0.50	21.3	62.6	2.67	3.20	9.21	0.007	0.005

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 760	≥ 420	≥ 27
例值	790	545	40.5

参考电流：(DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	
焊条长度 (mm)	300	350	350	
焊接电流 (A)	平 / 横焊	65-95	70-115	95-145
	立 / 仰焊	60-80	65-105	85-135

BC-NiCrMo-3 (Ni327-3)

Product Description:

- Welding rod for low hydrogen sodium nickel alloy. The nominal composition (by weight percentage) is 60Ni-22Cr-9Mo-Fe-3.5Nb+Ta, belonging to nickel-chromium-molybdenum-based alloy electrodes. Due to the high content of alloying elements, it can adapt to a temperature range from low temperature to 540° C. It exhibits high strength and corrosion resistance at both room temperature and high temperatures, including resistance to pitting corrosion, crevice corrosion, and stress corrosion in polythionic acid media.
- Suitable for nickel-chromium-molybdenum based alloys, such as: Inconel 601/625, ASTM B443, Alloy 20, Incoloy 800, 800H, 825. It can also be used for welding 9% Ni steel; as well as surfacing on steel and dissimilar metal welding between steel and nickel-based alloys.

Compliant with standards:

- GB/T 13814 ENi6625·AWS A5.11 ENiCrMo-3·ISO 14172: E Ni 6625

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	Cr	Ni	Fe	Nb+Ta	Mo	P	S
Standard value	≤ 0.1	≤ 2.0	≤ 0.8	20.0-23.0	≥ 55.0	≤ 7.0	3.0-4.2	8.0-10.0	≤ 0.02	≤ 0.015
Example value	0.052	0.7	0.50	21.3	62.6	2.67	3.20	9.21	0.007	0.005

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 760	≥ 420	≥ 27
Example value	790	545	40.5

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	
Length (mm)	300	350	350	
Welding current (A)	flat/horizontal welding	65-95	70-115	95-145
	vertical/overhead welding	60-80	65-105	85-135

BC-NiCrMo-4

产品说明：

- 低氢钠型镍合金用焊条，名义成分（重量百分数）是 57Ni-16Mo-15.5Cr-5.5Fe-4W- 低 C，为镍 - 铬 - 钼系合金焊条；具有优异的耐腐蚀性能，特别是耐点蚀及裂隙腐蚀能力；抗气孔性佳，熔敷金属的机械性能稳定。
- 适用于低碳 - 镍 - 铬 - 钼系合金，也可用于其他镍基合金的异材焊接。

符合标准：

- GB/T 13814 ENI6276·AWS A5.11 ENiCrMo-4·ISO 14172: E Ni 6276

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Fe	W	Mo	P	S
标准值	≤ 0.02	≤ 1.0	≤ 0.2	14.5-16.5	≥ 55.0	4.0-7.0	3.0-4.5	15.0-17.0	≤ 0.02	≤ 0.015
例值	0.018	0.45	0.18	15.7	57.9	5.71	3.92	16.0	0.009	0.008

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 690	≥ 400	≥ 22
例值	770	570	40

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2	4.0	
焊条长度 (mm)	300	350	350	
焊接电流 (A)	平 / 横焊	65-95	70-115	95-145
	立 / 仰焊	60-80	65-105	85-135

BC-NiCrMo-4

Product Description:

- Welding rod for low hydrogen sodium nickel alloy. The nominal composition (by weight percentage) is 57Ni-16Mo-15.5Cr-5.5Fe-4W-low C, belonging to nickel-chromium-molybdenum-based alloy electrodes. It has excellent corrosion resistance, particularly in resisting pitting corrosion and crevice corrosion. Additionally, it features good anti-porosity properties and stable mechanical properties of the deposited metal.
- Suitable for low-carbon nickel-chromium-molybdenum based alloys, and can also be used for dissimilar metal welding of other nickel-based alloys.

Compliant with standards:

- GB/T 13814 ENI6276·AWS A5.11 ENiCrMo-4·ISO 14172: E Ni 6276

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	Cr	Ni	Fe	W	Mo	P	S
Standard value	≤ 0.02	≤ 1.0	≤ 0.2	14.5-16.5	≥ 55.0	4.0-7.0	3.0-4.5	15.0-17.0	≤ 0.02	≤ 0.015
Example value	0.018	0.45	0.18	15.7	57.9	5.71	3.92	16.0	0.009	0.008

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 690	≥ 400	≥ 22
Example value	770	570	40

Reference current：（DC⁺）

Diameter (mm)	2.5	3.2	4.0	
Length (mm)	300	350	350	
Welding current (A)	flat/horizontal welding	65-95	70-115	95-145
	vertical/overhead welding	60-80	65-105	85-135

BC-NiCrMo-6

产品说明:

- 低氢钠型镍合金用焊条。名义成分（重量百分数）是 65Ni-14.5Cr-7Fe-7Mo-1.5W-1.5Nb+Ta，为镍 - 铬 - 钼系合金焊条；抗气孔性佳，熔敷金属的机械性能稳定；-196℃低温冲击韧性优异，并具有与 9%Ni 钢相似的热膨胀系数。
- 适用于 9% 镍钢，如 ASTM A353、A553 等；应用最广泛的行业多与 LNG 相关。

符合标准:

- GB/T13814 ENi6620 · AWS A5.11 ENiCrMo-6 · ISO 14172: E Ni6620

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo	Fe	W	Nb+Ta	P	S
标准值	≤ 0.1	2.0-4.0	≤ 1.0	12.0-17.0	≥ 55.0	5.0-9.0	≤ 10.0	1.0-2.0	0.5-2.0	≤ 0.02	≤ 0.015
例值	0.042	2.91	0.44	13.3	70.6	6.38	4.15	1.45	1.35	0.008	0.003

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-196℃冲击功 KV ₂ (J)
标准值	≥ 620	≥ 350	≥ 32	-
例值	720	450	40	80

参考电流：(DC⁺)

焊条直径 (mm)		2.5	3.2	4.0
焊条长度 (mm)		300	350	350
焊接电流 (A)	平 / 横焊	65-115	80-140	120-180
	立 / 仰焊	60-105	70-130	110-170

BC-NiCrMo-6

Product Description:

- Welding rod for low hydrogen sodium nickel alloy. The nominal composition (by weight percentage) is 65Ni-14.5Cr-7Fe-7Mo-1.5W-1.5Nb+Ta, belonging to nickel-chromium-molybdenum-based alloy electrodes. It has excellent anti-porosity properties and stable mechanical properties of the deposited metal. It exhibits outstanding low-temperature impact toughness at -196° C and has a thermal expansion coefficient similar to that of 9% Ni steel.
- Suitable for 9% nickel steels such as ASTM A353, A553, etc.; the most widely applied industries are mostly related to LNG.

Compliant with standards:

- GB/T13814 ENi6620 · AWS A5.11 ENiCrMo-6 · ISO 14172: E Ni6620

Chemical Composition of Deposition Metal (Mass Fraction)：%

	C	Mn	Si	Cr	Ni	Mo	Fe	W	Nb+Ta	P	S
Standard value	≤ 0.1	2.0-4.0	≤ 1.0	12.0-17.0	≥ 55.0	5.0-9.0	≤ 10.0	1.0-2.0	0.5-2.0	≤ 0.02	≤ 0.015
Example value	0.042	2.91	0.44	13.3	70.6	6.38	4.15	1.45	1.35	0.008	0.003

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -196°C KV ₂ (J)
Standard value	≥ 620	≥ 350	≥ 32	-
Example value	720	450	40	80

Reference current: (DC⁺)

Diameter (mm)		2.5	3.2	4.0
Length (mm)		300	350	350
Welding current (A)	flat/horizontal welding	65-115	80-140	120-180
	vertical/overhead welding	60-105	70-130	110-170

BC-Z208

产品说明：

- Z208 是低碳钢芯、强石墨化药皮的铸铁电焊条。焊缝在缓冷时变成灰口铸铁，但抗裂性能较差。本焊条可以交直流两用，价格低廉。
- 用于修补灰口铸铁件的缺陷。

符合标准：

- GB/T 10044 E ZC·ISO 1071-E C Z

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	S	P	Fe
标准值	2.00-4.00	≤ 0.75	2.5-6.5	≤ 0.10	≤ 0.15	余量
例值	2.3	0.38	4.50	0.003	0.02	-

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	70-120	110-180	160-190

BC-Z208

Product Description:

- Z208 is a cast iron electrode with strong graphitization coating with carbon steel core. The weld turns into gray cast iron when it is slowly cooled, but the crack resistance is poor. This electrode can be used for both AC and DC, and the price is low.
- It is used to repair the defects of gray iron castings.

Compliant with standards:

- GB/T 10044 E ZC·ISO 1071-E C Z

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	S	P	Fe
Standard value	2.00-4.00	≤ 0.75	2.5-6.5	≤ 0.10	≤ 0.15	allowance
Example value	2.3	0.38	4.5	0.003	0.02	-

Reference current: (DC⁺ or AC)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	70-120	110-180	160-190

BC-Z308

产品说明：

- Z308 是纯镍焊芯、强还原性石墨型药皮的铸铁焊条，施焊时，焊件可不预热，具有良好的抗裂性能和加工性能。交直流两用。
- 用于铸铁薄件及加工面的补焊，如发动机座齿轮箱以及机床轨等重要灰口铸铁件。

符合标准：

- GB/T 10044 EZNi-1· AWS A5.15 ENi-CI

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Fe	Ni	S	其他
标准值	≤ 2.0	≤ 1.0	≤ 2.5	≤ 8.0	≥ 90	≤ 0.03	≤ 1.0
例值	1.45	0.85	1.8	2	93.2	0.003	-

参考电流：（DC⁺ 或 AC）

焊条直径（mm）	2.5	3.2	4.0	5.0
焊条长度（mm）	300	300	350	350
焊接电流（A）	50-100	70-120	110-180	160-190

BC-Z308

Product Description:

- Z308 is a cast iron electrode with pure nickel core wire and highly reducing graphite-type coating. No preheating of workpieces is required during welding. It features excellent crack resistance and machinability, and is suitable for both AC and DC welding.
- It is ideal for repair welding of thin cast iron parts and machined surfaces, such as engine bases, gearboxes, machine tool guideways and other critical grey iron components.

Compliant with standards:

- GB/T 10044 EZNi-1· AWS A5.15 ENi-CI

Chemical Composition of Deposition Metal
(Mass Fraction) :%

	C	Mn	Si	Fe	Ni	S	Other
Standard value	≤ 2.0	≤ 1.0	≤ 2.5	≤ 8.0	≥ 90	≤ 0.03	≤ 1.0
Example value	1.45	0.85	1.8	2	93.2	0.003	-

Reference current: (DC⁺ or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350
Welding current (A)	50-100	70-120	110-180	160-190

BC-Z408

产品说明：

- Z408 是镍铁合金焊芯、强还原性石墨型药皮的铸铁焊条。具有强度高，塑性好，线膨胀系数低等特点。药皮呈黑色微红，电弧稳定，熔滴过渡细，药皮熔化均匀，熔渣覆盖优良，焊缝成型美观，特别是小电流具有优良的操作工艺性能，可避免大电流产生的不良影响。
- 用于重要高强度灰口铸铁及球墨铸铁的焊补，如汽缸、发动机座、齿轮等。

符合标准：

- GB/T 10044 EZNiFe-1· AWS A5.15 ENiFe-CI· ISO 1071-ECNiFe-CI 1

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	S	Ni	Cu	Fe	Al	其他
标准值	≤ 2.0	≤ 2.5	≤ 4.0	≤ 0.03	45-60	≤ 2.50	余量	≤ 1.0	≤ 1.0
例值	1.5	0.2	1.80	0.002	51.5	0.016	-	0.4	-

参考电流：（DC⁺ 或 AC）

焊条直径（mm）	3.2	4.0	5.0
焊条长度（mm）	300	350	350
焊接电流（A）	70-120	110-180	160-190

BC-Z408

Product Description:

- Z408 is a cast iron electrode with strong reducing graphite coating for nickel-iron alloy welding core. It has the characteristics of high strength, good plasticity and low linear expansion coefficient. The coating is black and reddish, the arc is stable, the droplet transition is fine, the coating melts evenly, the slag coverage is excellent, the weld forming is beautiful, especially the small current has excellent operation process performance, which can avoid the adverse effects of large current.
- It is used for the welding and repair of important high-strength gray cast iron and ductile iron, such as cylinders, engine seats, gears, etc.

Compliant with standards:

- GB/T 10044 EZNiFe-1· AWS A5.15 ENiFe-CI· ISO 1071-ECNiFe-CI 1

Chemical Composition of Deposition Metal
(Mass Fraction) :%

	C	Mn	Si	S	Ni	Cu	Fe	Al	Other
Standard value	≤ 2.0	≤ 2.5	≤ 4.0	≤ 0.03	45-60	≤ 2.50	allowance	≤ 1.0	≤ 1.0
Example value	1.5	0.2	1.80	0.002	51.5	0.016	-	0.4	-

Reference current：（DC⁺ or AC）

Diameter（mm）	3.2	4.0	5.0
Length（mm）	300	350	350
Welding current（A）	70-120	110-180	160-190

BC-Z508

产品说明：

- Z508 是镍铜合金（蒙乃尔）焊芯强还原性石墨型药皮的铸铁焊条。其工艺性及切削加工性能都接近 Z308，但由于收缩率较大，抗裂性较差，焊接接头强度较低，所以不宜用于受力部位的焊接，可用于常温或低温预热（300°C左右）的灰口铸铁的焊接。交直流两用，电弧稳定，操作方便。
- 用于强度要求不高的灰口铸铁件的焊补。

符合标准：

- GB/T10044 ENiCu-1 · AWS A5.15 ENiCu-B · ISO 1071-E C NiCu-B

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	S	Ni	Fe	Cu	其他
标准值	0.35-0.55	≤ 2.3	≤ 0.75	≤ 0.025	60-70	3.0-6.0	25-35	≤ 1.0

参考电流：（DC⁺ 或 AC）

焊条直径（mm）	2.5	3.2	4.0	5.0
焊条长度（mm）	300	300	350	350
焊接电流（A）	50-100	70-120	110-170	140-190

BC-Z508

Product Description:

- Z508 is a cast iron electrode with strong reducing graphite coating for nickel-copper alloy (Monel) welding core. Its manufacturability and cutting performance are close to Z308, but due to the large shrinkage, poor crack resistance, and low strength of welded joints, it is not suitable for the welding of stressed parts, and can be used for the welding of gray cast iron with normal temperature or low temperature preheating (about 300 ° C). AC and DC dual-purpose, stable arc, easy to operate.
- It is used for welding and repairing gray iron castings with low strength requirements.

Compliant with standards:

- GB/T10044 ENiCu-1 · AWS A5.15 ENiCu-B · ISO 1071-E C NiCu-B

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	S	Ni	Fe	Cu	Other
Standard value	0.35-0.55	≤ 2.3	≤ 0.75	≤ 0.025	60-70	3.0-6.0	25-35	≤ 1.0

Reference current：（DC⁺ or AC）

Diameter（mm）	2.5	3.2	4.0	5.0
Length（mm）	300	300	350	350
Welding current（A）	50-100	70-120	110-170	140-190

BC-E308-16 (A102)

产品说明:

- A102 是钛钙型药皮的 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。具有优良的焊接工艺性能和抗气孔性能，药皮耐发红、抗开裂。可交直流两用。
- 用于焊接工作温度低于 300°C 的耐腐蚀的 06Cr19Ni10 及 06Cr18Ni11Ti 的不锈钢结构。

符合标准:

- GB/T 983 E308-16·AWS A5.4 E308-16·ISO 3581-B-ES308-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18-21	≤ 0.75	≤ 0.75	9.0-11.0
例值	0.038	1.35	0.68	0.022	0.008	19.75	0.064	0.1	9.6

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 30
例值	590	45

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	40-80	50-100	70-130	100-160	140-200

BC-E308-16 (A102)

Product Description:

- A102 is a Cr19Ni10 stainless steel electrode with titania-calcium coating. The deposited metal has excellent mechanical properties and intergranular corrosion resistance. It features superior welding process performance and porosity resistance, with the coating resistant to overheating discoloration and cracking. Suitable for both AC and DC welding.
- It is used for welding corrosion-resistant stainless steel structures of 06Cr19Ni10 and 06Cr18Ni11Ti that operate below 300°C.

Compliant with standards:

- GB/T 983 E308-16·AWS A5.4 E308-16·ISO 3581-B-ES308-16

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18-21	≤ 0.75	≤ 0.75	9.0-11.0
Example value	0.038	1.35	0.68	0.022	0.008	19.75	0.064	0.1	9.6

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 30
Example value	590	45

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	40-80	50-100	70-130	100-160	140-200

BC-E308-15 (A107)

产品说明:

- A107 是碱性药皮的 Cr19Ni10 不锈钢焊条。其熔敷金属具有良好的力学性能和抗晶间腐蚀性能。采用直流反接，适合全位置焊接。
- 用于焊接 06Cr19Ni10 型不锈钢结构件。也可用于焊接一些可焊性较差的钢材（如高铬钢等）以及堆焊不锈钢表面层。

符合标准:

- GB/T 983 E308-15·AWS A5.4 E308-15·ISO 3581-B-ES308-15

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18-21	≤ 0.75	≤ 0.75	9.0-11.0
例值	0.056	1.90	0.24	0.021	0.006	20	0.068	0.11	9.5

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 30
例值	600	43

参考电流: (DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	40-80	50-100	70-120	90-160	140-200

BC-E308-15 (A107)

Product Description:

- A107 is a Cr19Ni10 stainless steel electrode with basic coating. Its deposited metal has excellent mechanical properties and intergranular corrosion resistance. It adopts DC reverse polarity and is suitable for all-position welding.
- It is used for welding 06Cr19Ni10 stainless steel structural parts. It can also be used to weld some steel with poor weldability (such as high chromium steel, etc.) and surfacing stainless steel surface layer.

Compliant with standards:

- GB/T 983 E308-15·AWS A5.4 E308-15·ISO 3581-B-ES308-15

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18-21	≤ 0.75	≤ 0.75	9.0-11.0
Example value	0.056	1.90	0.24	0.021	0.006	20	0.068	0.11	9.5

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 30
Example value	600	43

Reference current: (DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	40-80	50-100	70-120	90-160	140-200

BC-E308L-16 (A002)

产品说明：

- A002 是钛钙型药皮的超低碳 Cr19Ni10 不锈钢焊条，其熔敷金属含碳量 $\leq 0.04\%$ ，具有良好的抗晶间腐蚀性能及焊接工艺性能。抗气孔性好，焊条药皮不易发红，药皮强度高。可交直流两用。
- 用于焊接超低碳 Cr19Ni10 不锈钢结构件。也可用于 06Cr18Ni11Ti 不锈钢结构件的焊接。主要用于合成纤维、化肥、石油等设备的制造。

符合标准：

- GB/T 983 E308L-16·AWS A5.4 E308L-16·ISO 3581-A-E(19 9 L)R3 2

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-12.0	18-21	≤ 0.75	≤ 0.75
例值	0.024	1.3	0.62	0.02	0.008	9.8	19.9	0.04	0.035

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	断后伸长率 A(%)
标准值	≥ 510	≥ 30
例值	580	45

参考电流：(DC⁺ 或 AC)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	40-80	50-100	70-130	100-160	140-200

BC-E308L-16 (A002)

Product Description:

- A002 is a super low-carbon Cr19Ni10 stainless steel electrode with titania-calcium coating. Its deposited metal has a carbon content of $\leq 0.04\%$, featuring excellent intergranular corrosion resistance and welding process performance. It boasts good porosity resistance, with the electrode coating not prone to overheating discoloration and high coating strength. Suitable for both AC and DC welding.
- It is used for welding super low-carbon Cr19Ni10 stainless steel structural components. It can also be applied to weld 06Cr18Ni11Ti stainless steel structures, and is mainly used in the manufacturing of equipment for synthetic fiber, chemical fertilizer, petroleum and other industries.

Compliant with standards:

- GB/T 983 E308L-16·AWS A5.4 E308L-16·ISO 3581-A-E(19 9 L)R3 2

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-12.0	18-21	≤ 0.75	≤ 0.75
Example value	0.024	1.3	0.62	0.02	0.008	9.8	19.9	0.04	0.035

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation after fracture A(%)
Standard value	≥ 510	≥ 30
Example value	580	45

Reference current: (DC⁺ or AC)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	40-80	50-100	70-130	100-160	140-200

BC-E308L-15 (A007)

产品说明:

- A007 是低氢型不锈钢用手焊条、奥氏体型 / 碱性，主要成分是低碳 18%Cr-8%Ni; 2. 焊接作用性好, 电弧稳定、成型美观、波纹细腻、飞溅极少、脱渣容易、药皮耐火性优良、抗气孔性佳; 熔敷金属机械性能稳定, X-Ray 合格率高。
- 适用于石油化工、压力容器、食品机械、医疗机械、化肥等行业, 如 00Cr19Ni10(SUS304L) 等。

符合标准:

- GB/T 983 E308L-15 · AWS A5.4 E308L-15 · ISO 3581-B:ES308L-15

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-11.0	18-21	≤ 0.75	≤ 0.75
例值	0.035	0.92	0.63	0.028	0.009	9.9	19.8	0.02	0.08

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 510	≥ 30
例值	590	45

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350
焊接电流 (A)	50-85	80-120	100-150	140-180

BC-E308L-15 (A007)

Product Description:

- A007 is a low-hydrogen basic covered electrode for stainless steel, of austenitic type, with main chemical composition of low-carbon 18%Cr-8%Ni. It features excellent welding process performance, including stable arc, attractive weld appearance, fine ripples, minimal spatter, easy slag detachment, outstanding coating fire resistance and good porosity resistance. The deposited metal has stable mechanical properties and high X-Ray inspection qualification rate.
- It is suitable for applications in petrochemical, pressure vessel, food machinery, medical equipment and chemical fertilizer industries, and applicable for welding steels such as 00Cr19Ni10 (SUS304L).

Compliant with standards:

- GB/T 983 E308L-15 · AWS A5.4 E308L-15 · ISO 3581-B:ES308L-15

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-11.0	18-21	≤ 0.75	≤ 0.75
Example value	0.035	0.92	0.63	0.028	0.009	9.9	19.8	0.02	0.08

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 510	≥ 30
Example value	590	45

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350
Welding current (A)	50-85	80-120	100-150	140-180

BC-E309-16 (A302)

产品说明:

- A302 是金红石型药皮的不锈钢焊条。焊缝金属具有良好的抗裂性及抗氧化性能。该焊条交直流两用。飞溅小，焊缝成型美观，全位置焊接性良好。
- 用于焊接相同类型的不锈钢，不锈钢衬里，异种钢 (Cr19Ni10 和低碳钢) 以及高铬钢、高锰钢等。

符合标准:

- GB/T 983 E309-16·AWS A5.4 E309-16·ISO 3581-B-ES309-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	≤ 0.15	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	≤ 0.75	≤ 0.75	12.0-14.0
例值	0.06	1.08	0.64	0.027	0.012	24.32	0.35	0.1	12.4

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	600	33

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	400	400
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E309-16 (A302)

Product Description:

- A302 is a stainless steel electrode of rutile coating type. Weld metal has good crack resistance and oxidation resistance. The electrode is used for both AC and DC. The spatter is small, the weld seam is beautiful, and the weldability is good in all positions.
- It is used for welding the same type of stainless steel, stainless steel lining, dissimilar steel (Cr19Ni10 and mild steel) as well as high chromium steel, high manganese steel, etc.

Compliant with standards:

- GB/T 983 E309-16·AWS A5.4 E309-16·ISO 3581-B-ES309-16

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	≤ 0.15	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	≤ 0.75	≤ 0.75	12.0-14.0
Example value	0.06	1.08	0.64	0.027	0.012	24.32	0.35	0.1	12.4

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	600	33

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	400	400
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E309-15 (A307)

产品说明:

- A307 是碱性药皮类型的不锈钢焊条，焊缝金属具有优良的抗裂性以及抗氧化性能。采用直流反接，可进行全位置焊接。
- 用于焊接相同类型的不锈钢、异种钢以及高铬钢，高锰钢等。

符合标准:

- GB/T 983 E309-15·AWS A5.4 E309-15·ISO 3581-B-ES309-15

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	≤ 0.15	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	≤ 0.75	≤ 0.75	12.0-14.0
例值	0.057	1.46	0.58	0.025	0.009	23.80	0.13	0.12	12.80

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	590	39

参考电流: (DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	40-80	50-100	70-120	90-160	140-200

BC-E309-15 (A307)

Product Description:

- A307 is a stainless steel electrode with alkaline coating type, and the weld metal has excellent crack resistance and oxidation resistance. It adopts DC reverse connection, which can be welded in all positions.
- It is used for welding the same type of stainless steel, dissimilar steel, high chromium steel, high manganese steel, etc.

Compliant with standards:

- GB/T 983 E309-15·AWS A5.4 E309-15·ISO 3581-B-ES309-15

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	≤ 0.15	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	≤ 0.75	≤ 0.75	12.0-14.0
Example value	0.057	1.46	0.58	0.025	0.009	23.80	0.13	0.12	12.80

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	590	39

Reference current: (DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	40-80	50-100	70-120	90-160	140-200

BC-E309Mo-16 (A312)

产品说明:

- A312 是金红石型药皮的不锈钢焊条, 由于焊缝金属中含有钼, 故有更好的耐蚀、抗裂以及抗氧化性能。该焊条交直流两用。飞溅小, 焊缝成型美观, 全位置焊接性良好。
- 用于焊接耐硫酸介质(硫氨)腐蚀的同类不锈钢容器, 也可作不锈钢衬里、复合钢板, 异种钢的焊接。

符合标准:

- GB/T 983 E309Mo-16·AWS A5.4 E309Mo-16·ISO 3581-B-ES309Mo-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.12	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	2.0-3.0	≤ 0.75
例值	0.057	0.92	0.63	0.023	0.012	13.10	23.32	2.44	0.20

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	600	35

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	400	400
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E309Mo-16 (A312)

Product Description:

- A312 is a rutile coating type stainless steel electrode, which has better corrosion, crack and oxidation resistance due to the presence of molybdenum in the weld metal. The electrode is used for both AC and DC. The spatter is small, the weld seam is beautiful, and the weldability is good in all positions.
- It is used for welding the same kind of stainless steel containers that are resistant to sulfuric acid medium (sulfur ammonia) corrosion, and can also be used for stainless steel lining, composite steel plate, and welding of dissimilar steel.

Compliant with standards:

- GB/T 983 E309Mo-16·AWS A5.4 E309Mo-16·ISO 3581-B-ES309Mo-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.12	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	2.0-3.0	≤ 0.75
Example value	0.057	0.92	0.63	0.023	0.012	13.10	23.32	2.44	0.20

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	600	35

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	400	400
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E309LMo-16 (A042)

产品说明:

- A042 是金红石药皮类型的超低碳不锈钢焊条。其焊缝中加入了适量的钼，故提高了焊缝金属的耐热性、抗裂性及耐腐蚀性能。该焊条交直流两用，交流稳弧性佳。飞溅小，焊缝成形美观，全位置焊接性良好。
- 用于相同类型的超低碳不锈钢材料（如尿素合成塔衬里）及异种钢焊接。

符合标准:

- GB/T 983 E309LMo-16·AWS A5.4 E309LMo-16
- ISO 3581-B-ES309LMo-16

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	2.0-3.0	≤ 0.75	12.0-14.0
例值	0.026	0.92	0.64	0.021	0.011	23.34	2.42	0.09	12.6

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 510	≥ 25
例值	600	38

参考电流：（AC 或 DC⁺）

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	400	400
焊接电流 (A)	25-50	45-70	75-100	100-140	140-170

BC-E309LMo-16 (A042)

Product Description:

- A042 is an ultra-low carbon stainless steel electrode of rutile coating type. An appropriate amount of molybdenum is added to the weld, so the crack resistance and corrosion resistance of the weld metal are improved. The electrode is used for both AC and DC, and has good AC arc stability. The spatter is small, the weld is beautifully formed, and the weldability is good in all positions.
- It is used for welding the same type of ultra-low carbon stainless steel materials (such as urea synthetic column linings) and dissimilar steels.

Compliant with standards:

- GB/T 983 E309LMo-16·AWS A5.4 E309LMo-16
- ISO 3581-B-ES309LMo-16

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	22.0-25.0	2.0-3.0	≤ 0.75	12.0-14.0
Example value	0.026	0.92	0.64	0.021	0.011	23.34	2.42	0.09	12.6

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 510	≥ 25
Example value	600	38

Reference current：（AC 或 DC⁺）

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	400	400
Welding current (A)	25-50	45-70	75-100	100-140	140-170

BC-E309L-16 (A062)

产品说明:

- A062 是金红石型药皮的超低碳不锈钢焊条，其焊缝含碳量低，故在不含铌、钛等稳定剂时也能抵抗因碳化物析出而产生的晶间腐蚀。该焊条交直流两用。飞溅小，焊缝成型美观，全位置焊接性良好。
- 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，复合钢和异种钢等构件，也可用于核反应堆压力容器内壁过渡层堆焊和塔内构件焊接。

符合标准:

- GB/T 983 E309L-16·AWS A5.4 E309L-16·ISO 3581-B-ES309L-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
例值	0.027	1.3	0.61	0.021	0.008	13.09	23.43	0.18	0.092

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 510	≥ 25
例值	600	32

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	50-70	80-110	130-160	160-200

BC-E309L-16 (A062)

Product Description:

- A062 is an ultra-low carbon stainless steel electrode with rutile coating type, and its weld has a low carbon content, so it can resist intergranular corrosion caused by carbide precipitation even without niobium, titanium and other stabilizers. The electrode is used for both AC and DC. The spatter is small, the weld seam is beautiful, and the weldability is good in all positions.
- The same type of stainless steel structure, composite steel and dissimilar steel and other components used in the manufacture of synthetic fiber, petrochemical and other equipment can also be used for the surfacing welding of the transition layer on the inner wall of the nuclear reactor pressure vessel and the welding of tower internals.

Compliant with standards:

- GB/T 983 E309L-16·AWS A5.4 E309L-16·ISO 3581-B-ES309L-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
Example value	0.027	1.3	0.61	0.021	0.008	13.09	23.43	0.18	0.092

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 510	≥ 25
Example value	600	32

Reference current: (AC or DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	50-70	80-110	130-160	160-200

BC-E309L-15 (A067)

产品说明：

- A067 是碱性药皮类型的超低碳不锈钢焊条。由于含碳量低，故在不含铌、钛等稳定剂时也能抵抗因碳化物析出而产生的晶间腐蚀。且药皮碱度较高，焊缝 S、P、O 杂质含量低，焊缝抗裂性优良。该焊条采用直流反接，能进行全位置焊接；施焊时需轻微摆动焊条，以利于熔滴过渡和减轻磁偏吹。
- 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，复合钢和异种钢等构件，也可用于核反应堆压力容器内壁过渡层堆焊和塔内构件焊接。

符合标准：

- GB/T 983 E309L-15·AWS A5.4 E309L-15·ISO 3581-B-ES309L-15

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
例值	0.035	1.15	0.42	0.020	0.009	13.11	23.4	0.09	0.092

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	伸长率 A(%)	室温冲击功 KV ₂ (J)
标准值	≥ 510	≥ 25	—
例值	550	41	95

参考电流：(DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0	
焊条长度 (mm)	250	300	350	350	
焊接电流 (A)	平焊	50-80	80-110	120-150	160-200
	立、仰焊	50-80	70-110	90-150	

BC-E309L-15 (A067)

Product Description:

- A067 is a type of alkaline flux-coated ultra-low carbon stainless steel welding rod. Due to its low carbon content, it can resist intergranular corrosion caused by carbide precipitation even in the absence of stabilizers such as niobium and titanium. Additionally, the high alkalinity of the flux results in low impurity content of S, P, and O in the weld seam, providing excellent crack resistance. This welding rod is designed for direct current reverse polarity and can be used for all-position welding; a slight oscillation of the rod is required during welding to facilitate droplet transfer and reduce magnetic blow.
- The same type of stainless steel structure, composite steel and dissimilar steel and other components used in the manufacture of synthetic fiber, petrochemical and other equipment can also be used for the surfacing welding of the transition layer on the inner wall of the nuclear reactor pressure vessel and the welding of tower internals.

Compliant with standards:

- GB/T 983 E309L-15·AWS A5.4 E309L-15·ISO 3581-B-ES309L-15

Chemical Composition of Deposition Metal(Mass Fraction) :%

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
Example value	0.035	1.15	0.42	0.020	0.009	13.11	23.4	0.09	0.092

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)	Room temperature impact energy KV ₂ (J)
Standard value	≥ 510	≥ 25	—
Example value	550	41	95

Reference current：(DC⁺)

Diameter (mm)		2.5	3.2	4.0	5.0
Length (mm)		250	300	350	350
Welding current (A)	flat welding	50-80	80-110	120-150	160-200
	vertical/overhead welding	50-80	70-110	90-150	

BC-E310-16 (A402)

产品说明:

- A402 是金红石型药皮的 Cr26Ni21 纯奥氏体不锈钢焊条，焊缝金属在 900°C -1100°C 高温工作条件下，具有优良的抗氧化性。交直流两用，可进行全位置焊接，具有良好的焊接工艺性能。
- 用于在高温条件下工作的同类型耐热不锈钢焊接。也用于硬化性大的铬钢如 (Cr5Mo、Cr9Mo、Cr13、Cr28 等) 以及异种钢的焊接。

符合标准:

- GB/T 983 E310-16·AWS A5.4 E310-16·ISO 3581-B-ES310-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	0.08-0.2	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	20.0-22.5	25-28	≤ 0.75	≤ 0.75
例值	0.13	2.12	0.38	0.021	0.009	21.1	26.85	0.05	0.104

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	600	39

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E310-16 (A402)

Product Description:

- A402 is a rutile coating type of Cr26Ni21 pure austenitic stainless steel electrode, the weld metal has excellent oxidation resistance under high temperature working conditions of 900° C-1100° C. AC and DC dual-purpose, with good welding process performance.
- Welding of the same type of heat-resistant stainless steel for working at high temperatures. It is also used for the welding of chromium steel with high hardening properties such as (Cr5Mo, Cr9Mo, Cr13, Cr28, etc.) and dissimilar steel.

Compliant with standards:

- GB/T 983 E310-16·AWS A5.4 E310-16·ISO 3581-B-ES310-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	0.08-0.2	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	20.0-22.5	25-28	≤ 0.75	≤ 0.75
Example value	0.13	2.12	0.38	0.021	0.009	21.1	26.85	0.05	0.104

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	600	39

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E310-15 (A407)

产品说明:

- A407 是碱性药皮类型的 Cr26Ni21 纯奥氏体不锈钢焊条，焊缝金属在 900°C -1100°C 高温下具有良好的抗氧化性能，采用直流反接，可进行全位置焊接。由于焊缝为纯奥氏体，抗热裂性能不及双相组织的好。
- 用于同类型的耐热不锈钢，不锈钢衬里以及异种钢焊接，也可用来焊接硬化性大的 Cr5Mo、Cr9Mo、Cr13 及 Cr28 等结构。

符合标准:

- GB/ T983 E310-15·AWS A5.4 E310-15·ISO 3581-B-ES310-15

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
标准值	0.08-0.2	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	25-28	≤ 0.75	≤ 0.75	20.0-22.5
例值	0.133	1.74	0.3	0.02	0.008	26.60	0.05	0.12	21.1

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	590	38

参考电流: (DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	40-80	50-100	70-120	90-160	140-200

BC-E310-15 (A407)

Product Description:

- A407 is a Cr26Ni21 pure austenitic stainless steel electrode with alkaline coating type, the weld metal has good oxidation resistance at high temperature of 900 ° C-1100 ° C, and adopts DC reverse connection, which can be welded in all positions. Because the weld is pure austenite, the thermal cracking resistance is not as good as that of duplex structure.
- It is used for welding the same type of heat-resistant stainless steel, stainless steel lining and dissimilar steel, and can also be used to weld Cr5Mo, Cr9Mo, Cr13 and Cr28 structures with high hardening.

Compliant with standards:

- GB/ T983 E310-15·AWS A5.4 E310-15·ISO 3581-B-ES310-15

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni
Standard value	0.08-0.2	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	25-28	≤ 0.75	≤ 0.75	20.0-22.5
Example value	0.133	1.74	0.3	0.02	0.008	26.60	0.05	0.12	21.1

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	590	38

Reference current: (DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	40-80	50-100	70-120	90-160	140-200

BC-E310Mo-16 (A412)

产品说明：

- A412 是金红石型药皮的 Cr26Ni21Mo2 不锈钢焊条，由于焊缝金属添加了钼，故耐腐蚀性、耐热性、抗裂性更好。可交直流两用，可进行全位置焊接，焊接工艺性能好。
- 用于焊接 25%Cr-20%Ni-2%Mo 不锈钢等。在焊接淬硬性高的碳钢、低合金钢时韧性极好。

符合标准：

- GB/ T983 E310Mo-16·AWS A5.4 E310Mo-16·ISO 3581-B-ES310Mo-16

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.12	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	20-22	25-28	2.0-3.0	≤ 0.75
例值	0.083	2	0.5	0.021	0.01	21.09	26.71	2.5	0.1

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 28
例值	605	38

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E310Mo-16 (A412)

Product Description:

- A412 is a rutile-coated Cr26Ni21Mo2 stainless steel electrode. The addition of molybdenum to the weld metal enhances its corrosion resistance, heat resistance and crack resistance. It is suitable for both AC and DC power supplies and all-position welding, with excellent welding process performance.
- It is used for welding 25%Cr-20%Ni-2%Mo stainless steel and similar grades. It also delivers excellent toughness when welding high-hardening carbon steels and low-alloy steels.

Compliant with standards:

- GB/ T983 E310Mo-16·AWS A5.4 E310Mo-16·ISO 3581-B-ES310Mo-16

Chemical Composition of Deposition Metal
(Mass Fraction)： %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.12	1.0-2.5	≤ 0.75	≤ 0.03	≤ 0.03	20-22	25-28	2.0-3.0	≤ 0.75
Example value	0.083	2	0.5	0.021	0.01	21.09	26.71	2.5	0.1

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 28
Example value	605	38

Reference current: (DC⁺ or AC)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E316-16 (A202)

产品说明:

- A202 是金红石型药皮的 Cr18Ni12Mo2 不锈钢焊条，焊缝金属具有良好的耐蚀、耐热及抗裂性能，特别对抗氯离子点蚀有很好的效果，可交直流两用，有优良的焊接工艺性能，适合于全位置焊接。
- 用于焊接在有机和无机酸（非氧化性酸）介质中工作的 06Cr17Ni12Mo2 不锈钢设备，也可用于焊接后不能进行热处理的高铬钢或作异种钢的焊接。

符合标准:

- GB/ T983 E316-16·AWS A5.4 E316-16·ISO 3581-B-ES316-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
例值	0.037	0.82	0.76	0.028	0.013	11.83	18.81	2.40	0.1

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	595	42

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350	350
焊接电流 (A)	25-50	50-80	85-110	110-160	160-200

BC-E316-16 (A202)

Product Description:

- A202 is a rutile-coated Cr18Ni12Mo2 stainless steel electrode. The weld metal offers good corrosion resistance, heat resistance and crack resistance, and exhibits excellent performance especially against chloride ion pitting corrosion. Suitable for both AC and DC polarity, it features superior welding process performance and is applicable for all-position welding.
- It is designed for welding 06Cr17Ni12Mo2 stainless steel equipment operating in organic and inorganic acid (non-oxidizing acid) media. It is also suitable for welding high-chromium steels that cannot be heat-treated after welding or for dissimilar steel welding.

Compliant with standards:

- GB/ T983 E316-16·AWS A5.4 E316-16·ISO 3581-B-ES316-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
Example value	0.037	0.82	0.76	0.028	0.013	11.83	18.81	2.40	0.1

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	595	42

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	25-50	50-80	85-110	110-160	160-200

BC-E316-15 (A207)

产品说明:

- A207 是碱性药皮类型的不锈钢焊条。由于焊缝金属含有钼，故具有良好的耐蚀、耐热及抗裂性能。特别对抗氯离子点蚀有好处。采用直流反接，能进行全位置焊接。
- 用于焊接低碳的 06Cr17Ni12Mo2 不锈钢设备，也可焊接要求焊后不进行热处理的高铬钢（如 Cr13、Cr17 等），以及用于异种钢的焊接。

符合标准:

- GB/ T983 E316-15·AWS A5.4 E316-15·ISO 3581-B-ES316-15

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
例值	0.051	1.2	0.4	0.022	0.008	12.2	19.08	2.40	0.1

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	575	43

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	350
焊接电流 (A)	50-70	80-110	130-160	160-200

BC-E316-15 (A207)

Product Description:

- A207 is a stainless steel electrode of the alkaline coating type. Because the weld metal contains molybdenum, it has good corrosion, heat and crack resistance. It is especially good for resisting chloride pitting. It adopts DC reverse connection, which can be welded in all positions.
- It is used for welding low-carbon 06Cr17Ni12Mo2 stainless steel equipment, and can also be used for welding high-chromium steel (such as Cr13, Cr17, etc.) that requires no heat treatment after welding, as well as for the welding of dissimilar steel.

Compliant with standards:

- GB/ T983 E316-15·AWS A5.4 E316-15·ISO 3581-B-ES316-15

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
Example value	0.051	1.2	0.4	0.022	0.008	12.2	19.08	2.40	0.1

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	575	43

Reference current：（DC⁺）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350
Welding current (A)	50-70	80-110	130-160	160-200

BC-E316L-16 (A022)

产品说明:

- A022 是金红石型药皮的超低碳不锈钢焊条。熔敷金属具有良好的耐热、耐腐蚀及抗裂性能。可交直流两用。有良好的焊接工艺性能，更适合全位置焊接。
- 用于焊接尿素、石油化工生产、合成纤维等设备及相关类型的不锈钢结构件，也可用于焊接后不能进行热处理的铬不锈钢以及复合钢和异种钢等。

符合标准:

- GB/T 983 E316L-16·AWS A5.4 E316L-16·ISO 3581-B-ES316L-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
例值	0.03	1.01	0.66	0.025	0.015	11.86	19.00	2.50	0.08

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 490	≥ 25
例值	575	44

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	400	400
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E316L-16 (A022)

Product Description:

- A022 is a rutile-coated ultra-low carbon stainless steel electrode. The deposited metal has excellent heat resistance, corrosion resistance and crack resistance. It is suitable for both AC and DC power supplies, features favorable welding process performance and is more ideal for all-position welding.
- It is applied to welding equipment in urea, petrochemical production and synthetic fiber industries as well as stainless steel structural components of the same type. It is also suitable for welding chromium stainless steels that cannot be post-weld heat treated, clad steels and dissimilar steels.

Compliant with standards:

- GB/T 983 E316L-16·AWS A5.4 E316L-16·ISO 3581-B-ES316L-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
Example value	0.03	1.01	0.66	0.025	0.015	11.86	19.00	2.50	0.08

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 490	≥ 25
Example value	575	44

Reference current: (DC⁺ or AC)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	400	400
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E316L-15 (A027)

产品说明:

- A027 是碱性药皮类型的超低碳不锈钢焊条。其药皮碱度较高, 焊缝金属含碳量 $\leq 0.04\%$, S、P、O 杂质含量低, 故有良好的耐热、耐蚀及抗裂性能。该焊条采用直流反接, 全位置焊接工艺性能和操作性能良好。施焊时需轻微摆动焊条, 以利于熔滴过渡和减轻磁偏吹。
- 用于焊接尿素、合成纤维等设备及相关类型的不锈钢结构件, 也可用于焊接后不能进行热处理的铬不锈钢以及复合钢和异种钢等。

符合标准:

- GB/T 983 E316L-15·AWS A5.4 E316L-15·ISO 3581-B-ES316L-15

熔敷金属化学成分 (质量分数): %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
例值	0.035	1.2	0.35	0.015	0.009	12.5	18.5	2.40	0.23

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 490	≥ 25
例值	540	40

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	250	300	350	350
焊接电流 (A)	50-80	80-110	120-150	160-200

BC-E316L-15 (A027)

Product Description:

- A027 is an ultra-low carbon stainless steel electrode of the alkaline coating type. The alkalinity of the coating is high, the carbon content of the weld metal is $\leq 0.04\%$, and the content of S, P and O impurities is low, so it has good heat resistance, corrosion resistance and crack resistance. The electrode is reversed DC and has good all-position welding process performance and operation performance. The electrode needs to be slightly oscillated during welding to facilitate the droplet transition and reduce magnetic deflection.
- It is used for welding equipment such as urea, synthetic fibers, and similar types of stainless steel structural components, and can also be used for welding chromium stainless steel that cannot undergo heat treatment after welding, as well as composite steel and dissimilar steel.

Compliant with standards:

- GB/T 983 E316L-15·AWS A5.4 E316L-15·ISO 3581-B-ES316L-15

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
Example value	0.035	1.2	0.35	0.015	0.009	12.5	18.5	2.40	0.23

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 490	≥ 25
Example value	540	40

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	250	300	350	350
Welding current (A)	50-80	80-110	120-150	160-200

BC-E347-16 (A132)

产品说明:

- A132 金红石型药皮的低碳含铌稳定剂的 Cr18Ni9Nb 不锈钢焊条。交、直流两用，可进行全位置焊接。焊接工艺性能优良，电弧稳定，飞溅小，脱渣容易，焊缝成型美观。熔敷金属具有良好的抗晶间腐蚀性能。
- 适用于焊接重要的含钛或铌稳定剂的 Cr18Ni9Nb 型耐腐蚀不锈钢，如 06Cr18Ni11Ti、06Cr18Ni11Nb 等。

符合标准:

- GB/T 983 E347-16·AWS A5.4 E347-16·ISO 3581-B-ES347-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni	Nb+Ta
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18.0-21.0	≤ 0.75	≤ 0.75	9.0-11.0	8*C-1.00
例值	0.042	0.95	0.86	0.027	0.012	19.95	0.035	0.02	9.50	0.56

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	650	38

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	350	400	400
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E347-16 (A132)

Product Description:

- A132 stainless steel electrode with rutile coating, low-carbon content and niobium stabilizer, belonging to Cr18Ni9Nb grade. It is suitable for both AC and DC power supplies and all-position welding. It features excellent welding process performance, stable arc, low spatter, easy slag removal and attractive weld appearance. The deposited metal has good intergranular corrosion resistance.
- It is applicable for welding important niobium or titanium stabilized Cr18Ni9Nb corrosion-resistant stainless steels, such as 06Cr18Ni11Ti and 06Cr18Ni11Nb.

Compliant with standards:

- GB/T 983 E347-16·AWS A5.4 E347-16·ISO 3581-B-ES347-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni	Nb+Ta
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18.0-21.0	≤ 0.75	≤ 0.75	9.0-11.0	8*C-1.00
Example value	0.042	0.95	0.86	0.027	0.012	19.95	0.035	0.02	9.50	0.56

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	650	38

Reference current: (AC or DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	350	350	350
Welding current (A)	30-50	50-85	85-120	120-160	150-200

BC-E347-15 (A137)

产品说明：

- A137 是碱性药皮类型的含铌稳定剂的不锈钢焊条，有优良的抗晶间腐蚀性能。采用直流反接，能进行全位置焊接。
- 用于焊接重要的耐腐蚀含钛或铌稳定剂的 Cr18Ni11 型不锈钢，如 06Cr18Ni11Ti、06Cr18Ni11Nb 等。

符合标准：

- GB/T 983 E347-15·AWS A5.4 E347-15·ISO 3581-B-ES347-15

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni	Nb+Ta
标准值	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18.0-21.0	≤ 0.75	≤ 0.75	9.0-11.0	8*C-1.00
例值	0.056	1.5	0.38	0.028	0.01	19.8	0.2	0.1	9.9	0.6

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	595	39

参考电流：(DC⁺)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	300	300	350	350
焊接电流 (A)	25-50	50-80	80-110	110-160	160-200

BC-E347-15 (A137)

Product Description:

- A137 is a niobium-stabilized stainless steel electrode with alkaline coating type and excellent resistance to intergranular corrosion. It adopts DC reverse connection, which can be welded in all positions.
- It is used for welding important corrosion-resistant Cr18Ni11 stainless steels containing titanium or niobium stabilizers, such as 06Cr18Ni11Ti, 06Cr18Ni11Nb, etc.

Compliant with standards:

- GB/T 983 E347-15·AWS A5.4 E347-15·ISO 3581-B-ES347-15

Chemical Composition of Deposition Metal (Mass Fraction)：%

	C	Mn	Si	P	S	Cr	Mo	Cu	Ni	Nb+Ta
Standard value	≤ 0.08	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	18.0-21.0	≤ 0.75	≤ 0.75	9.0-11.0	8*C-1.00
Example value	0.056	1.5	0.38	0.028	0.01	19.8	0.2	0.1	9.9	0.6

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	595	39

Reference current：(DC⁺)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	300	300	350	350
Welding current (A)	25-50	50-80	80-110	110-160	160-200

BC-E347L-16

产品说明:

- E347L-16 是钛钙型药皮的超低碳含 Nb 稳定剂的 Cr19Ni10Nb 不锈钢焊条, 具有优良的抗晶间腐蚀性能。交直流两用, 能进行全位置焊接。
- 用于 06Cr18Ni11Ti 型不锈钢焊接及石化设备耐蚀堆焊。

符合标准:

- GB/T 983 E347L-16·AWS A5.4 E347-16·ISO 3581-B-ES347L-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	Nb+Ta
标准值	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75	8*C-1.00
例值	0.03	1.7	0.68	0.02	0.006	9.7	19.3	0.042	0.038	0.4

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 510	≥ 25
例值	590	40

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	350	350
焊接电流 (A)	50-100	70-130	100-160	140-200

BC-E347L-16

Product Description:

- E347L-16 is a titanium-calcium coated ultra-low carbon Cr19Ni10Nb stainless steel electrode with Nb stabilizer, featuring excellent intergranular corrosion resistance. It is suitable for both AC and DC power supplies and allows all-position welding.
- It is applied to the welding of 06Cr18Ni11Ti stainless steel and corrosion-resistant surfacing of petrochemical equipment.

Compliant with standards:

- GB/T 983 E347L-16·AWS A5.4 E347-16·ISO 3581-B-ES347L-16

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Standard value	≤ 0.04	0.5-2.5	≤ 1.00	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75	8*C-1.00
Example value	0.03	1.7	0.68	0.02	0.006	9.7	19.3	0.042	0.038	0.4

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 510	≥ 25
Example value	590	40

Reference current: (DC⁺ or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	350	350
Welding current (A)	50-100	70-130	100-160	140-200

BC-E2209-16

产品说明:

- E2209 是金红石型药皮的超低碳 Cr22Ni9Mo3N 双相不锈钢焊条。焊条药皮呈红色，交流稳弧性能极佳，电弧柔和，飞溅很小，脱渣容易，焊缝成型美观，焊条药皮强度高。由于含碳量低，并含有钼、氮，故焊缝金属具有较强的耐腐蚀性能，且耐应力腐蚀性能尤为突出。
- 用于石化、核电、造船等行业同类型超低碳双相不锈钢材料的焊接，如 00Cr22Ni5Mo3N 等双相不锈钢。

符合标准:

- GB/T 983 E2209-16 · AWS A5.4 E2209-16 · ISO 3581-B-ES2209-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
标准值	≤ 0.04	0.5-2.0	≤ 1.00	≤ 0.04	≤ 0.03	7.5-10.5	21.5-23.5	2.5-3.5	≤ 0.75	0.08-0.20
例值	0.03	1.04	0.66	0.026	0.010	8.75	23.00	2.98	0.10	0.15

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 690	≥ 15
例值	830	27

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	350	350
焊接电流 (A)	50-70	80-110	110-150	160-200

BC-E2209-16

Product Description:

- E2209 is a rutile-coated ultra-low carbon Cr22Ni9Mo3N duplex stainless steel electrode. The electrode coating is red, featuring excellent AC arc stability, soft arc, minimal spatter, easy slag detachment, attractive weld appearance and high coating strength. With low carbon content and additions of molybdenum and nitrogen, the weld metal exhibits excellent corrosion resistance, with particularly outstanding stress corrosion resistance.
- It is used for welding the same type of ultra-low carbon duplex stainless steel materials in petrochemical, nuclear power, shipbuilding and other industries, such as 00Cr22Ni9Mo3N and other duplex stainless steels.

Compliant with standards:

- GB/T 983 E2209-16 · AWS A5.4 E2209-16 · ISO 3581-B-ES2209-16

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
Standard value	≤ 0.04	0.5-2.0	≤ 1.00	≤ 0.04	≤ 0.03	7.5-10.5	21.5-23.5	2.5-3.5	≤ 0.75	0.08-0.20
Example value	0.03	1.04	0.66	0.026	0.010	8.75	23.00	2.98	0.10	0.15

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 690	≥ 15
Example value	830	27

Reference current: (DC⁺ or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	350	350
Welding current (A)	50-70	80-110	110-150	160-200

BC-E2594-16

产品说明:

- E2594 是钛钙型药皮的超低碳含氮双相不锈钢焊条。熔敷金属具有良好的抗热裂性。由于含碳量极低,同时含有钼、氮,熔敷金属具有良好的耐点蚀和应力腐蚀开裂性能。焊条具有良好的焊接工艺性能,电弧稳定,飞溅小,成型美观,药皮耐发红,可交直流两用。
- 用于海洋石油、天然气、石化行业同类型双相不锈钢的焊接,如 022Cr25Ni7Mo4N,03Cr25Ni6Mo3Cu2N 等。

符合标准:

- GB/T 983 E2594-16·AWS A5.4 E2594-16

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
标准值	≤ 0.04	0.5-2.0	≤ 1.00	≤ 0.04	≤ 0.03	8.0-10.5	24.0-27.0	3.5-4.5	≤ 0.75	0.20-0.30
例值	0.025	0.96	0.72	0.014	0.007	9.2	25.1	3.87	0.010	0.25

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 760	≥ 13
例值	880	25

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	2.5	3.2	4.0
焊条长度 (mm)	300	350	350
焊接电流 (A)	50-100	70-120	100-160

BC-E2594-16

Product Description:

- E2594 is a titanium-calcium coated ultra-low carbon nitrogen-bearing duplex stainless steel electrode. The deposited metal has excellent hot cracking resistance. With extremely low carbon content and additions of molybdenum and nitrogen, the deposited metal offers good pitting corrosion resistance and stress corrosion cracking resistance. The electrode features excellent welding process performance, with stable arc, minimal spatter, attractive weld appearance, anti-overheating coating, and compatibility with both AC and DC power supplies.
- It is suitable for welding homogeneous duplex stainless steels in offshore oil, natural gas and petrochemical industries, such as 022Cr25Ni7Mo4N and 03Cr25Ni6Mo3Cu2N.

Compliant with standards:

- GB/T 983 E2594-16·AWS A5.4 E2594-16

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
Standard value	≤ 0.04	0.5-2.0	≤ 1.00	≤ 0.04	≤ 0.03	8.0-10.5	24.0-27.0	3.5-4.5	≤ 0.75	0.20-0.30
Example value	0.025	0.96	0.72	0.014	0.007	9.2	25.1	3.87	0.010	0.25

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 760	≥ 13
Example value	880	25

Reference current: (DC⁺ or AC)

Diameter (mm)	2.5	3.2	4.0
Length (mm)	300	350	350
Welding current (A)	50-100	70-120	100-160

BC-R107

产品说明:

- R107 是低氢型药皮的含 Mo0.5% 的珠光体耐热钢焊条, 采用直流反接, 可全位置焊接。
- 用于焊接工作温度在 510°C 以下的锅炉管道 (如 15Mo 等), 也可用于焊接一般的低合金高强度钢。

符合标准:

- GB/T 5118 E5015-1M3·AWS A5.5 E7015-A1·ISO 3580-B-E4915-1M3

熔敷金属化学成分 (质量分数): %

	C	Mn	Si	Mo	S	P
标准值	≤ 0.12	≤ 1.0	≤ 0.80	0.4-0.65	≤ 0.030	≤ 0.030
例值	0.056	0.65	0.38	0.5	0.01	0.018

熔敷金属力学性能: (605-645°C *1h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 490	≥ 390	≥ 22
例值	570	480	28

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R107

Product Description:

- R107 is a low-hydrogen coated pearlitic heat-resistant steel electrode containing 0.5% molybdenum. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding boiler pipes operating below 510°C (e.g., 15Mo) and general high-strength low-alloy steels.

Compliant with standards:

- GB/T 5118 E5015-1M3·AWS A5.5 E7015-A1·ISO 3580-B-E4915-1M3

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	Si	Mo	S	P
Standard value	≤ 0.12	≤ 1.0	≤ 0.80	0.4-0.65	≤ 0.030	≤ 0.030
Example value	0.056	0.65	0.38	0.5	0.01	0.018

Mechanical properties of deposited metal: (Heat treatment at 605-645°C * 1 h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 490	≥ 390	≥ 22
Example value	550	460	28

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R106Fe

产品说明：

- R106Fe 是铁粉低氢型药皮的含 Mo0.5% 的珠光体耐热钢焊条，交直流两用，可全位置焊接。
- 用于焊接工作温度在 510°C 以下的锅炉管道（如 15Mo），也可用于焊接一般的低合金钢。

符合标准：

- GB/T 5118 E5018-1M3·AWS A5.5 E7018-A1·ISO 3580-B-E4918-1M3

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	Mo	S	P
标准值	≤ 0.12	≤ 1.0	≤ 0.80	0.4-0.65	≤ 0.030	≤ 0.030

熔敷金属力学性能：（605-645°C *1h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 490	≥ 390	≥ 22

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺ 或 AC 空载电压 ≥ 70V）

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	90-140	140-180	170-220

BC-R106Fe

Product Description:

- R106Fe is an iron powder low-hydrogen coated pearlitic heat-resistant steel electrode containing 0.5% Mo. It is suitable for both AC and DC power supplies and allows all-position welding.
- It is used for welding boiler pipes operating below 510° C (e.g. 15Mo) and general low-alloy steels.

Compliant with standards:

- GB/T 5118 E5018-1M3·AWS A5.5 E7018-A1·ISO 3580-B-E4918-1M3

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Mo	S	P
Standard value	≤ 0.12	≤ 1.0	≤ 0.80	0.4-0.65	≤ 0.030	≤ 0.030

Mechanical properties of deposited metal: (Heat treatment at 605-645° C * 1 h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 490	≥ 390	≥ 22

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current:（DC⁺ or AC no-load voltage ≥ 70V）

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	90-140	140-180	170-220

BC-R207

产品说明：

- R207 是低氢钠型药皮的含 Cr0.5%-Mo0.5% 的珠光体耐热钢焊条，采用直流反接，可进行全位置焊接。
- 用于焊接工作温度在 510°C 以下的 CrMo 珠光体耐热钢结构 (如 12CrMo) 和高温、高压下的化学容器等相应的钢种。

符合标准：

- GB/T 5118 E5515-CM·ISO 3580-B-E5515-CM

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.03	≤ 0.03	≤ 0.80	0.4-0.65	0.4-0.65
例值	0.075	0.80	0.017	0.005	0.23	0.58	0.5

熔敷金属力学性能：(675-705°C *1h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 17
例值	640	540	25

熔敷金属 X 射线探伤要求：I 级

参考电流：(DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R207

Product Description:

- R207 is a basic coated pearlitic heat-resistant steel electrode containing 0.5%Cr and 0.5%Mo. It adopts DC reverse polarity, enabling all-position welding.
- It is suitable for welding CrMo pearlitic heat-resistant steel structures (e.g. 12CrMo) operating below 510°C, as well as corresponding steel grades for high-temperature and high-pressure chemical vessels.

Compliant with standards:

- GB/T 5118 E5515-CM·ISO 3580-B-E5515-CM

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.03	≤ 0.03	≤ 0.80	0.4-0.65	0.4-0.65
Example value	0.075	0.80	0.017	0.005	0.23	0.58	0.5

Mechanical properties of deposited metal: (Heat treatment at 675-705°C * 1 h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 17
Example value	640	540	25

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R307

产品说明：

- R307 是低氢钠型药皮的含 Cr1%-Mo0.5% 的珠光体耐热钢焊条，采用直流反接，可进行全位置焊接。
- 用于焊接工作温度在 520°C 以下的 Cr1%-Mo0.5% 耐热钢，如锅炉管道、高压容器、石油精练设备等，也可用于焊接 30CrMoSi 铸钢件。

符合标准：

- GB/T 5118 E5515-1CM·AWS A5.5 E8015-B2·ISO 3580-B-E5515-1CM

熔敷金属化学成分（质量分数）： %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.80	1.0-1.5	0.4-0.65
例值	0.065	0.65	0.017	0.007	0.4	1.15	0.54

熔敷金属力学性能：（675-705°C *1h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 17
例值	610	520	25

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	130-180	160-210

BC-R307

Product Description:

- R307 is a basic coated pearlitic heat-resistant steel electrode containing 1%Cr and 0.5%Mo. It adopts DC reverse polarity and allows all-position welding.
- It is intended for welding 1%Cr-0.5%Mo heat-resistant steels operating below 520°C, such as boiler pipes, high-pressure vessels and petroleum refining equipment. It can also be used for welding 30CrMoSi steel castings.

Compliant with standards:

- GB/T 5118 E5515-1CM·AWS A5.5 E8015-B2·ISO 3580-B-E5515-1CM

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.80	1.0-1.5	0.4-0.65
Example value	0.065	0.65	0.017	0.007	0.4	1.15	0.54

Mechanical properties of deposited metal:
(Heat treatment at 675-705°C *1h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 17
Example value	610	520	25

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC⁺）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	130-180	160-210

BC-R306Fe

产品说明：

- R306Fe 是铁粉低氢钾型药皮的含 Cr1%-Mo0.5% 的珠光体耐热钢焊条，交直流两用，短弧操作，可进行全位置焊接，焊接时焊件预热和层间温度为 160-190°C。
- 用于 Cr1%-Mo0.5% 的珠光体耐热钢（如 15CrMo）的焊接，例如，工作温度在 550°C 以下的锅炉受热面管子和工作温度在 520°C 以下的蒸汽管道，高压容器等，也可用于 30GrMoSi 铸钢件的焊接。

符合标准：

- GB/T 5118 E5518-1CM·AWS A5.5 E8018-B2·ISO 3580-B-E5518-1CM

熔敷金属化学成分（质量分数）： %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.80	1.0-15.0	0.4-0.65

熔敷金属力学性能：（675-705°C *1h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 17

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	100-130	140-180	180-210

BC-R306Fe

Product Description:

- R306Fe is an iron powder basic potassium coated pearlitic heat-resistant steel electrode with 1%Cr and 0.5%Mo. It is suitable for both AC and DC, requires short arc operation and allows all-position welding. During welding, the preheating and interpass temperature of workpieces shall be 160-190°C.
- It is used for welding 1%Cr-0.5%Mo pearlitic heat-resistant steels (e.g. 15CrMo), such as boiler heating surface tubes operating below 550°C, steam pipelines and high-pressure vessels operating below 520°C. It can also be applied to welding 30CrMoSi steel castings.

Compliant with standards:

- GB/T 5118 E5518-1CM·AWS A5.5 E8018-B2·ISO 3580-B-E5518-1CM

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.80	1.0-15.0	0.4-0.65

Mechanical properties of deposited metal: (Heat treatment at 675-705°C *1h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 17

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current:（DC⁺ or AC）

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	100-130	140-180	180-210

BC-R317

产品说明:

- R317 是低氢钠型药皮的 Cr1%-Mo0.5%-V 的珠光体耐热钢焊条，直流反接，可全位置焊接。
- 用于焊接工作温度在 540°C 以下的珠光体耐热钢 (如 12CrMoV) 结构，如高温高压锅炉管道，石油裂化设备，高温合成化工设备等。

符合标准:

- GB/T 5118 E5515-1CMV·ISO 3580-B-E5515-G

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo	V
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.4-0.65	0.10-0.35
例值	0.062	0.70	0.018	0.008	0.42	1.12	0.5	0.18

熔敷金属力学性能: (715-745°C *2h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 15
例值	630	540	24

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R317

Product Description:

- R317 is a basic coated pearlitic heat-resistant steel electrode with 1%Cr, 0.5%Mo and V. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding pearlitic heat-resistant steel structures (e.g. 12CrMoV) operating below 540°C, such as high-temperature and high-pressure boiler pipelines, petroleum cracking equipment and high-temperature synthetic chemical equipment.

Compliant with standards:

- GB/T 5118 E5515-1CMV·ISO 3580-B-E5515-G

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo	V
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.4-0.65	0.10-0.35
Example value	0.062	0.70	0.018	0.008	0.42	1.12	0.5	0.18

Mechanical properties of deposited metal: (Heat treatment at 715-745°C *2h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 15
Example value	630	540	24

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R327

产品说明:

- R327 是低氢钠型药皮的 CrMoVW 的珠光体耐热钢焊条，直流反接，可全位置焊接。
- 用于焊接工作温度在 570°C 以下的 15CrMoV 等珠光体耐热钢。

符合标准:

- GB/T 5118 E5515-1CMWV·ISO 3580-B-E5515-G

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo	V	W
标准值	0.05-0.12	0.70-1.10	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.70-1.00	0.20-0.35	0.25-0.50

熔敷金属力学性能: (715-745°C *5h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 15

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R327

Product Description:

- R327 is a basic coated pearlitic heat-resistant steel electrode with Cr, Mo, V and W. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding pearlitic heat-resistant steels such as 15CrMoV that operate below 570°C.

Compliant with standards:

- GB/T 5118 E5515-1CMWV·ISO 3580-B-E5515-G

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo	V	W
Standard value	0.05-0.12	0.70-1.10	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.70-1.00	0.20-0.35	0.25-0.50

Mechanical properties of deposited metal: (Heat treatment at 715-745°C *5h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 15

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R337

产品说明:

- R337 是低氢钠型药皮的含 CrMoVNb 的珠光体耐热钢焊条，直流反接，可全位置焊接。
- 用于焊接工作温度在 570°C 以下的 15CrMoV 等珠光体耐热钢。

符合标准:

- GB/T 5118 E5515-1CMVNb·ISO 3580-B-E5515-G

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo	V	Nb
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.70-1.00	0.15-0.40	0.10-0.25

熔敷金属力学性能: (715-745°C *5h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 15

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R337

Product Description:

- R337 is a basic coated pearlitic heat-resistant steel electrode containing Cr, Mo, V and Nb. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding pearlitic heat-resistant steels such as 15CrMoV operating below 570°C.

Compliant with standards:

- GB/T 5118 E5515-1CMVNb·ISO 3580-B-E5515-G

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	P	S	Si	Cr	Mo	V	Nb
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	0.8-1.5	0.70-1.00	0.15-0.40	0.10-0.25

Mechanical properties of deposited metal: (Heat treatment at 715-745°C *5h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 15

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R347

产品说明：

- R347 是低氢钠型药皮的含 CrMoVWB 的珠光体耐热钢焊条，直流反接，可全位置焊接。
- 用于焊接工作温度在 620°C 以下相应的珠光体耐热钢结构。如高温、高压汽轮发电机组、锅炉管道等。

符合标准：

- GB/T 5118 E5515-2CMWVB·ISO 3580-B-E5515-G

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	V	W	B
标准值	0.05-0.12	≤ 1.00	≤ 0.60	≤ 0.030	≤ 0.030	1.50-2.50	0.30-0.80	0.20-0.60	0.20-0.60	0.001-0.003

熔敷金属力学性能：（745-775°C *2h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 15

熔敷金属 X 射线探伤要求： I 级

Reference current: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R347

Product Description:

- R347 is a basic coated pearlitic heat-resistant steel electrode containing Cr, Mo, V, W and B. It adopts DC reverse polarity and allows all-position welding.
- It is suitable for welding corresponding pearlitic heat-resistant steel structures operating below 620°C, such as high-temperature and high-pressure steam turbine generator units and boiler pipelines.

Compliant with standards:

- GB/T 5118 E5515-2CMWVB·ISO 3580-B-E5515-G

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	W	B
Standard value	0.05-0.12	≤ 1.00	≤ 0.60	≤ 0.030	≤ 0.030	1.50-2.50	0.30-0.80	0.20-0.60	0.20-0.60	0.001-0.003

Mechanical properties of deposited metal:
(Heat treatment at 745-775°C *2h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 15

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R406

产品说明：

- R406 是碱性药皮的热强钢焊条。交直流两用，焊接工艺性能极佳，飞溅小，电弧稳定，脱渣容易，焊缝成型美观，全位置焊接性能优良。
- 用于焊接工作温度在 550℃ 以下的高温高压管道、合成化工机械、石油裂化设备等，如 2.5Cr1Mo 管板、A335-P22 钢管、A387Gr.22 钢板。

符合标准：

- GB/T 5118 E6216-2C1M·AWS A5.5E9016-B3·ISO 3580-B-E6216-2C1M

熔敷金属化学成分（质量分数）： %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	2.00-2.50	0.90-1.20
例值	0.068	0.72	0.015	0.008	0.26	2.32	1.08

熔敷金属力学性能：（690±15℃ *1h₀⁺¹⁰ min）

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	室温冲击功 KV ₂ (J)
标准值	≥ 620	≥ 530	≥ 15	-
例值	665	576	20	100

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC 或 AC）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R406

Product Description:

- R406 is a heat-strength steel electrode with alkaline coating. AC and DC dual-purpose, excellent welding process performance, small spatter, stable arc, easy slag removal, beautiful weld forming, excellent all-position welding performance.
- It is used for welding high-temperature and high-pressure pipelines, synthetic chemical machinery, petroleum cracking equipment, etc., such as 2.5Cr1Mo tube sheet, A335-P22 steel pipe, A387Gr.22 steel plate, etc.

Compliant with standards:

- GB/T 5118 E6216-2C1M·AWS A5.5E9016-B3·ISO 3580-B-E6216-2C1M

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 0.60	2.00-2.50	0.90-1.20
Example value	0.068	0.72	0.015	0.008	0.26	2.32	1.08

Mechanical properties of deposited metal: (690±15℃ *1h₀⁺¹⁰ min)

	Tensile strength Rm(MPa)	Yield strength Rp0.2 (MPa)	Elongation A(%)	Room temperature impact energy KV ₂ (J)
Standard value	≥ 620	≥ 530	≥ 15	-
Example value	665	576	20	100

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC 或 AC）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R407

产品说明:

- R407 是低氢钠型药皮的含 Cr2.5%-Mo1% 的珠光体耐热刚焊条，直流反接，可全位置焊接。
- 用于焊接 Cr2.5Mo 类珠光体耐热钢结构。如 550°C 以下工作的高温高压管道，合成化工设备，石油裂化设备等。

符合标准:

- GB/T 5118 E6215-2C1M·AWS A5.5 E9015-B3·ISO 3580-B-E6215-2C1M

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 1.00	2.0-2.5	0.9-1.2
例值	0.065	0.65	0.016	0.006	0.38	2.15	1.00

熔敷金属力学性能: (675-705°C *1h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 ReL (MPa)	伸长率 A(%)
标准值	≥ 620	≥ 530	≥ 15
例值	670	580	20

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R407

Product Description:

- R407 is a basic coated pearlitic heat-resistant steel electrode containing 2.5%Cr and 1%Mo. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding Cr2.5Mo series pearlitic heat-resistant steel structures, such as high-temperature and high-pressure pipelines, synthetic chemical equipment and petroleum cracking equipment operating below 550°C.

Compliant with standards:

- GB/T 5118 E6215-2C1M·AWS A5.5 E9015-B3·ISO 3580-B-E6215-2C1M

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.030	≤ 0.030	≤ 1.00	2.0-2.5	0.9-1.2
Example value	0.065	0.65	0.016	0.006	0.38	2.15	1.00

Mechanical properties of deposited metal: (Heat treatment at 675-705°C *1h)

	Tensile strength Rm(MPa)	Yield strength Rel or ReL (MPa)	Elongation A(%)
Standard value	≥ 620	≥ 530	≥ 15
Example value	670	580	20

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R406Fe

产品说明:

- R406Fe 是碱性 + 铁粉型药皮的热强钢焊条。具有高温抗氧侵蚀性能。交直流两用，短弧操作，可进行全位置焊接。
- 用于焊接铬 2.5 钼类 (2.25CrMo 等) 低合金钢结构，如 550°C 以下工作的高温高压管道、化工机械、石油裂化设备等。

符合标准:

- GB/T 5118 E6218-2C1M·AWS A5.5 E9018-B3·ISO 3580-B-E6218-2C1M

熔敷金属化学成分 (质量分数) : %

	C	Mn	P	S	Si	Cr	Mo
标准值	0.05-0.12	≤ 0.90	≤ 0.03	≤ 0.03	≤ 1.00	2.00-2.50	0.90-1.20
例值	0.08	0.75	0.012	0.010	0.24	2.34	1.14

熔敷金属力学性能: (690±15°C *1h₀⁺¹⁰min)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)	室温冲击功 KV ₂ (J)
标准值	≥ 620	≥ 530	≥ 15	-
例值	680	580	20	180

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺ 或 AC 空载电压 ≥ 70V)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R406Fe

Product Description:

- R406Fe is a heat-strength steel electrode with alkaline + iron powder type coating. It has high temperature oxidation resistance properties. AC and DC dual-purpose, short arc operation, can be used for all-position welding.
- It is used for welding chromium 2.5 molybdenum (2.25CrMo, etc.) low alloy steel structures, such as high-temperature and high-pressure pipelines, chemical machinery, petroleum cracking equipment, etc.

Compliant with standards:

- GB/T 5118 E6218-2C1M·AWS A5.5 E9018-B3·ISO 3580-B-E6218-2C1M

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	P	S	Si	Cr	Mo
Standard value	0.05-0.12	≤ 0.90	≤ 0.03	≤ 0.03	≤ 1.00	2.00-2.50	0.90-1.20
Example value	0.08	0.75	0.012	0.010	0.24	2.34	1.14

Mechanical properties of deposited metal: (690±15°C *1h₀⁺¹⁰min)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)	Room temperature impact energy KV ₂ (J)
Standard value	≥ 620	≥ 530	≥ 15	-
Example value	680	580	20	180

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺ or AC No-load voltage ≥ 70V)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R417

产品说明：

- R417 是低氢钠型药皮的含 CrMoVNb 的珠光体耐热钢焊条，直流反接，可全位置焊接。
- 用于焊接工作温度在 620°C 以下的 12Cr3MoVSiTb 类珠光体耐热钢结构，如高温高压锅炉、管道等。

符合标准：

- GB/T 5118 E5515-2CMVNb·ISO 3580-B-E5515-G

熔敷金属化学成分（质量分数）： %

	C	Mn	P	S	Si	Cr	Mo	Nb	V
标准值	0.05-0.12	≤ 1.00	≤ 0.03	≤ 0.03	≤ 0.60	2.40-3.00	0.70-1.00	0.35-0.65	0.25-0.50

熔敷金属力学性能：（715-745°C *4h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 550	≥ 460	≥ 15

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	140-180	170-210

BC-R417

Product Description:

- R417 i is a basic coated pearlitic heat-resistant steel electrode containing Cr, Mo, V and Nb. It adopts DC reverse polarity and allows all-position welding.
- It is used for welding pearlitic heat-resistant steel structures such as 12Cr3MoVSiTb operating below 620°C , including high-temperature and high-pressure boilers and pipelines.

Compliant with standards:

- GB/T 5118 E5515-2CMVNb·ISO 3580-B-E5515-G

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Mn	P	S	Si	Cr	Mo	Nb	V
Standard value	0.05-0.12	≤ 1.00	≤ 0.03	≤ 0.03	≤ 0.60	2.40-3.00	0.70-1.00	0.35-0.65	0.25-0.50

Mechanical properties of deposited metal: (Heat treatment at 715-745°C *4h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 550	≥ 460	≥ 15

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC⁺）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	140-180	170-210

BC-R717

产品说明:

- R717 是低氢钠型药皮的含 Cr9%-Mo1%-Ni0.8%-V 的贝氏体 - 马氏体耐热钢焊条, 直流反接, 短弧操作, 可进行全位置焊接。
- 用于焊接 Cr9MoNiV(如 T91/P91) 耐热钢结构及过热器管道等。

符合标准:

- GB/T 5118 E6215-9C1MV·AWS A5.5 E9015-B9
- ISO 3580-B-E6215-9C1MV

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr
标准值	0.08-0.13	≤ 1.25	≤ 0.30	≤ 0.01	≤ 0.01	≤ 1.0	8.0-10.50
	Mo	V	Nb	N	Cu	Al	
标准值	0.85-1.20	0.15-0.30	0.02-0.10	0.02-0.07	≤ 0.25	≤ 0.04	

熔敷金属力学性能: (745-775°C *2h 热处理)

	抗拉强度 Rm(MPa)	屈服强度 Rel 或 Rp0.2 (MPa)	伸长率 A(%)
标准值	≥ 620	≥ 530	≥ 15

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	400	400
焊接电流 (A)	60-90	90-120	130-170	170-210

BC-R717

Product Description:

- R717 is a basic coated bainitic-martensitic heat-resistant steel electrode containing 9%Cr, 1%Mo, 0.8%Ni and V. It adopts DC reverse polarity, requires short arc operation and enables all-position welding.
- It is used for welding Cr9MoNiV heat-resistant steel structures (e.g. T91/P91) and superheater pipelines.

Compliant with standards:

- GB/T 5118 E6215-9C1MV·AWS A5.5 E9015-B9
- ISO 3580-B-E6215-9C1MV

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	S	P	Ni	Cr
Standard value	0.08-0.13	≤ 1.25	≤ 0.30	≤ 0.01	≤ 0.01	≤ 1.0	8.0-10.50
	Mo	V	Nb	N	Cu	Al	
Standard value	0.85-1.20	0.15-0.30	0.02-0.10	0.02-0.07	≤ 0.25	≤ 0.04	

Mechanical properties of deposited metal: (Heat treatment at 745-775°C *2h)

	Tensile strength Rm(MPa)	Yield strength Rel or Rp0.2 (MPa)	Elongation A(%)
Standard value	≥ 620	≥ 530	≥ 15

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	300	350	400	400
Welding current (A)	60-90	90-120	130-170	170-210

BC-D212

产品说明:

- D212是钛钙型药皮的CrMo型堆焊焊条。可交直流两用，堆焊时电弧稳定，脱渣容易。
- 用于单层或多层堆焊各种受磨损的机件表面，如齿轮、挖斗、矿山机械等。

符合标准:

- GB/T 984 EDPCrMo-A4-03

熔敷金属化学成分 (质量分数) : %

	C	Cr	Mo
标准值	0.30-0.60	≤ 5.00	≤ 4.00
例值	0.45	4.00	0.35

堆焊层硬度: HRC ≥ 50

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	90-120	150-180	190-230

BC-D212

Product Description:

- D212 is a titanium-calcium coating overlay electrode. It can be used for both AC and DC, the arc is stable during surfacing welding, and the slag removal is easy.
- It is used for single-layer or multi-layer surfacing welding of various worn parts surfaces, such as gears, buckets, mining machinery, etc.

Compliant with standards:

- GB/T 984 EDPCrMo-A4-03

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Cr	Mo
Standard value	0.30-0.60	≤ 5.00	≤ 4.00
Example value	0.45	4.00	0.35

Hardness of deposited metal: HRC ≥ 50

Reference current: (DC⁺ or AC)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	90-120	150-180	190-230

BC-D256

产品说明:

- D256 是低氢钾型药皮的堆焊焊条。可交直流两用，堆焊时，宜用小电流，窄道焊，并趁红热时锤击或水淬，以减少裂纹倾向。焊缝金属为奥氏体高锰钢，具有加工硬化，坚韧和耐磨的特点。
- 用于破碎机、钢轨、推土机等受冲击易磨损件的堆焊。

符合标准:

- GB/T 984 EDMn-A-16

熔敷金属化学成分 (质量分数) : %

	C	Si	Mn	其他
标准值	≤ 1.10	≤ 1.30	11.0-16.00	≤ 5.00
例值	0.6	0.4	13.30	-

堆焊层硬度: HB ≥ 170

参考电流: (DC⁺ 或 AC 空载电压 ≥ 70V)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	70-90	100-140	150-180

BC-D256

Product Description:

- D256 is a low-hydrogen potassium type coating overlay electrode. It can be used for both AC and DC, and when surfacing welding, it is advisable to use small current, narrow channel welding, and hammer or water quenching when it is red hot to reduce the crack tendency. The weld metal is austenitic high manganese steel, which has the characteristics of work hardening, toughness and wear resistance.
- It is used for surfacing welding of crushers, rails, bulldozers and other impact-prone wear parts.

Compliant with standards:

- GB/T 984 EDMn-A-16

Chemical Composition of Deposition Metal (Mass Fraction): %

	C	Si	Mn	Other
Standard value	≤ 1.10	≤ 1.30	11.0-16.00	≤ 5.00
Example value	0.6	0.4	13.30	-

Hardness of deposited metal: HB ≥ 170

Reference current: (DC⁺ or AC No-load voltage ≥ 70V)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	70-90	100-140	150-180

BC-D507

产品说明:

- D507 是低氢钠型药皮的 1Cr13 型阀门堆焊焊条。堆焊金属为 1Cr13 半铁素体高铬钢。堆焊层具有空淬特性，一般不需要进行热处理，硬度均匀，亦可在 750°C ~800°C 退火软化。当加热至 900~1000°C 空冷或油淬后，可重新硬化。采用直流反接。
- 这是一种通用性的表面堆焊用焊条，用于堆焊工作温度在 450°C 以下的碳钢或合金钢的轴及阀门等。

符合标准:

- GB/T 984 EDCr-A1-15

熔敷金属化学成分 (质量分数) : %

	C	Cr	S	P	其他
标准值	≤ 0.15	10-16	≤ 0.03	≤ 0.04	≤ 2.5
例值	0.13	13.35	0.006	0.019	-

堆焊层硬度: (焊后空冷) HRC ≥ 40

参考电流: (DC⁺)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	80-120	120-160	160-200

BC-D507

Product Description:

- D507 is a low-hydrogen sodium-type coated 1Cr13 valve surfacing electrode. The surfacing metal is 1Cr13 semi-ferritic high-chromium steel. The surfacing layer features air-hardening property, generally requiring no heat treatment, with uniform hardness; it can also be annealed for softening at 750°C ~800°C . It can be re-hardened after heating to 900~1000°C followed by air cooling or oil quenching. DC reverse polarity is adopted.
- As a universal electrode for surface surfacing, it is applicable to surfacing shafts, valves and other components made of carbon steel or alloy steel that work below 450°C .

Compliant with standards:

- GB/T 984 EDCr-A1-15

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Cr	S	P	其他
Standard value	≤ 0.15	10-16	≤ 0.03	≤ 0.04	≤ 2.5
Example value	0.13	13.35	0.006	0.019	-

Overlay Hardness: (Air-cooled after welding) HRC ≥ 40

Reference current: (DC⁺)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	300	350	350
Welding current (A)	80-120	120-160	160-200

BC-D507Mo

产品说明:

- D507Mo 是低氢钠型药皮的 1Cr13 型阀门堆焊焊条。堆焊金属为 1Cr13 半铁素体高铬钢。堆焊层具有空淬特性，堆焊金属具有较高的中温硬度，良好的热稳定性，抗冲蚀性。与 D577 焊条配合使用，能获得良好的抗擦伤性能，采用直流反接，堆焊工艺简单，焊前不预热，焊后不处理。
- 用于堆焊工作温度在 510°C 以下的中温高压截止阀密封面。闸阀密封面应将本焊条与 D557 焊条配合使用（阀座与阀瓣分别用以上两种焊条）。

符合标准:

- GB/T 984 EDCr-A2-15

熔敷金属化学成分（质量分数）： %

	C	Cr	Ni	Mo	W	其他
标准值	≤ 0.20	10.00-16.00	≤ 6.00	≤ 2.50	≤ 2.00	≤ 2.50
例值	0.12	11.8	3.5	0.45	1.20	-

堆焊层硬度：（焊后空冷）HRC ≥ 37（耐软化至 510°C）

参考电流：（DC⁺）

焊条直径（mm）	3.2	4.0	5.0
焊条长度（mm）	350	400	400
焊接电流（A）	80-120	120-160	160-200

BC-D507Mo

Product Description:

- D507Mo is a low-hydrogen sodium-type coated 1Cr13 valve surfacing electrode. The surfacing metal is 1Cr13 semi-ferritic high-chromium steel. The surfacing layer has air-hardening property, and the surfacing metal features high medium-temperature hardness, excellent thermal stability and erosion resistance. When used in conjunction with D577 electrode, it delivers excellent anti-seizure performance. It adopts DC reverse polarity, with simple surfacing process, no preheating required before welding and no treatment needed after welding.
- It is suitable for surfacing the sealing surfaces of medium-temperature and high-pressure globe valves operating below 510°C. For the sealing surfaces of gate valves, this electrode shall be used together with D557 electrode (the valve seat and valve disc are surfaced with the two electrodes respectively).

Compliant with standards:

- GB/T 984 EDCr-A2-15

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Cr	Ni	Mo	W	Other
Standard value	≤ 0.20	10.00-16.00	≤ 6.00	≤ 2.50	≤ 2.00	≤ 2.50
Example value	0.12	11.8	3.5	0.45	1.20	-

Overlay Hardness: (Air-cooled after welding)
HRC ≥ 37 (Resistant to softening up to 510°C)

Reference current:（DC⁺）

Diameter（mm）	3.2	4.0	5.0
Length（mm）	350	400	400
Welding current（A）	80-120	120-160	160-200

BC-D577

产品说明:

- D577 是低氢钠型药皮，合金钢芯的铬锰型阀门堆焊焊条。采用直流反接，堆焊金属为高铬锰型奥氏体钢，故冷作硬化效果显著，具有良好的抗擦伤性能，有一定的中温硬度，较好的热稳定性，如与 D507Mo 配合使用，可获得很好的抗擦伤性能，该焊条抗裂性好，堆焊金属切削加工性能良好。
- 用于堆焊工作温度在 510°C 以下的中温高压阀门密封面，在闸阀中如与 D507Mo 配合使用，使用寿命更高。

符合标准:

- GB/T 984 EDCrMn-C-15

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	其他
标准值	≤ 1.1	12.0-18.0	≤ 2.0	12.0-18.0	≤ 6.00	≤ 4.0	≤ 3.0

堆焊层硬度: HRC ≥ 28

参考电流: (DC⁺)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	80-120	120-160	160-200

BC-D577

Product Description:

- D577 is a Cr-Mn valve surfacing electrode with low-hydrogen sodium-type coating and alloy steel core. Adopting DC reverse polarity, its surfacing metal is high Cr-Mn austenitic steel, featuring remarkable work-hardening effect, excellent anti-seizure performance, certain medium-temperature hardness and good thermal stability. Especially when used in conjunction with D507Mo, it delivers superior anti-seizure performance. This electrode has good crack resistance and the surfacing metal offers excellent machinability.
- It is suitable for surfacing the sealing surfaces of medium-temperature and high-pressure valves operating below 510°C. When matched with D507Mo for gate valves, it achieves longer service life.

Compliant with standards:

- GB/T 984 EDCrMn-C-15

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	Mo	Other
Standard value	≤ 1.1	12.0-18.0	≤ 2.0	12.0-18.0	≤ 6.00	≤ 4.0	≤ 3.0

Overlay Hardness: HRC ≥ 28

Reference current: (DC⁺)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	80-120	120-160	160-200

BC-D608

产品说明:

- D608 是石墨型药皮的 CrMo 铸铁堆焊焊条。可交直流两用，但采用直流反接更适宜。由于堆焊金属为铸铁组织的铬、钼碳化物，因此堆焊层具有较高的硬度和耐磨性，对泥沙及矿石的磨耗有良好的抵抗能力。
- 可用于农业机械、矿山设备等承受砂粒磨损与轻微冲击的零件。

符合标准:

- GB/T984 EDZ-A1-08

熔敷金属化学成分 (质量分数) : %

	C	Cr	Mo
标准值	2.50-4.50	3.00-5.00	3.00-5.00
例值	3.5	3.56	4.00

堆焊层硬度: HRC \geq 55参考电流: (DC⁺)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	90-120	120-160	170-210

BC-D608

Product Description:

- D608 is a graphite-type coating overlay electrode. It can be used for both AC and DC, but it is more suitable to use reverse DC connection. Because the surfacing metal is chromium and molybdenum carbide with cast iron structure, the surfacing layer has high hardness and wear resistance, and has good resistance to the abrasion of sediment and ore.
- It can be used for agricultural machinery, mining equipment and other parts that are subject to sand wear and slight impact.

Compliant with standards:

- GB/T984EDZ-A1-08

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Cr	Mo
Standard value	2.50-4.50	3.00-5.00	3.00-5.00
Example value	3.5	3.56	4.00

Overlay Hardness: HRC \geq 55Reference current: (DC⁺)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	90-120	120-160	170-210

BC-D707

产品说明:

- D707 是采用碳钢为焊芯的低氢钠型药皮碳化钨堆焊焊条，依靠药皮中碳化物合金过渡，堆焊金属含钨量 40%~50%，由于药皮较厚，因而焊接过程中套筒较长，药皮发红后易小块脱落，所以宜用直流反接，使用较小的电流。
- 用于堆焊耐岩石强烈磨损之机械零件，如混凝土搅拌叶片、推土机和泵浦叶片、挖泥机叶片、高速混砂箱等。

符合标准:

- GB/T 984 EDW-A-15

熔敷金属化学成分 (质量分数) : %

	C	Si	Mn	W
标准值	1.50-3.00	≤ 4.00	≤ 2.00	40.00-50.00

堆焊层硬度: HRC ≥ 60

参考电流: (DC⁺)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	70-120	140-180	180-220

BC-D707

Product Description:

- D707 is a tungsten carbide surfacing electrode with a mild steel core and low-hydrogen sodium-type coating. Carbide alloy transfer relies on the coating, with the tungsten content of the surfacing metal ranging from 40% to 50%. Owing to the thick coating, the sleeve remains long during welding, and small pieces tend to fall off when the coating turns red. Therefore, DC reverse polarity and a relatively low current are recommended.
- It is used for surfacing mechanical parts subject to severe abrasion by rocks, such as concrete mixer blades, bulldozer and pump impellers, dredger blades, and high-speed sand mixing boxes.

Compliant with standards:

- GB/T 984 EDW-A-15

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Si	Mn	W
Standard value	1.50-3.00	≤ 4.00	≤ 2.00	40.00-50.00

Overlay Hardness: HRC ≥ 60

Reference current: (DC⁺)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	70-120	140-180	180-220

BC-E6013(J421)

产品说明:

- J421 是氧化钛型药皮的碳钢焊条。交直流两用，可进行全位置焊接。具有优异的焊接工艺性能，操作性能良好，再引弧容易。电弧稳定，焊缝成形美观。
- 焊接低碳钢结构，特别适用于薄板小件短焊缝的间断焊和要求表面光洁的盖面焊。

符合标准:

- GB/T 5117 E4313 · AWS A5.1 E6013 · ISO 2560-B-E43 13 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.0	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.07	0.4	0.25	0.025	0.02	0.03	0.005	0.01	0.02

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	冲击功 KV ₂ (J)0°C
标准值	≥ 430	≥ 330	≥ 17	≥ 47
例值	485	380	28	86

熔敷金属 X 射线探伤要求: II 级

参考电流: (DC 或 AC)

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	350	400	400
焊接电流 (A)	40-70	50-90	90-130	130-210	170-230

BC-E6013(J421)

Product Description:

- is a carbon steel electrode with rutile-type coating. It is suitable for both AC and DC power supplies and allows all-position welding. It features excellent welding process performance, good operability and easy arc restarting, with stable arc and attractive weld appearance.
- It is used for welding low-carbon steel structures, especially suitable for intermittent welding of thin-plate small parts and short welds, as well as cover pass welding requiring smooth surface finish.

Compliant with standards:

- GB/T 5117 E4313 · AWS A5.1 E6013 · ISO 2560-B-E43 13 A

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.0	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.07	0.4	0.25	0.025	0.02	0.03	0.005	0.01	0.02

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at 0°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 17	≥ 47
Example value	485	380	28	86

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC or AC)

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	350	350	400	400
Welding current (A)	40-70	50-90	90-130	130-210	170-230

BC-J421Fe18

产品说明：

- J421Fe18 是铁粉氧化钛型药皮的碳钢焊条，交、直流两用，适用于平焊、平角焊。再引弧容易，飞溅小，脱渣容易；焊缝成形美观，熔敷效率达 180% 左右。
- 用于一般低碳钢结构的平焊、平角焊。

符合标准：

- GB/T 5117 E4324 · ISO 2560-B-E43 24 A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Ni	Mo	V
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.20	≤ 0.3	≤ 0.30	≤ 0.08
例值	0.075	0.78	0.4	0.023	0.014	0.035	0.025	0.007	0.008

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL(MPa)	伸长率 A(%)	常温冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 17	-
例值	510	420	26	96

熔敷金属 X 射线探伤要求：II 级

参考电流：（DC 或 AC）

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	110-160	160-240	210-270

BC-J421Fe18

Product Description:

- J421Fe18 a carbon steel electrode with iron powder rutile-type coating, suitable for both AC and DC power supplies and applicable to flat welding and fillet welding in the flat position. It features easy arc restart, low spatter and easy slag removal, with attractive weld appearance and a deposition efficiency of about 180% respectively..
- For flat welding and flat fillet welding of general low-carbon steel structures.

Compliant with standards:

- GB/T 5117 E4324 · ISO 2560-B-E43 24 A

Chemical Composition of Deposition Metal
(Mass Fraction)：%

	C	Mn	Si	P	S	Cr	Ni	Mo	V
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.20	≤ 0.3	≤ 0.30	≤ 0.08
Example value	0.075	0.78	0.4	0.023	0.014	0.035	0.025	0.007	0.008

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Charpy impact energy at room temperature KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 17	-
Example value	510	420	26	96

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC or AC）

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	110-160	160-240	210-270

BC-J422

产品说明：

- J422 是钛钙型药皮的碳钢焊条。交直流两用，可进行全位置焊接。具有优良的焊接工艺性能及良好的力学性能；电弧稳定，飞溅小，脱渣易，再引弧容易；焊缝成形美观，焊波可宽、可窄、可薄、可厚，焊接轻松，效率高。
- 用于焊接较重要的低碳钢结构和强度等级低的低合金钢结构，如 Q235、09MnV、09Mn2 等

符合标准：

- GB/T 5117 E4303 · ISO 2560-B-E43 03 A

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Cr	Ni	Mo	V
标准值	≤ 0.20	≤ 1.20	≤ 1.00	≤ 0.040	≤ 0.035	≤ 0.20	≤ 0.30	≤ 0.30	≤ 0.08
例值	0.077	0.40	0.18	0.025	0.018	0.032	0.05	0.005	0.01

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	0°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 20	≥ 27
例值	480	390	27	97

熔敷金属 X 射线探伤要求： II 级

参考电流：（DC 或 AC）

焊条直径 (mm)	2.0	2.5	3.2	4.0	5.0
焊条长度 (mm)	300	350	350	400	400
焊接电流 (A)	40-70	60-100	180-140	140-220	180-240

BC-J422

Product Description:

- J422 is a non-alloy steel electrode, the coating type is titanium type, suitable for all-position welding, AC and DC dual-purpose. It has excellent welding process performance, stable arc, beautiful weld bead and less spatter.
- It is used for welding general carbon steel structures and low-alloy steels with low strength grades, such as 09Mn2, etc.

Compliant with standards:

- GB/T 5117 E4303 · ISO 2560-B-E43 03 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Ni	Mo	V
Standard value	≤ 0.20	≤ 1.20	≤ 1.00	≤ 0.040	≤ 0.035	≤ 0.20	≤ 0.30	≤ 0.30	≤ 0.08
Example value	0.077	0.40	0.18	0.025	0.018	0.032	0.05	0.005	0.01

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at 0°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 20	≥ 27
Example value	480	390	27	97

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC or AC）

Diameter (mm)	2.0	2.5	3.2	4.0	5.0
Length (mm)	300	350	350	400	400
Welding current (A)	40-70	60-100	180-140	140-220	180-240

BC-J423(E6019)

产品说明:

- J423 是钛铁矿型药皮酸性焊条。交、直流两用,平焊、平角焊工艺性能良好,具有良好的力学性能,抗裂性好。电弧稳定,飞溅较小。
- 用于焊接较重要相应强度级别的低碳钢结构。

符合标准:

- GB/T 5117 E4319·AWS A5.1 E6019·ISO 2560-B-E4319 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.08	0.37	0.13	0.025	0.02	0.035	0.005	0.004	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL/Rp0.2(MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 20	≥ 27
例值	490	410	28	70

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC 或 AC)

焊条直径 (mm)	3.2	4.0	5.0	5.8
焊条长度 (mm)	350	400	400	400
焊接电流 (A)	90-140	150-210	200-270	250-310

BC-J423(E6019)

Product Description:

- J423 is an acidic electrode with ilmenite-type coating. It is suitable for both AC and DC power supplies, featuring excellent welding process performance in flat welding and flat fillet welding, good mechanical properties and high crack resistance, along with stable arc and low spatter.
- It is used for welding important low-carbon steel structures of corresponding strength grade.

Compliant with standards:

- GB/T 5117 E4319·AWS A5.1 E6019·ISO 2560-B-E4319 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.08	0.37	0.13	0.025	0.02	0.035	0.005	0.004	0.03

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL/Rp0.2(MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 20	≥ 27
Example value	490	410	28	70

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC or AC)

Diameter (mm)	3.2	4.0	5.0	5.8
Length (mm)	350	400	400	400
Welding current (A)	90-140	150-210	200-270	250-310

BC-J424(E6020)

产品说明：

- J424 是非合金钢焊条，药皮类型为氧化铁型，适用于平焊、平角焊，交流和直流反接，熔深大，熔化速度快，由于熔敷金属锰含量较高，抗裂性能较好。
- 用于一般碳钢结构，如重型机械、建筑机械等的焊接。

符合标准：

- GB/T 5117 E4320·AWS A5.1 E6020·ISO 2560-B-E4320 A

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.075	0.63	0.10	0.027	0.018	0.015	0.008	0.01	0.07

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 430	≥ 330	≥ 20
例值	470	370	26

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC 或 AC）

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	350	400	400
焊接电流 (A)	80-110	150-190	190-250

BC-J424(E6020)

Product Description：

- J424 is a non-alloy steel electrode, the coating type is iron oxide type, suitable for flat welding, flat fillet welding, AC and DC reverse connection, large penetration depth, fast melting speed, due to the high content of manganese in the deposited metal, good crack resistance.
- It is used for the welding of general carbon steel structures, such as heavy machinery, construction machinery, etc.

Compliant with standards：

- GB/T 5117 E4320·AWS A5.1 E6020·ISO 2560-B-E4320 A

Chemical Composition of Deposition Metal
(Mass Fraction)： %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.075	0.63	0.10	0.027	0.018	0.015	0.008	0.01	0.07

Mechanical properties of deposited metal：

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 430	≥ 330	≥ 20
Example value	470	370	26

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC or AC）

Diameter (mm)	3.2	4.0	5.0
Length (mm)	350	400	400
Welding current (A)	80-110	150-190	190-250

BC-J424Fe16(E6027)

产品说明：

- J424Fe16 是非合金钢焊条，药皮类型为氧化铁 + 铁粉型，适用于平焊、平角焊、交直流两用，电弧吹力大、熔深大、熔化速度快。
- 用于焊接较重要的碳钢结构。

符合标准：

- GB/T 5117 E4327 · AWS A5.1E6027 · ISO 2560-B-E4327A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.071	0.67	0.27	0.022	0.015	0.018	0.005	0.01	0.05

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 20	≥ 27
例值	450	355	30	75

熔敷金属 X 射线探伤要求：II 级

Reference current: (DC 或 AC)

焊条直径 (mm)	3.2	4.0	5.0
焊条长度 (mm)	400	450	450
焊接电流 (A)	110-150	140-220	180-260

BC-J424Fe16(E6027)

Product Description:

- J424Fe16 is a non-alloy steel electrode, the coating type is iron oxide + iron powder type, suitable for flat welding, flat fillet welding, AC and DC dual-purpose, with large arc blowing force, large penetration depth and fast melting speed.
- It is used to weld the more important carbon steel structure.

Compliant with standards:

- GB/T 5117 E4327 · AWS A5.1E6027 · ISO 2560-B-E4327A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.071	0.67	0.27	0.022	0.015	0.018	0.005	0.01	0.05

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 20	≥ 27
Example value	450	355	30	75

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC or AC)

Diameter (mm)	3.2	4.0	5.0
Length (mm)	400	450	450
Welding current (A)	110-150	140-220	180-260

BC-J426

产品说明：

- J426 是低氢钾型药皮的碳钢焊条。交直流两用，可进行全位置焊接。其熔敷金属具有优良的力学性能和抗裂性能，低温冲击韧性好。
- 用于焊接重要的低碳钢和低合金钢的结构，如造船、桥梁、压力容器等。

符合标准：

- GB/T 5117 E4316·ISO 2560-B-E43 16 A

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.065	0.83	0.3	0.019	0.009	0.03	0.005	0.018	0.03

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 20	≥ 27
例值	495	395	33	170

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	80-140	110-210	160-230

BC-J426

Product Description:

- J426 is a carbon steel electrode with low-hydrogen potassium-type coating. It is suitable for both AC and DC power supplies and allows all-position welding. Its deposited metal has excellent mechanical properties, good crack resistance and high low-temperature impact toughness.
- It is used for welding important low-carbon steel and low-alloy steel structures such as shipbuilding, bridges and pressure vessels.

Compliant with standards:

- GB/T 5117 E4316·ISO 2560-B-E43 16 A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.065	0.83	0.3	0.019	0.009	0.03	0.005	0.018	0.03

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 20	≥ 27
Example value	495	395	33	170

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC⁺ or AC）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	80-140	110-210	160-230

BC-J427

产品说明:

- J427 是低氢钠型药皮的碳钢焊条。采用直流反接，可进行全位置焊接。其熔敷金属具有优良的力学性能和抗裂性能，低温冲击韧性好。
- 用于焊接重要受压载荷或低碳钢厚板结构和低合金钢的结构，如机械、造船、桥梁、压力容器等。

符合标准:

- GB/T 5117 E4315·ISO 2560-B-E43 15 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.075	0.85	0.5	0.020	0.01	0.03	0.005	0.01	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 20	≥ 27
例值	520	440	30	142

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	80-140	110-210	160-230

BC-J427

Product Description:

- J427 is a carbon steel electrode with low-hydrogen sodium-type coating. It adopts DC reverse polarity and allows all-position welding. Its deposited metal has excellent mechanical properties, good crack resistance and superior low-temperature impact toughness.
- It is used for welding important structures under compressive load, thick-plate low-carbon steel structures and low-alloy steel structures, such as machinery, shipbuilding, bridges and pressure vessels.

Compliant with standards:

- GB/T 5117 E4315·ISO 2560-B-E43 15 A

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.2	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.075	0.85	0.5	0.020	0.01	0.03	0.005	0.01	0.03

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 20	≥ 27
Example value	520	440	30	142

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	80-140	110-210	160-230

BC-J501Fe(E7014)

产品说明:

- J501Fe 是铁粉氧化钛型药皮的碳钢焊条。熔敷效率为 110% 左右。交直流两用,可进行全位置焊接。具有优异的焊接工艺性能,电弧稳定,飞溅小,脱渣容易;焊缝成形美观。
- 用于碳钢和低合金结构的焊接,如 16Mn 等船舶、车辆及机械结构的焊接。

符合标准:

- GB/T 5117 E5014·AWS A5.1 E7014·ISO 2560-B-E49 14 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.25	≤ 0.90	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.085	0.65	0.25	0.025	0.015	0.032	0.005	0.015	0.032

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	0°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 16	-
例值	530	435	25	69

熔敷金属 X 射线探伤要求: II 级

参考电流: (DC 或 AC)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	70-90	90-130	160-210	210-250

BC-J501Fe(E7014)

Product Description:

- J501Fe is a carbon steel electrode with iron powder rutile-type coating. Its deposition efficiency is about 110%. Suitable for both AC and DC, it allows all-position welding. It features excellent welding process performance, stable arc, low spatter and easy slag removal, with attractive weld appearance.
- It is used for welding carbon steel and low-alloy structures, such as ships, vehicles and mechanical structures made of 16Mn and other steels.

Compliant with standards

- GB/T 5117 E5014·AWS A5.1 E7014·ISO 2560-B-E49 14 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.25	≤ 0.90	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.085	0.65	0.25	0.025	0.015	0.032	0.005	0.015	0.032

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at 0°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 16	-
Example value	530	435	25	69

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	70-90	90-130	160-210	210-250

BC-J501Fe18(E7024)

产品说明：

- J501Fe18 是铁粉氧化钛型药皮的高效碳钢焊条。熔敷效率达 180% 左右。交直流两用，适宜船形焊、平焊、平角焊。电弧稳定，飞溅小，脱渣容易，焊缝成形美观。
- 用于碳钢和低合金结构的焊接，如 A、B、D 级钢，16Mn 等船舶、机车车辆及锅炉等结构的焊接。

符合标准：

- GB/T 5117 E5024 · AWS A5.1 E7024 · ISO 2560-B-E49 24 A

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.25	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.08	0.9	0.48	0.022	0.010	0.035	0.005	0.014	0.032

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	0°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 16	≥ 47
例值	540	465	29	79

熔敷金属 X 射线探伤要求： II 级

参考电流：（DC 或 AC）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	90-130	130-160	140-200	160-220

BC-J501Fe18(E7024)

Product Description:

- J501Fe18 is a high-efficiency carbon steel electrode with iron powder rutile-type coating. Its deposition efficiency is about 180%. Suitable for both AC and DC power supplies, it is ideal for fillet welding in flat position, flat welding and flat fillet welding. It features stable arc, low spatter, easy slag removal and attractive weld appearance.
- It is used for welding carbon steel and low-alloy steel structures, such as ships, rolling stock and boilers made of Grade A, B, D steels and 16Mn steel.

Compliant with standards:

- GB/T 5117 E5024 · AWS A5.1 E7024 · ISO 2560-B-E49 24 A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.25	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.08	0.9	0.48	0.022	0.010	0.035	0.005	0.014	0.032

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at 0°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 16	≥ 47
Example value	540	465	29	79

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC or AC）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	90-130	130-160	140-200	160-220

BC-J502

产品说明:

- J502 是钛钙型药皮的碳钢焊条。交直流两用，可进行全位置焊接。具有优良的焊接工艺性能和力学性能，电弧稳定，飞溅很少，脱渣容易；焊缝成形美观
- 用于 490MPa 抗拉强度等级的低合金钢结构的焊接，如建筑用螺纹钢及其它 16Mn 等结构钢的焊接。

符合标准:

- GB/T 5117 E5003·ISO 2560-B-E49 03 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.25	≤ 0.9	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.10	0.75	0.27	0.025	0.015	0.036	0.01	0.01	0.025

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	0°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 47
例值	530	440	25	96

熔敷金属 X 射线探伤要求: II 级

参考电流: (DC 或 AC)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	80-140	140-220	180-240

BC-J502

Product Description:

- J502 is a carbon steel electrode with titania-calcium type coating. It is suitable for both AC and DC power supplies and allows all-position welding. It features excellent welding process performance and mechanical properties, with stable arc, minimal spatter, easy slag removal and attractive weld appearance.
- It is used for welding low-alloy steel structures with a tensile strength grade of 490MPa, such as construction deformed steel bars and other structural steels like 16Mn.

Compliant with standards:

- GB/T 5117 E5003·ISO 2560-B-E49 03 A

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.25	≤ 0.9	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.10	0.75	0.27	0.025	0.015	0.036	0.01	0.01	0.025

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at 0°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 47
Example value	530	440	25	96

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	80-140	140-220	180-240

BC-J502WCu

产品说明：

- J502WCu 是耐候钢专用细晶粒钢焊条，药皮类型为钛型，全位置焊接，交直流两用，焊接工艺性能良好，焊缝金属具有良好的耐大气腐蚀性能。
- 为耐候钢专用焊条。用于铁路耐候车辆的焊接。亦可用于其它低合金钢。如：09MnCuPTi、Q355 等。

符合标准：

- GB/T 5117 E5003-G

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cu	W
标准值	≤ 0.12	0.30-0.90	≤ 0.40	≤ 0.035	≤ 0.030	0.20-0.50	0.20-0.50
例值	0.080	0.51	0.23	0.025	0.014	0.38	0.32

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 22	≥ 27
例值	550	460	25	52

熔敷金属 X 射线探伤要求：II 级

参考电流：（DC 或 AC）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	70-90	110-140	160-200	200-260

BC-J502WCu

Product Description:

- J502WCu is a special fine-grained steel electrode for weathering steel, the coating type is titanium type, full-position welding, AC and DC dual-use, good welding process performance, and the weld metal has good atmospheric corrosion resistance.
- It is a special welding rod for weathering steel. It is used for the welding of railway weather-resistant vehicles. It can also be used for other low-alloy steels. Such as: 09MnCuPTi, Q355, etc.

Compliant with standards:

- GB/T 5117 E5003-G

Chemical Composition of Deposition Metal
(Mass Fraction) :%

	C	Mn	Si	P	S	Cu	W
Standard value	≤ 0.12	0.30-0.90	≤ 0.40	≤ 0.035	≤ 0.030	0.20-0.50	0.20-0.50
Example value	0.080	0.51	0.23	0.025	0.014	0.38	0.32

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 22	≥ 27
Example value	550	460	25	52

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC or AC）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	70-90	110-140	160-200	200-260

BC-J506(E7016)

产品说明：

- J506 是低氢钾型碱性焊条，适用于全位置焊接，交直流两用。交流电弧稳定性好，电弧柔和，飞溅小，成型美观，脱渣容易。焊缝金属有良好的塑性，低温韧性和抗裂性能。
- 用于碳钢或低合金钢如 16Mn、09Mn2Si 等的焊接和船舶用 A、B、D、E 级钢的焊接，以及相应强度等级的车辆、建筑、桥梁的重要结构件焊接。

符合标准：

- GB/T 5117 E5016·AWS A5.1 E7016·ISO 2560-B-E49 16 A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.6	≤ 0.75	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.08	1.1	0.5	0.02	0.01	0.03	0.005	0.015	0.013

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 27
例值	550	440	31	170

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	80-140	110-210	160-230

BC-J506(E7016)

Product Description:

- J506 is Low hydrogen potassium type alkaline welding rod, suitable for all-position welding, AC and DC dual-use. The AC arc has good stability, soft arc, small spatter, beautiful forming, and easy slag removal. Weld metal has excellent plasticity, low temperature toughness and crack resistance.
- It is used for the welding of carbon steel or low-alloy steel such as 16Mn, 09Mn2Si, etc., and the welding of A, B, D, E grade steel for ships, as well as the welding of important structural parts of vehicles, buildings and bridges with corresponding strength grades.

Compliant with standards:

- GB/T 5117 E5016·AWS A5.1 E7016·ISO 2560-B-E49 16 A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.6	≤ 0.75	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.08	1.1	0.5	0.02	0.01	0.03	0.005	0.015	0.013

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 27
Example value	550	440	31	170

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC⁺ or AC）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	80-140	110-210	160-230

BC-E7018(J506Fe)

产品说明:

- E7018 是低氢钾型铁粉型碱性焊条，交直流两用。由于药皮含有铁粉，可提高熔敷效率。电弧稳定，飞溅少，脱渣容易，工艺性能良好，熔敷金属力学性能良好，可进行全位置焊接。
- 用于碳钢或低合金钢结构的焊接，如 16Mn 等。

符合标准:

- GB/T 5117 E5018 · AWS A5.1 E7018 · ISO 2560-B-E49 18 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.3	≤ 0.2	≤ 0.3	≤ 0.08
例值	0.077	1.07	0.54	0.005	0.014	0.011	0.028	0.007	0.016

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 27
例值	550	455	32	156

熔敷金属 X 射线探伤要求: I 级

参考电流: (DC⁺ 或 AC)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	100-150	170-210	210-250

BC-E7018(J506Fe)

Product Description:

- E7018 is a Low hydrogen potassium type iron powder type alkaline welding rod, suitable for both AC and DC power sources. Due to the ferrous powder in the coating, the deposition efficiency can be improved. It features stable arc, minimal spatter, easy slag removal, good technological performance, excellent mechanical properties of the deposited metal, and can be used for all-position welding.
- Used for welding carbon steel or low-alloy steel structures, such as 16Mn, etc.

Compliant with standards:

- GB/T 5117 E5018 · AWS A5.1 E7018 · ISO 2560-B-E49 18 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard value	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.3	≤ 0.2	≤ 0.3	≤ 0.08
Example value	0.077	1.07	0.54	0.005	0.014	0.011	0.028	0.007	0.016

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 27
Example value	550	455	32	156

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺ or AC)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	100-150	170-210	210-250

BC-J506Fe16(E7028)

产品说明：

- J506Fe16 是低氢钾型铁粉型碱性焊条，交、直流两用，适用于平焊、平角焊。焊接工艺性能佳，熔敷效率可达 160% 左右。
- 用于 490MPa 级碳钢及低合金结构的平焊、平角焊，如 16Mn 等。

符合标准：

• GB/T 5117 E5028 · AWS A5.1 E7028 · ISO 2560-B-E4928 A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.07	1.1	0.3	0.021	0.012	0.035	0.005	0.004	0.03

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 27
例值	540	430	25	180

熔敷金属 X 射线探伤要求：II 级

参考电流：（DC⁺ 或 AC）

焊条直径 (mm)	4.0	5.0
焊条长度 (mm)	400	400
焊接电流 (A)	180-240	210-280

BC-J506Fe16(E7028)

Product Description:

- J506Fe16 is a low-hydrogen potassium iron powder alkaline electrode, AC and DC dual-purpose, suitable for flat welding and flat fillet welding. The welding process has good performance, and the deposition efficiency can reach about 160%.
- It is used for flat welding and flat fillet welding of 490MPa grade carbon steel and low-alloy structures, such as 16Mn, etc.

Compliant with standards:

• GB/T 5117 E5028 · AWS A5.1 E7028 · ISO 2560-B-E4928 A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.07	1.1	0.3	0.021	0.012	0.035	0.005	0.004	0.03

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 27
Example value	540	430	25	180

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC⁺ or AC）

Diameter (mm)	4.0	5.0
Length (mm)	400	400
Welding current (A)	180-240	210-280

BC-J507(E7015)

产品说明：

- J507 是低氢钠型碱性焊条，用于全位置焊接，直流反接，电弧挺度好，不易产生磁偏吹，焊缝成型细腻美观，飞溅小，脱渣容易，电弧稳定。焊缝金属具有优良的力学性能和抗裂性能，抗低温冲击韧性好。
- 用于焊接重要的中碳钢和低合金钢结构（受压、动载），如 16Mn、09Mn2Si、09Mn2V 和船舶用 A、B、D、E 级钢等，也用于厚板及可焊性较差的碳钢结构的焊接。

符合标准：

- GB/T 5117 E5015 · AWS A5.1 E7015 · ISO 2560-B-E49 15 A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.087	1.12	0.58	0.021	0.012	0.028	0.007	0.016	0.011

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 27
例值	550	440	32	140

熔敷金属 X 射线探伤要求： I 级

参考电流： (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	60-100	80-140	110-210	160-230

BC-J507(E7015)

Product Description:

- J507 is a low-hydrogen sodium-type basic electrode, suitable for all-position welding with DC reverse polarity. It features excellent arc stiffness, low susceptibility to magnetic blow, fine and attractive weld appearance, minimal spatter, easy slag detachment and stable arc. The weld metal exhibits outstanding mechanical properties and crack resistance, along with excellent low-temperature impact toughness.
- It is intended for welding important medium-carbon steel and low-alloy steel structures (subjected to pressure and dynamic loads), such as 16Mn, 09Mn2Si, 09Mn2V and marine grade A, B, D and E steels. It is also applicable for welding thick plates and carbon steel structures with poor weldability.

Compliant with standards:

- GB/T 5117 E5015 · AWS A5.1 E7015 · ISO 2560-B-E49 15 A

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.15	≤ 1.6	≤ 0.9	≤ 0.035	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.087	1.12	0.58	0.021	0.012	0.028	0.007	0.016	0.011

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 27
Example value	550	440	32	140

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	60-100	80-140	110-210	160-230

BC-J507RH

产品说明：

- 低氢钠型超低氢高韧性碱性焊条，采用直流反接，可进行全位置焊接。焊接工艺性能优良，焊缝金属具有良好的塑性、低温韧性和抗裂性能。
- 适用于船舶、桥梁、海上平台以及其他重要结构的焊接。

符合标准：

- GB/T 5117 E5015-G · AWS A5.5 E7015-G · ISO 2560-B-E4915-GPU

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	Ni	P	S
标准值	≤ 0.12	1-1.5	≤ 0.6	0.3-0.8	≤ 0.025	≤ 0.02
例值	0.06	1.3	0.35	0.65	0.015	0.01

熔敷金属力学性能：（焊态或 620±15°C *1h 热处理）

	抗拉强度 Rm(MPa)	屈服强度 ReL / Rp0.2(MPa)	伸长率 A(%)	-40°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 400	≥ 20	≥ 47
例值	570	460	30	160

熔敷金属扩散氢含量： ≤ 5.0mL/100g(水银法或热导法)

熔敷金属 X 射线探伤要求： I 级

参考电流：（DC⁺）

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	70-100	100-140	140-180	180-220

BC-J507RH

Product Description:

- Low-hydrogen sodium-type ultra-low hydrogen high-toughness basic electrode, for DC reverse polarity, suitable for all-position welding. It features excellent welding process performance, and the weld metal has good plasticity, low-temperature toughness and crack resistance.
- It is applicable for welding of ships, bridges, offshore platforms and other important structures.

Compliant with standards:

- GB/T 5117 E5015-G · AWS A5.5 E7015-G · ISO 2560-B-E4915-GPU

Chemical Composition of Deposition Metal (Mass Fraction) :%

	C	Mn	Si	Ni	P	S
Standard value	≤ 0.12	1-1.5	≤ 0.6	0.3-0.8	≤ 0.025	≤ 0.02
Example value	0.06	1.3	0.35	0.65	0.015	0.01

Mechanical properties of deposited metal: (as-welded or post-weld heat treatment at 620±15°C for 1h)

	Tensile strength Rm(MPa)	Yield strength ReL / Rp0.2(MPa)	Elongation A(%)	Impact energy at -40°C KV ₂ (J)
Standard value	≥ 490	≥ 400	≥ 20	≥ 47
Example value	570	460	30	160

Diffusible hydrogen content of deposited metal: ≤ 5.0 mL/100g (Mercury method or thermal conductivity method)

Requirements for X-ray flaw detection of deposited metals: Class I

Reference current：（DC⁺）

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	70-100	100-140	140-180	180-220

BC-E6010

产品说明:

- E6010 是高纤维素钠型药皮立向下焊条, 电弧吹力大, 单面焊双面成型, 熔渣少, 易清除, 焊缝成型美观, 焊接速度快, 熔敷金属有良好的力学性能, 并具有优良的抗气孔和抗裂性能, 是管线现场环缝全位置立向下焊接专用焊条, 采用直流反接。
- 管道焊接专用焊条, 用于各种碳钢钢管的环缝对接, 也适宜一般碳钢结构立向下焊接。

符合标准:

- GB/T 5117 E4310 · AWS A5.1 E6010 · ISO 2560-B-E 43 10 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.20	≤ 1.20	≤ 1.00	≤ 0.040	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.11	0.38	0.10	0.013	0.009	0.030	0.023	0.008	0.085

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 22	≥ 27
例值	510	400	27	80

熔敷金属 X 射线探伤要求: II 级

参考电流: (DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	50-80	60-100	100-140	160-240

BC-E6010

Product Description:

- E6010 is a high cellulose sodium-type coated electrode dedicated to vertical-down welding. It features strong arc blow, enables single-side welding with double-side forming, produces little and easily removable slag, delivers neat and attractive weld appearance and high welding speed. The deposited metal boasts excellent mechanical properties, along with outstanding porosity and crack resistance. It is a special electrode for all-position vertical-down welding of on-site pipeline girth welds, and shall be used with DC reverse polarity.
- As a dedicated electrode for pipeline welding, it is suitable for girth butt welding of various carbon steel pipes, and also applicable for vertical-down welding of general carbon steel structures.

Compliant with standards:

- GB/T 5117 E4310 · AWS A5.1 E6010 · ISO 2560-B-E 43 10 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.20	≤ 1.20	≤ 1.00	≤ 0.040	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.11	0.38	0.10	0.013	0.009	0.030	0.023	0.008	0.085

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 22	≥ 27
Example value	510	400	27	50

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	50-80	60-100	100-140	160-240

BC-E6011

产品说明:

- E6011 是高纤维素钾型药皮立向下焊条。交直流两用，电弧吹力大，可实现单面焊双面成型，熔化速度快，熔池清晰，脱渣容易，抗气孔性强，可进行全位置焊接。
- 管道焊接专用焊条，用于各种碳钢管的环缝对接，也适宜一般碳钢结构立向下焊接。

符合标准:

- GB/T 5117 E4311 · AWS A5.1 E6011

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.20	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
例值	0.12	0.39	0.17	0.020	0.014	0.036	0.005	0.007	0.085

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 430	≥ 330	≥ 22	≥ 27
例值	496	400	28.5	50

熔敷金属 X 射线探伤要求: II 级

参考电流: (AC 或 DC⁺)

焊条直径 (mm)	2.5	3.2	4.0	5.0
焊条长度 (mm)	350	350	400	400
焊接电流 (A)	40-60	80-100	100-140	160-220

BC-E6011

Product Description:

- E6011 is a high cellulose potassium type peel vertical downward electrode. AC and DC dual-purpose, large arc blowing force, can realize single-sided welding and double-sided forming, fast melting speed, clear molten pool, easy slag removal, strong porosity resistance, and can be welded in all positions.
- The special welding rod for pipeline welding is used for the annular seam butt of various carbon steel pipes, and is also suitable for vertical downward welding of general carbon steel structures.

Compliant with standards:

- GB/T 5117 E4311 · AWS A5.1 E6011

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.20	≤ 1.2	≤ 1.00	≤ 0.04	≤ 0.035	≤ 0.2	≤ 0.3	≤ 0.08	≤ 0.3
Example value	0.12	0.39	0.17	0.020	0.014	0.036	0.005	0.007	0.085

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2 (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 430	≥ 330	≥ 22	≥ 27
Example value	496	400	28.5	50

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (AC or DC⁺)

Diameter (mm)	2.5	3.2	4.0	5.0
Length (mm)	350	350	400	400
Welding current (A)	40-60	80-100	100-140	160-220

BC-E7010

产品说明：

- E7010 是高纤维素钠型药皮立向下焊条。电弧吹力大，单面焊双面成形，熔渣少，易清除，焊缝成形美观，焊接速度快，熔敷金属有良好的力学性能，并具有优良的抗气孔和抗裂性能，是管线现场环缝全位置立向下焊接专用焊条，采用直流正接。
- 管道焊接专用焊条，用于各种碳钢钢管的环缝对接，也适宜一般钢结构立向下焊接。

符合标准：

- GB/T5117 E5010-P1·AWS A5.5 E7010-P1·ISO 2560-B-E 49 10-P1A

熔敷金属化学成分（质量分数）： %

	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值	≤ 0.20	≤ 1.20	≤ 0.60	≤ 0.030	≤ 0.030	≤ 1.00	≤ 0.30	≤ 0.50	≤ 0.10
例值	0.11	0.43	0.10	0.008	0.014	0.35	0.032	0.30	0.009

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 490	≥ 420	≥ 20	≥ 27
例值	535	440	24	56

熔敷金属 X 射线探伤要求： II 级

参考电流：（DC）

焊条直径（mm）	3.2	4.0
焊条长度（mm）	350	400
焊接电流（A）	80-100	110-130

BC-E7010

Product Description:

- E7010 is a high cellulose sodium type peel vertical downward electrode. The arc blowing force is large, single-sided welding and double-sided forming, less slag, easy to remove, the weld is beautifully formed, the welding speed is fast, the deposited metal has good mechanical properties, and has excellent porosity resistance and crack resistance.
- The special welding rod for pipeline welding is used for the annular seam butting of various carbon steel pipes, and is also suitable for vertical downward welding of general steel structures.

Compliant with standards:

- GB/T5117 E5010-P1·AWS A5.5 E7010-P1·ISO 2560-B-E 49 10-P1A

Chemical Composition of Deposition Metal
(Mass Fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo	V
Standard value	≤ 0.20	≤ 1.20	≤ 0.60	≤ 0.030	≤ 0.030	≤ 1.00	≤ 0.30	≤ 0.50	≤ 0.10
Example value	0.11	0.43	0.10	0.008	0.014	0.35	0.032	0.30	0.009

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2 (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 490	≥ 420	≥ 20	≥ 27
Example value	535	440	24	56

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current：（DC）

Diameter（mm）	3.2	4.0
Length（mm）	350	400
Welding current（A）	80-100	110-130

BC-E8010

产品说明:

- E8010 是高纤维素钠型药皮立向下焊条。电弧吹力大，熔渣少，易清除，焊缝成形美观，焊接速度快，熔敷金属有良好的力学性能，并具有优良的抗气孔和抗裂性能，是管线现场环缝全位置立向下焊接专用焊条，采用直流正接。
- 管道焊接专用焊条，用于同强度等级的碳钢，低合金钢管道的填充，盖面焊，也适宜一般同强度结构的立向下焊接。

符合标准:

- GB/T 5117 E5510-P1·AWS A5.5 E8010-P1·ISO 2560-B-E 55 10-P1 A

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
标准值	≤ 0.20	≤ 1.2	≤ 0.60	≤ 0.03	≤ 0.03	≤ 0.3	≤ 0.5	≤ 0.10	≤ 1.00
例值	0.10	0.50	0.14	0.014	0.010	0.035	0.42	0.010	0.40

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	≥ 550	≥ 460	≥ 17	≥ 27
例值	590	500	24	55

熔敷金属 X 射线探伤要求: II 级

参考电流: (DC)

焊条直径 (mm)	3.2	4.0
焊条长度 (mm)	350	400
焊接电流 (A)	80-100	110-130

BC-E8010

Product Description:

- E8010 is a high cellulose sodium type peel vertical downward electrode. The arc blowing force is large, the slag is less, it is easy to remove, the weld is beautiful, the welding speed is fast, the deposited metal has good mechanical properties, and has excellent porosity resistance and crack resistance.
- The special welding rod for pipe welding is used for the filling and cover welding of carbon steel and low-alloy steel pipes of the same strength grade, and is also suitable for vertical and downward welding of general structures of the same strength.

Compliant with standards:

- GB/T 5117 E5510-P1·AWS A5.5 E8010-P1·ISO 2560-B-E 55 10-P1 A

Chemical Composition of Deposition Metal
(Mass Fraction) : %

	C	Mn	Si	P	S	Cr	Mo	V	Ni
Standard value	≤ 0.20	≤ 1.2	≤ 0.60	≤ 0.03	≤ 0.03	≤ 0.3	≤ 0.5	≤ 0.10	≤ 1.00
Example value	0.10	0.50	0.14	0.014	0.010	0.035	0.42	0.010	0.40

Mechanical properties of deposited metal:

	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2 (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	≥ 550	≥ 460	≥ 17	≥ 27
Example value	590	500	24	55

Requirements for X-ray flaw detection of deposited metals: Class II

Reference current: (DC)

Diameter (mm)	3.2	4.0
Length (mm)	350	400
Welding current (A)	80-100	110-130

碳钢药芯焊丝

BC-E70T-1C

产品说明:

- E70T-1C 属 490Mpa 级 / 铁粉型耐底漆高效率高强度钢用药芯焊丝, 电弧柔和稳定、飞溅少、成型美观、脱渣性好, 烟尘量少, 具有优良的焊接工艺性能。耐底漆抗气孔性优良, 抗裂性佳。
- 适用于船舶、桥梁、机械、车辆及钢结构等各种结构的平焊、平角焊; 可用做铸钢件或中厚板的打底焊接。

符合标准:

- GB/T10045 T49 2 T15-0 C1 A · AWS A5.20 E70T-1C
- ISO 17632-B: T49 2 T15-1C1A · JIS Z3313 T492T15-1CA-U

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
标准值	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
例值	0.05	1.45	0.4	0.02	0.02	0.01	0.012	0.007	0.01

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	490-670	≥ 390	≥ 18	≥ 27
例值	575	500	25	70

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.4	1.6
电压 (Volt)	23-34	24-42	25-46
电流 (Amp)	150-320	170-400	200-450
干伸长度 (mm)	15-20	15-20	18-25
气体流量 (l/min)	15-25	15-25	15-25

Carbon steel flux-cored wire

BC-E70T-1C

Product Description:

- E70T-1C is a 490MPa grade, iron powder type, primer-tolerant, high-efficiency flux-cored wire for high-strength steel. It features a soft and stable electric arc, low spatter, attractive weld appearance, good slag detachability, and low fume emission, exhibiting excellent welding process performance. Additionally, it has outstanding primer tolerance and resistance to porosity, as well as good crack resistance.
- It is suitable for flat welding and flat fillet welding of various structures such as ships, bridges, machinery, vehicles and steel structures; it can also be used for backing welding of cast steel parts or medium and thick plates.

Compliant with standards:

- GB/T10045 T49 2 T15-0 C1 A · AWS A5.20 E70T-1C
- ISO 17632-B: T49 2 T15-1C1A · JIS Z3313 T492T15-1CA-U

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
Standard value	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
Example value	0.05	1.45	0.4	0.02	0.02	0.01	0.012	0.007	0.01

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	490-670	≥ 390	≥ 18	≥ 27
Example value	575	500	25	70

Reference current: (DC⁺)

Diameter (mm)	1.2	1.4	1.6
Voltage (Volt)	23-34	24-42	25-46
Electric Current (Amp)	150-320	170-400	200-450
Dry Extension Length (mm)	15-20	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25	15-25

BC-E70T-5C

产品说明:

- E70T-5C 属氧化钙 - 氟化物型渣系的 CO₂ 气保护药芯焊丝。焊接工艺性能良好, 电弧较稳定, 脱渣容易, 焊缝成型较好, 适用于平焊和平角焊以及不大于 45° 的爬坡焊, 焊缝金属的塑韧性和抗裂性能优良, 焊缝扩散氢含量低。
- 适用于塑韧性、抗裂性要求较高的低碳钢和 490MPa 级高强钢结构的焊接, 多用于船舶、机械制造、容器、石油化工、桥梁等重要钢结构的焊接。

符合标准:

- GB/T10045 T49 3 T5-0 C1 A · AWS A5.20 E70T-5C
- ISO 17632-B-T49 3 T5-0 C1 A

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S
标准值	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.030	≤ 0.030
例值	0.07	1.50	0.50	0.018	0.013

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-30°C冲击功 KV ₂ (J)
标准值	490-670	≥ 390	≥ 18	≥ 27
例值	545	435	28	150

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	
焊接电流 (A)	平焊	120-320
	平角焊	120-320

BC-E70T-5C

Product Description:

- E70T-5C is a CO₂ gas-shielded flux-cored wire with calcium oxide-fluoride type slag system. It features excellent welding process performance, relatively stable arc and easy slag removal, yielding good weld formation. It is suitable for flat welding, flat fillet welding and vertical-up welding with an angle not exceeding 45°. The weld metal has superior plasticity, toughness and crack resistance, with low diffusible hydrogen content.
- It is applicable for welding low-carbon steel and 490MPa grade high-strength steel structures requiring high plasticity, toughness and crack resistance, and is widely used in welding critical steel structures such as ships, machinery manufacturing, vessels, petrochemical industry and bridges.

Compliant with standards:

- GB/T10045 T49 3 T5-0 C1 A · AWS A5.20 E70T-5C
- ISO 17632-B-T49 3 T5-0 C1 A

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S
Standard value	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.030	≤ 0.030
Example value	0.07	1.50	0.50	0.018	0.013

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -30°C KV ₂ (J)
Standard value	490-670	≥ 390	≥ 18	≥ 27
Example value	545	435	28	150

Reference current: (DC⁺)

Diameter (mm)	1.2	
Welding current (A)	Flat welding	120-320
	Flat fillet welding	120-320

BC-E71T-1C

产品说明：

- E71T-1C 属 490Mpa 级高强度钢用药芯焊丝，电弧柔和稳定、飞溅少、成型美观、脱渣性好，烟尘量少，具有优良的焊接工艺性能。低温冲击性能良好。全位置焊接。
- 适用于船舶、桥梁、建筑、航洋平台、管道、钢结构等焊接。

符合标准：

- GB/T10045 T49 2 T1-1 C1 A·AWS A5.20 E71T-1C
- ISO 17632-A-T42 2 P C1 1 · JIS Z3313 T492T1-1CA-U

保护气体：

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo	P	S	V
标准值	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
例值	0.05	1.35	0.40	0.02	0.02	0.01	0.015	0.009	0.01

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	490-670	≥ 390	≥ 18	≥ 27
例值	570	500	26	80

参考电流：(DC⁺)

焊丝直径 (mm)	1.2	1.4	1.6
电压 (Volt)	23-32	24-36	25-40
电流 (Amp)	150-300	170-360	200-400
干伸长度 (mm)	15-20	15-20	18-25
气体流量 (l/min)	15-25	15-25	15-25

BC-E71T-1C

Product Description:

- E71T-1C is a flux-cored wire for 490MPa grade high-strength steel. It features a soft and stable arc, low spatter, attractive weld appearance, good slag detachability, and low fume emission, boasting excellent welding process performance. It also has good low-temperature impact toughness and is suitable for all-position welding.
- It is applicable to the welding of ships, bridges, buildings, offshore platforms, pipelines, steel structures and other components.

Compliant with standards:

- GB/T10045 T49 2 T1-1 C1 A·AWS A5.20 E71T-1C
- ISO 17632-A-T42 2 P C1 1 · JIS Z3313 T492T1-1CA-U

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction)：%

	C	Mn	Si	Cr	Ni	Mo	P	S	V
Standard value	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
Example value	0.05	1.35	0.40	0.02	0.02	0.01	0.015	0.009	0.01

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	490-670	≥ 390	≥ 18	≥ 27
Example value	570	500	26	80

Reference current：(DC⁺)

Diameter (mm)	1.2	1.4	1.6
Voltage (Volt)	23-32	24-36	25-40
Electric Current (Amp)	150-300	170-360	200-400
Dry Extension Length (mm)	15-20	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25	15-25

BC-E71NiT-1C

产品说明:

- E71NiT-1C 属 490MPa 级高强度钢用药芯焊丝。电弧柔和稳定、飞溅少、成型美观、脱渣性好，烟尘量少，具有优良的焊接工艺性能。-40°C 冲击性能优良，CTOD 性能稳定。
- 适用于海洋平台、港口机械、船舶、桥梁、低温容器等焊接。

符合标准:

- GB/T10045 T49 4 T1-1 C1 A·AWS A5.20 E71T-1C-J
- ISO 17632-A:T42 4 P C1 1

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
标准值	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
例值	0.034	1.24	0.37	0.03	0.45	0.01	0.011	0.005	0.01

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-40°C冲击功 KV ₂ (J)
标准值	490-670	≥ 390	≥ 18	≥ 27
例值	560	505	28	118

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.4	1.6
电压 (Volt)	25-32	24-36	25-40
电流 (Amp)	150-300	170-360	200-400
干伸长度 (mm)	15-20	15-20	18-25
气体流量 (l/min)	15-25	15-25	15-25

BC-E71NiT-1C

Product Description:

- E71NiT-1C is a flux-cored welding wire designed for 490MPa grade high-strength steel. It features soft and stable arc, low spatter, smooth weld appearance, easy slag removal and low fume emission, boasting excellent welding process performance. It also delivers outstanding impact toughness at -40°C and stable CTOD properties.
- It is suitable for welding of offshore platforms, port machinery, ships, bridges, low-temperature vessels and other structures.

Compliant with standards:

- GB/T10045 T49 4 T1-1 C1 A·AWS A5.20 E71T-1C-J
- ISO 17632-A:T42 4 P C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
Standard value	≤ 0.18	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 0.08
Example value	0.034	1.24	0.37	0.03	0.45	0.01	0.011	0.005	0.01

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -40°C KV ₂ (J)
Standard value	490-670	≥ 390	≥ 18	≥ 27
Example value	560	505	28	118

Reference current: (DC⁺)

Diameter (mm)	1.2	1.4	1.6
Voltage (Volt)	25-32	24-36	25-40
Electric Current (Amp)	150-300	170-360	200-400
Dry Extension Length (mm)	15-20	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25	15-25

BC-E71T-GS

产品说明:

- E71T-GS 属 490Mpa 级高强度钢用自保护药芯焊丝; 方便携带, 用于单道焊接; 电弧柔和稳定, 飞溅小; 全位置焊接。
- 适用于薄的碳钢及镀锌钢板等轻型结构的焊接, 单道焊接用。

符合标准:

- GB/T10045 T49TG-1 N S·AWS A5.20 E71T-GS
- ISO 17632-A:T3T ZV NO·ISO 17632-B:T49TG-1NO S

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
例值	0.095	0.95	0.02	0.02	0.02	0.01	0.010	0.002	2.50

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 490	-	-
例值	510	-	-

参考电流: (DC)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
电压 (Volt)	14-19	16-20	18-25	18-25	20-26
电流 (Amp)	40-140	60-160	80-200	140-260	180-300
干伸长度 (mm)	10-15	10-15	10-15	10-15	10-15

BC-E71T-GS

Product Description:

- E71T-GS is a self-shielded flux-cored wire for 490MPa grade high-strength steel; it is easy to carry and suitable for single-pass welding; it features a soft and stable arc with low spatter; and it is applicable for all-position welding.
- Suitable for welding thin carbon steel, galvanized steel sheets and other light structures, and for single-pass welding.

Compliant with standards:

- GB/T10045 T49TG-1 N S·AWS A5.20 E71T-GS
- ISO 17632-A:T3T ZV NO·ISO 17632-B:T49TG-1NO S

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
Example value	0.095	0.95	0.02	0.02	0.02	0.01	0.010	0.002	2.50

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	≥ 490	-	-
Example value	510	-	-

Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Voltage (Volt)	14-19	16-20	18-25	18-25	20-26
Electric Current (Amp)	40-140	60-160	80-200	140-260	180-300
Dry Extension Length (mm)	10-15	10-15	10-15	10-15	10-15

BC-E70T-4

产品说明：

- E70T-4 属 490MPa 级高强度钢用自保护药芯焊丝。在母材生锈、氧化及含硫量高的条件下，使用具有良好的耐气孔性；焊道成型美观，脱渣性好。
- 适用于建筑结构、钢架等各种钢结构的对接焊及角焊。

符合标准：

- GB/T10045 T49 Z T4-0 N A · AWS A5.20 E70T-4 · AWS A5.20M E490T-4
- ISO 17632-A:T42 Z Y NO3 · ISO 17632-B:T49 Z T4-0 NOA

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
标准值	≤ 0.30	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 2.00
例值	0.25	0.55	0.30	0.03	0.05	0.01	0.015	0.002	1.50

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	490-670	≥ 390	≥ 18
例值	580	430	25

参考电流：（DC⁺）

焊丝直径 (mm)	2.4	2.8	3.0
电压 (Volt)	24-32	24-35	24-35
电流 (Amp)	260-400	280-450	280-450
干伸长度 (mm)	65-70	65-70	90-95

BC-E70T-4

Product Description:

- E70T-4 is a self-shielded flux-cored wire for 490MPa grade high-strength steel. It has good porosity resistance when used under conditions where the base metal is rusted, oxidized, or has a high sulfur content; the weld bead has an attractive appearance and good slag detachability.
- Suitable for butt welding and fillet welding of various steel structures such as building structures and steel frames.

Compliant with standards:

- GB/T10045 T49 Z T4-0 N A · AWS A5.20 E70T-4 · AWS A5.20M E490T-4
- ISO 17632-A:T42 Z Y NO3 · ISO 17632-B:T49 Z T4-0 NOA

Chemical Composition of Deposition Metal
(Mass Fraction)：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
Standard value	≤ 0.30	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 2.00
Example value	0.25	0.55	0.30	0.03	0.05	0.01	0.015	0.002	1.50

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	490-670	≥ 390	≥ 18
Example value	580	430	25

Reference current：（DC⁺）

Diameter (mm)	2.4	2.8	3.0
Voltage (Volt)	24-32	24-35	24-35
Electric Current (Amp)	260-400	280-450	280-450
Dry Extension Length (mm)	65-70	65-70	90-95

BC-E70T-7

产品说明：

- E70T-7 属 490MPa 级高强度钢用自保护药芯焊丝。熔滴为细熔滴过渡或喷射过渡，穿透深度佳，湿润度好，熔填速度快。焊缝金属硫含量低，抗裂性好；平焊、对角焊、小直径焊丝可用于全位置焊接。
- 适用于土木建筑、钢架、钢管型钩、烟囱、管道等各种结构件的室外焊接。

符合标准：

- GB/T10045 T49 Z T7-0 N A · AWS A5.20 E70T-7 · AWS A5.20M E490T-7
- ISO 17632-A:T42 ZY NO 3 · ISO 17632-B:T49 Z T7-0 NO A

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
标准值	≤ 0.30	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 2.00
例值	0.25	0.50	0.10	0.05	0.02	0.01	0.010	0.005	1.50

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	490-670	≥ 390	≥ 18
例值	600	430	27

参考电流：(DC)

焊丝直径 (mm)	1.6	2.0	2.4
电压 (A)	22-30	24-32	26-34
电流 (A)	160-300	200-350	250-400
干伸长度 (mm)	20-30	25-35	30-40

BC-E70T-7

Product Description:

- E70T-7 is a self-shielded flux-cored wire for 490MPa grade high-strength steel. It features fine droplet transfer or spray transfer, with excellent penetration depth, good wettability, and high deposition rate. The weld metal has low sulfur content and good crack resistance. It is suitable for flat welding, fillet welding, and the small-diameter wire variant can be used for all-position welding.
- Suitable for outdoor welding of various structural components such as civil construction, steel frames, steel pipe hooks, chimneys, and pipelines.

Compliant with standards:

- GB/T10045 T49 Z T7-0 N A · AWS A5.20 E70T-7 · AWS A5.20M E490T-7
- ISO 17632-A:T42 ZY NO 3 · ISO 17632-B:T49 Z T7-0 NO A

Chemical Composition of Deposition Metal
(Mass Fraction)：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Al
Standard value	≤ 0.30	≤ 2.00	≤ 0.90	≤ 0.20	≤ 0.50	≤ 0.30	≤ 0.03	≤ 0.03	≤ 2.00
Example value	0.25	0.50	0.10	0.05	0.02	0.01	0.010	0.005	1.50

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)
Standard value	490-670	≥ 390	≥ 18
Example value	600	430	27

Reference current：(DC)

Diameter (mm)	1.6	2.0	2.4
Voltage (A)	22-30	24-32	26-34
Electric Current (A)	160-300	200-350	250-400
Dry Extension Length (mm)	20-30	25-35	30-40

BC-E81T1-K2C

产品说明：

- E81T1-K2C 属低温钢用药芯焊丝，主要成分是 1.5%Ni；电弧柔和稳定、飞溅小、成型美观、脱渣性好、烟尘量少，具有优良的焊接工艺性能；低温冲击和 CTOD 性能优异；全位置焊接。
- 适用于 550MPa 级 /1.5Ni 钢用、桥梁、港口机械、造船、海洋平台等焊接。

符合标准：

- GB/T10045 T55 6 T1-1 C1 A-N3 ·AWS A5.29 E81T1-K2C
- AWS A5.29ME551T1-K2C·ISO 17632-A:T46 6 1.5Ni P C1 1
- ISO 17632-B:T55 6 T1-1 C1 A-N3·JIS Z3313 T556T1-1CA-N3-U

保护气体：

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	P	S	Ni	Mo
标准值	≤ 0.12	≤ 1.75	≤ 0.80	-	≤ 0.03	≤ 0.03	1.00-2.00	≤ 0.35
例值	0.05	1.22	0.30	0.02	0.010	0.005	1.58	0.01

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-60°C冲击功 KV ₂ (J)
标准值	550-740	≥ 460	≥ 17	≥ 27
例值	625	550	25	100

参考电流：(DC⁺)

焊丝直径 (mm)	1.2	1.4	1.6
电压 (Volt)	25-32	24-36	25-40
电流 (Amp)	150-300	170-360	200-400
干伸长度 (mm)	15-20	15-20	18-25
气体流量 (l/min)	15-25	15-25	15-25

BC-E81T1-K2C

Product Description:

- E81T1-K2C is a flux-cored wire for low-temperature steel, with 1.5% nickel as its main component. It features a soft and stable arc, low spatter, attractive weld appearance, good slag detachability, and low fume emission, boasting excellent welding process performance. It also exhibits outstanding low-temperature impact toughness and CTOD properties, and is suitable for all-position welding.
- Suitable for welding 550MPa grade / 1.5Ni steel, as well as bridges, port machinery, shipbuilding, offshore platforms, etc.

Compliant with standards:

- GB/T10045 T55 6 T1-1 C1 A-N3 ·AWS A5.29 E81T1-K2C
- AWS A5.29ME551T1-K2C·ISO 17632-A:T46 6 1.5Ni P C1 1
- ISO 17632-B:T55 6 T1-1 C1 A-N3·JIS Z3313 T556T1-1CA-N3-U

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal

(Mass Fraction)：%

	C	Mn	Si	Cr	P	S	Ni	Mo
Standard value	≤ 0.12	≤ 1.75	≤ 0.80	-	≤ 0.03	≤ 0.03	1.00-2.00	≤ 0.35
Example value	0.05	1.22	0.30	0.02	0.010	0.005	1.58	0.01

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -60°C KV ₂ (J)
Standard value	550-740	≥ 460	≥ 17	≥ 27
Example value	625	550	25	100

Reference current：(DC⁺)

Diameter (mm)	1.2	1.4	1.6
Voltage (Volt)	25-32	24-36	25-40
Electric Current (Amp)	150-300	170-360	200-400
Dry Extension Length (mm)	15-20	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25	15-25

BC-E81T1-Ni1C

产品说明：

- E81T1-Ni1C 属低温钢用药芯焊丝，主要成分是 1%Ni；电弧柔和稳定、飞溅小、成型美观、脱渣性好、烟尘量少，具有优良的焊接工艺性能；低温冲击性能优异；全位置焊接。
- 适用于 550MPa 级 /1Ni 钢用、及相同强度等级桥梁、港口机械、造船、海洋平台、LPG 贮槽低温设备等焊接。

符合标准：

- GB/T10045 T55 4 T1-1 C1 A-N2 ·AWS A5.29 E81T1-Ni1C
- ISO 17632-A:T46 4 1Ni P C1 1

保护气体：

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	P	S	Ni	Mo
标准值	≤ 0.12	≤ 1.75	≤ 0.80	-	≤ 0.03	≤ 0.03	0.8-1.2	≤ 0.35
例值	0.04	1.34	0.30	0.02	0.010	0.005	0.93	0.02

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	-40°C冲击功 KV ₂ (J)
标准值	550-740	≥ 460	≥ 17	≥ 27
例值	590	530	27	110

参考电流：(DC⁺)

焊丝直径 (mm)	1.2	1.4	1.6
电压 (Volt)	25-32	24-36	25-40
电流 (Amp)	150-300	170-360	200-400
干伸长度 (mm)	15-20	15-20	18-25
气体流量 (l/min)	15-25	15-25	15-25

BC-E81T1-Ni1C

Product Description:

- E81T1-Ni1C is a flux-cored welding wire for low-temperature steel, with a main composition of 1% nickel. It features a soft and stable arc, minimal spatter, smooth weld appearance, easy slag removal and low fume emission, offering excellent welding process performance. It also has outstanding low-temperature impact toughness and supports all-position welding.
- It is suitable for welding 550MPa grade steel, 1Ni steel, as well as structures of the same strength grade such as bridges, port machinery, shipbuilding, offshore platforms, LPG storage tanks and other low-temperature equipment.

Compliant with standards:

- GB/T10045 T55 4 T1-1 C1 A-N2 ·AWS A5.29 E81T1-Ni1C
- ISO 17632-A:T46 4 1Ni P C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction)：%

	C	Mn	Si	Cr	P	S	Ni	Mo
Standard value	≤ 0.12	≤ 1.75	≤ 0.80	-	≤ 0.03	≤ 0.03	0.8-1.2	≤ 0.35
Example value	0.04	1.34	0.30	0.02	0.010	0.005	0.93	0.02

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Yield strength ReL (MPa)	Elongation A(%)	Impact energy at -40°C KV ₂ (J)
Standard value	550-740	≥ 460	≥ 17	≥ 27
Example value	590	530	27	110

Reference current：(DC⁺)

Diameter (mm)	1.2	1.4	1.6
Voltage (Volt)	25-32	24-36	25-40
Electric Current (Amp)	150-300	170-360	200-400
Dry Extension Length (mm)	15-20	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25	15-25

不锈钢药芯焊丝

BC-E308T1-1

产品说明:

- E308T1-1 属奥氏体型不锈钢药芯焊丝，可全位置焊接。焊缝金属含有适量的铁素体，裂纹敏感性低；电弧柔和稳定、飞溅少、成型美观、脱渣性好，送丝稳定，具有优良的焊接工艺性能。
- 适用于焊接 18%Cr-8%Ni 不锈钢 (SUS304 钢)，多用于石油化工、压力容器、医疗器械、食品机械、化肥等领域。

符合标准:

- GB/T 17853 TS308-FC1 1·AWS A5.22 E308T1-1

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75
例值	0.03	1.4	0.60	0.017	0.003	9.35	19.3	0.03	0.04

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 550	≥ 25
例值	580	38

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E308T1-1

Product Description:

- E308T1-1 is an austenitic stainless steel flux-cored wire, suitable for all-position welding. The weld metal contains an appropriate amount of ferrite, resulting in low crack sensitivity. It features a soft and stable electric arc, low spatter, attractive weld appearance, good slag detachability, and stable wire feeding, exhibiting excellent welding process performance.
- It is suitable for welding 18%Cr-8%Ni stainless steel (SUS304 steel), and is mostly used in fields such as petrochemical industry, pressure vessels, medical devices, food machinery, and chemical fertilizer.

Compliant with standards:

- GB/T 17853 TS308-FC1 1·AWS A5.22 E308T1-1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75
Example value	0.03	1.4	0.60	0.017	0.003	9.35	19.3	0.03	0.04

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 550	≥ 25
Example value	580	38

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E308LT1-1

产品说明:

- E308LT1-1 属奥氏体型不锈钢用药芯焊丝，焊缝金属含有适量的铁素体，裂纹敏感性低；电弧柔和稳定、飞溅少、成型美观，脱渣性好，送丝稳定，具有优良的焊接工艺性能，全位置焊接。
- 适用于焊接 18%Cr-8%Ni 不锈钢（SUS304、304L），多用于石油化工、压力容器、医疗器械、食品机械、化肥等领域。

符合标准:

- GB/T17853 TS308L-FC1 1·AWS A5.22 E308LT1-1
- ISO 17633-A-T 19 9 L P C1 1

保护气体:

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75
例值	0.025	1.05	0.5	0.016	0.002	9.34	19.29	0.02	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	560	40

参考电流：（DC⁺）

焊丝直径（mm）	1.2	1.6
电压（Volt）	22-36	26-38
电流（Amp）	120-260	200-300
干伸长度（mm）	15-20	18-25
气体流量（l/min）	15-25	15-25

Stainless steel flux-cored wire

BC-E308LT1-1

Product Description:

- E308LT1-1 is a flux-cored wire for austenitic stainless steel. The weld metal contains an appropriate amount of ferrite, resulting in low crack sensitivity. It features a soft and stable arc, minimal spatter, an attractive weld bead appearance, good slag detachability, and stable wire feeding, thus boasting excellent welding process performance and suitability for all-position welding.
- It is suitable for welding 18%Cr-8%Ni stainless steel (SUS304, 304L) and is widely used in fields such as petrochemical industry, pressure vessels, medical equipment, food machinery, and chemical fertilizer.

Compliant with standards:

- GB/T17853 TS308L-FC1 1·AWS A5.22 E308LT1-1
- ISO 17633-A-T 19 9 L P C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction)：%

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	9.0-11.0	18.0-21.0	≤ 0.75	≤ 0.75
Example value	0.025	1.05	0.5	0.016	0.002	9.34	19.29	0.02	0.03

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	560	40

Reference current：（DC⁺）

Diameter（mm）	1.2	1.6
Voltage（Volt）	22-36	26-38
Electric Current（Amp）	120-260	200-300
Dry Extension Length（mm）	15-20	18-25
Gas Flow Rate（l/min）	15-25	15-25

BC-E309LT1-1

产品说明:

- E309LT1-1 属奥氏体型 / 异种钢不锈钢用药芯焊丝, 焊缝金属含有较多的铁素体, 裂纹敏感性低; 电弧柔和稳定、飞溅少、成型美观, 脱渣性好, 送丝稳定, 具有优良的焊接工艺性能, 全位置焊接。
- 适用于不锈钢和碳钢或低合金钢的异种钢焊接, 不锈钢复合板覆层的打底焊接, 在碳钢或低合金钢上堆焊 308 系不锈钢时的打底焊接。

符合标准:

- GB/T17853 TS309L-FC1 1·AWS A5.22 E309LT1-1
- ISO 17633-A-T 23 12 L P C1 1

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
例值	0.02	1.66	0.58	0.018	0.005	12.4	23.85	0.08	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	550	40

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

BC-E309LT1-1

Product Description:

- E309LT1-1 is an austenitic/dissimilar steel stainless steel flux-cored wire. The weld metal contains a relatively large amount of ferrite, leading to low crack sensitivity. It has a soft and stable arc, minimal spatter, an attractive weld bead appearance, good slag detachability, and stable wire feeding, thus possessing excellent welding process performance and being suitable for all-position welding.
- It is suitable for the welding of dissimilar steels between stainless steel and carbon steel or low-alloy steel, the backing welding of the cladding layer of stainless steel clad plates, and the backing welding when surfacing 308 series stainless steel on carbon steel or low-alloy steel.

Compliant with standards:

- GB/T17853 TS309L-FC1 1·AWS A5.22 E309LT1-1
- ISO 17633-A-T 23 12 L P C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-14.0	22.0-25.0	≤ 0.75	≤ 0.75
Example value	0.02	1.66	0.58	0.018	0.005	12.4	23.85	0.08	0.03

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	550	40

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E309LMoT1-1

产品说明:

- E309LMoT1-1 属奥氏体型 / 异种钢用不锈钢药芯焊丝, 焊缝金属含有较多的铁素体, 裂纹敏感性低; 电弧柔和稳定、飞溅少、成型美观, 脱渣性好, 送丝稳定, 具有优良的焊接工艺性能, 全位置焊接。
- 适用于不锈钢和碳钢或低合金钢的异种钢焊接, 不锈钢复合板覆层的打底焊接, 在碳钢或低合金钢上堆焊 316 系不锈钢时的打底焊接。

符合标准:

- GB/T17853 TS309LMo-FC11·AWS A5.22 E309LMoT1-1
- ISO 7633-A:T 23 12 2LP C11

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-16.0	21.0-25.0	2.0-3.0	≤ 0.75
例值	0.025	1.4	0.58	0.016	0.003	13.4	23.50	2.56	0.02

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 15
例值	600	30

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E309LMoT1-1

Product Description:

- E309LMoT1-1 is an austenitic stainless steel flux-cored wire for dissimilar steel welding. The weld metal contains a relatively high amount of ferrite, resulting in low crack sensitivity. It features a soft and stable arc, minimal spatter, an attractive weld bead appearance, good slag detachability, and stable wire feeding, boasting excellent welding process performance and suitability for all-position welding.
- It is suitable for the welding of dissimilar steels between stainless steel and carbon steel or low-alloy steel, the backing welding of the cladding layer of stainless steel clad plates, and the backing welding when surfacing 316 series stainless steel on carbon steel or low-alloy steel.

Compliant with standards:

- GB/T17853 TS309LMo-FC11·AWS A5.22 E309LMoT1-1
- ISO 7633-A:T 23 12 2LP C11

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	NI	Cr	Mo	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	12.0-16.0	21.0-25.0	2.0-3.0	≤ 0.75
Example value	0.025	1.4	0.58	0.016	0.003	13.4	23.50	2.56	0.02

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 15
Example value	600	30

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E347T1-1

产品说明：

- E347T1-1 属非金属粉型不锈钢药芯焊丝，焊接工艺性能优良，机械性能优良，其抗裂性能极佳。因在 SUS304 基础上添加了 Ti 或 Nb，能有效改善耐腐蚀性，尤其提高抗晶间腐蚀性能。
- 多用于石油化工、压力容器、医疗器械、食品机械等领域。如 0Cr18Ni9Ti、0Cr19Ni11Nb 等。

符合标准：

- GB/T17853 TS347-FC1 1·AWS A5.22 E347T1-1

保护气体：

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	Nb+Ta
标准值	≤0.08	0.5-2.5	≤1.0	≤0.04	≤0.03	9.0-11.0	18.0-21.0	≤0.75	≤0.75	8xC-1.0
例值	0.03	1.68	0.56	0.018	0.003	9.88	19.17	0.05	0.08	0.56

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	550	40

参考电流：（DC⁺）

焊丝直径 (mm)		1.2	1.6
焊接电流 (A)	平焊、平角焊	160-240	180-270
	立向上焊、仰焊	160-210	170-220
	横焊	160-240	180-270
	立向下焊	160-220	180-250

Stainless steel flux-cored wire

BC-E347T1-1

Product Description:

- E347T1-1 is a non-metallic powder type stainless steel flux-cored wire, featuring excellent welding process performance, superior mechanical properties and outstanding crack resistance. Based on SUS304 with added Ti or Nb, it effectively enhances corrosion resistance, especially intergranular corrosion resistance.
- Widely used in petrochemical, pressure vessel, medical device and food machinery fields, e.g. 0Cr18Ni9Ti, 0Cr19Ni11Nb.

Compliant with standards:

- GB/T17853 TS347-FC1 1·AWS A5.22 E347T1-1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Standard value	≤0.08	0.5-2.5	≤1.0	≤0.04	≤0.03	9.0-11.0	18.0-21.0	≤0.75	≤0.75	8xC-1.0
Example value	0.03	1.68	0.56	0.018	0.003	9.88	19.17	0.05	0.08	0.56

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	550	40

Reference current: (DC⁺)

Wire Diameter (mm)		1.2	1.6
Welding Current (A)	Flat Welding、Flat Fillet Welding	160-240	180-270
	Vertical Up Welding、Overhead Welding	160-210	170-220
	Horizontal Welding	160-240	180-270
	Vertical Down Welding	160-220	180-250

不锈钢药芯焊丝

BC-E347LT1-1

产品说明：

- E347LT1-1 属奥氏体型 / 耐晶间腐蚀用不锈钢药芯焊丝，因添加 Nb，耐晶间腐蚀性能优异；电弧柔和稳定、飞溅少、成型美观，脱渣性好，送丝稳定，具有优良的焊接工艺性能。全位置焊接。
- 多用于石油化工、压力容器、医疗器械、食品机械等领域。焊接 18%Cr-8%Ni-Nb 不锈钢 (SUS347) 和 18%Cr-8%Ni-Ti 不锈钢 (SUS321) 等。

符合标准：

- GB/T17853 TS347L-FC1 1·AWS A5.22 E347T1-1
- ISO 17633-A:T19 9 Nb P C1 1

保护气体：

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	P	S	Mo	Cu	Nb
标准值	≤ 0.08	0.5-2.5	≤ 1.0	18.0-21.0	9.0-11.0	≤ 0.04	≤ 0.03	≤ 0.5	≤ 0.75	8xC-1.0
例值	0.03	1.35	0.5	19.17	9.88	0.022	0.003	0.02	0.02	0.25

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	580	40

参考电流：(DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E347LT1-1

Product Description:

- E347LT1-1 is an austenitic stainless steel flux-cored welding wire. Due to the addition of Nb (niobium), it exhibits excellent intergranular corrosion resistance. It also features gentle and stable arc, low spatter, attractive weld appearance, good slag detachability, and stable wire feeding, thus possessing superior welding process performance.
- It is mostly used in fields such as petrochemical industry, pressure vessels, medical devices, and food machinery. It is suitable for welding 18%Cr-8%Ni-Nb stainless steel (SUS347), 18%Cr-8%Ni-Ti stainless steel (SUS321), etc.

Compliant with standards:

- GB/T17853 TS347L-FC1 1·AWS A5.22 E347T1-1
- ISO 17633-A:T19 9 Nb P C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	P	S	Mo	Cu	Nb
Standard value	≤ 0.08	0.5-2.5	≤ 1.0	18.0-21.0	9.0-11.0	≤ 0.04	≤ 0.03	≤ 0.5	≤ 0.75	8xC-1.0
Example value	0.03	1.35	0.5	19.17	9.88	0.022	0.003	0.02	0.02	0.25

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 520	≥ 25
Example value	580	40

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E316T1-1

产品说明:

- E316T1-1 属非金属粉型不锈钢药芯焊丝，焊接工艺性能优良，熔敷金属的机械性能稳定，耐热耐蚀性能优异。
- 适用于 SUS 316 钢，多用于焊接尿素、化肥、合成纤维、石油化工生产或储存设备的重要结构等。

符合标准:

- GB/T17853 TS316-FC1 1·AWS A5.22 E316T1-1

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
标准值	≤ 0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
例值	0.054	1.75	0.57	0.018	0.004	11.65	18.52	2.45	0.08

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 520	≥ 25
例值	545	40

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6	
焊接电流 (A)	平焊、平角焊	160-240	180-270
	立向上焊、仰焊	160-210	170-220
	横焊	160-240	180-270
	立向下焊	160-220	180-250

Stainless steel flux-cored wire

BC-E316T1-1

Product Description:

- E316T1-1 is a non-metallic powder type stainless steel flux-cored welding wire. It features excellent welding process performance, the deposited metal has stable mechanical properties, and its heat resistance and corrosion resistance are excellent.
- It is applicable to SUS 316 steel and widely used in welding critical structures of production or storage equipment in urea, chemical fertilizer, synthetic fiber and petrochemical industries.

Compliant with standards:

- GB/T17853 TS316-FC1 1·AWS A5.22 E316T1-1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu
Standard value	≤ 0.08	0.5-2.5	≤ 1.0	≤ 0.04	≤ 0.03	11.0-14.0	17.0-20.0	2.0-3.0	≤ 0.75
Example value	0.054	1.75	0.57	0.018	0.004	11.65	18.52	2.45	0.08

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 485	≥ 25
Example value	540	40

Reference current: (DC⁺)

Wire Diameter (mm)	1.2	1.6	
Welding Current (A)	Flat Welding、Flat Fillet Welding	160-240	180-270
	Vertical Up Welding、Overhead Welding	160-210	170-220
	Horizontal Welding	160-240	180-270
	Vertical Down Welding	160-220	180-250

不锈钢药芯焊丝

BC-E316LT1-1

产品说明:

- E316LT1-1 属奥氏体型不锈钢药芯焊丝，焊缝金属含有适量的铁素体，裂纹敏感性低；因 Mo 含量较高，耐腐蚀性优良；电弧柔和稳定、飞溅少、成型美观，脱渣性好，送丝稳定，具有优良的焊接工艺性能。全位置焊接。
- 适用于石油化工、压力容器、食品机械、医疗机械、化肥等行业，焊接 18%Cr-12%Ni-2%Mo 不锈钢（SUS316、SUS316L 等）。

符合标准:

- GB/T17853 TS316L-FC1 1·AWS A5.22 E316LT1-1
- ISO 17633-A: T 19 12 3 L R C1 1

保护气体:

- 100%CO₂

熔敷金属化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
标准值	≤ 0.04	0.5-2.5	≤ 1.0	17.0-20.0	11.0-14.0	2.0-3.0	≤ 0.04	≤ 0.03	≤ 0.75
例值	0.019	1.50	0.57	18.55	11.98	2.35	0.018	0.005	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 485	≥ 25
例值	550	35

参考电流：(DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E316LT1-1

Product Description:

- E316LT1-1 is an austenitic stainless steel flux-cored welding wire. The weld metal contains an appropriate amount of ferrite, resulting in low crack sensitivity. Due to its relatively high molybdenum (Mo) content, it exhibits excellent corrosion resistance. It features a soft and stable arc, minimal spatter, an attractive weld bead appearance, good slag detachability, and stable wire feeding, thus possessing superior welding process performance. It is suitable for all-position welding.
- It is suitable for industries such as petrochemical, pressure vessel, food machinery, medical machinery, and chemical fertilizer. It is used for welding 18%Cr-12%Ni-2%Mo stainless steel (such as SUS316, SUS316L).

Compliant with standards:

- GB/T17853 TS316L-FC1 1·AWS A5.22 E316LT1-1
- ISO 17633-A-T 19 12 3 L R C1 1

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal

(Mass Fraction)：%

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Standard value	≤ 0.04	0.5-2.5	≤ 1.0	17.0-20.0	11.0-14.0	2.0-3.0	≤ 0.04	≤ 0.03	≤ 0.75
Example value	0.019	1.50	0.57	18.55	11.98	2.35	0.018	0.005	0.03

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 485	≥ 25
Example value	550	35

Reference current：(DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E2209T1-1

产品说明:

- E2209T1-1 属奥氏体-铁素体双相型不锈钢药芯焊丝, 焊缝组织为奥氏体-铁素体双相组织, 含有 40% 左右的铁素体; 熔敷金属兼有奥氏体和铁素体不锈钢的综合性能, 耐点蚀和应力腐蚀性能优异; 全位置焊接。
- 应用于石油化工行业对应钢材 00Cr22Ni5Mo3N(SUS2205) 等含 22%Cr 双相不锈钢的焊接。

符合标准:

- GB/T17853 TS2209-FC1 1·AWS A5.22 E2209T1-1
- ISO 17633-A: T22 9 3NLPC11

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
标准值	≤ 0.04	0.5-2.0	≤ 1.0	≤ 0.04	≤ 0.03	7.5-10.0	21.0-24.0	2.5-4.0	≤ 0.75	0.08-2.0
例值	0.02	1.0	0.6	0.015	0.005	8.2	22.9	3.5	0.02	0.17

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)	-20°C冲击功 KV ₂ (J)
标准值	≥ 690	≥ 15	-
例值	815	26	46

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E2209T1-1

Product Description:

- E2209T1-1 is an austenitic-ferritic duplex stainless steel flux-cored welding wire. The weld metal exhibits an austenitic-ferritic duplex microstructure, containing approximately 40% ferrite. The deposited metal combines the comprehensive properties of both austenitic and ferritic stainless steels, with excellent pitting corrosion resistance and stress corrosion cracking resistance. It is suitable for all-position welding.
- It is applied to the welding of 22% Cr-containing duplex stainless steels in the petrochemical industry, such as the corresponding steel grade 00Cr22Ni5Mo3N (SUS2205).

Compliant with standards:

- GB/T17853 TS2209-FC1 1·AWS A5.22 E2209T1-1
- ISO 17633-A: T22 9 3NLPC11

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	P	S	Ni	Cr	Mo	Cu	N
Standard value	≤ 0.04	0.5-2.0	≤ 1.0	≤ 0.04	≤ 0.03	7.5-10.0	21.0-24.0	2.5-4.0	≤ 0.75	0.08-2.0
Example value	0.02	1.0	0.6	0.015	0.005	8.2	22.9	3.5	0.02	0.17

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)	Impact energy at -20°C KV ₂ (J)
Standard value	≥ 690	≥ 15	-
Example value	815	26	46

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

不锈钢药芯焊丝

BC-E2594T1-1

产品说明:

- E2594T1-1 焊缝组织为奥氏体 - 铁素体超级双相组织。耐点蚀性能优异, PREN (耐点蚀当量) ≥ 40 。送丝稳定, 具有优良的焊接工艺性能。全位置焊接。
- 适用于超级双相不锈钢 UNS S32750、UNS J93380 等含 25%Cr 双相钢的焊接。

符合标准:

- GB/T17853 TS 2594-F C1 1·AWS A5.22 E2594T1-1
- ISO 17633-A:T2594NLPC11

保护气体:

- 100%CO₂

熔敷金属化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu	W
标准值	≤ 0.04	0.5-2.5	≤ 1.0	24.0-27.0	8.0-10.5	2.5-4.5	≤ 0.04	≤ 0.03	0.2-0.3	≤ 1.5	≤ 1.0
例值	0.025	1.15	0.65	24.5	9.00	3.50	0.018	0.002	0.25	0.02	0.01

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
标准值	≥ 760	≥ 13
例值	880	25

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电压 (Volt)	22-36	26-38
电流 (Amp)	120-260	200-300
干伸长度 (mm)	15-20	18-25
气体流量 (l/min)	15-25	15-25

Stainless steel flux-cored wire

BC-E2594T1-1

Product Description:

- The main component of E2594T1-1 is 25.5%Cr-9.3%Ni-3.5%Mo-0.25%N, and the weld structure is austenitic-ferrite super duplex structure. Excellent pitting resistance, PREN (Pitting Resistance Equivalent) ≥ 40 . The wire feeding is stable and has excellent welding process performance.
- It is suitable for welding super duplex stainless steel UNS S32750, UNS J93380 and other duplex steels containing 25% Cr.

Compliant with standards:

- GB/T17853 TS 2594-F C1 1·AWS A5.22 E2594T1-1
- ISO 17633-A:T2594NLPC11

Protective gas:

- 100%CO₂

Chemical Composition of Deposition Metal (Mass Fraction) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	N	Cu	W
Standard value	≤ 0.04	0.5-2.5	≤ 1.0	24.0-27.0	8.0-10.5	2.5-4.5	≤ 0.04	≤ 0.03	0.2-0.3	≤ 1.5	≤ 1.0
Example value	0.025	1.15	0.65	24.5	9.00	3.50	0.018	0.002	0.25	0.02	0.01

Mechanical properties of deposited metals:

	Tensile strength Rm(MPa)	Elongation A(%)
Standard value	≥ 760	≥ 13
Example value	880	25

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Voltage (Volt)	22-36	26-38
Electric Current (Amp)	120-260	200-300
Dry Extension Length (mm)	15-20	18-25
Gas Flow Rate (l/min)	15-25	15-25

BC-D212

产品说明:

- D212 是 CO₂ 气体保护的钛钙型堆焊药芯焊丝，堆焊时电弧稳定，易脱渣，成形好。采用直流反接。
- 用于受磨损的中低碳钢及合金钢的表面堆焊，抗裂较好，可机加工。

堆焊层化学成分（质量分数）： %

	C	Cr	Mn	Si	Mo	P	S
例值	0.40-0.50	4.50-5.50	1.50-2.50	1.00-2.00	0.30-0.80	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 50-53

参考电流：（DC⁺）

焊丝直径（mm）	1.2	1.6
电流（A）	150-300	180-350
电压（V）	16-33	19-37

BC-D212

Product Description:

- D212 is a titanium-calcium type surfacing flux-cored wire protected by CO gas. During surfacing, the arc is stable, slag removal is easy, and the forming is good. Use direct current reverse polarity.
- It is used for surfacing on the surfaces of worn medium-low carbon steel and alloy steel. It has good crack resistance and can be machined.

Chemical composition of the surfacing layer
(mass fraction): %

	C	Cr	Mn	Si	Mo	P	S
Example value	0.40-0.50	4.50-5.50	1.50-2.50	1.00-2.00	0.30-0.80	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 50-53

Reference current：（DC⁺）

Diameter（mm）	1.2	1.6
Electric Current（A）	150-300	180-350
Voltage（V）	16-33	19-37

BC-D218

产品说明:

- D218 是 CO₂ 气体保护的金属粉型堆焊药芯焊丝，堆焊时电弧稳定，焊后无渣，成形好。采用直流反接。
- 用于受磨损的中低碳钢及合金钢的表面堆焊，抗裂较好，可机加工。

堆焊层化学成分 (质量分数) : %

	C	Cr	Mn	Si	Mo	Cu	P	S
例值	0.50-0.70	6.00-8.00	1.00-2.00	1.00-2.00	0.30-0.60	0.20-0.50	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 55-59

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

BC-D218

Product Description:

- D218 is a metal powder type surfacing flux-cored wire protected by CO gas. During surfacing, the arc is stable, there is no slag after welding, and the forming is good. Direct current reverse polarity is adopted.
- It is used for surfacing on the surfaces of worn medium-low carbon steel and alloy steel. It has good crack resistance and can be machined.

Chemical composition of the surfacing layer (mass fraction): %

	C	Cr	Mn	Si	Mo	Cu	P	S
Example value	0.50-0.70	6.00-8.00	1.00-2.00	1.00-2.00	0.30-0.60	0.20-0.50	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 55-59

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

BC-D256

产品说明:

- D256 是 CO₂ 气体保护的锰型渣系堆焊药芯焊丝，堆焊时电弧稳定，易脱渣，成形好。采用直流反接。
- 用于堆焊修复各种破碎机，道岔推土机，高锰钢轨等冲击易磨损的工件。

堆焊层化学成分 (质量分数) : %

	C	Mn	Si	Mo	P	S
例值	0.10-0.50	10.00-13.00	0.50-1.00	0.10-0.20	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 33-38

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

BC-D256

Product Description:

- D256 is a manganese-based slag system flux-cored wire for CO gas shielded surfacing. During surfacing, the arc is stable, slag is easy to detach, and the forming is good. DC reverse polarity is adopted.
- Suitable for surfacing repair of various impact and abrasion-prone workpieces such as crushers, turnout bulldozers, and high-manganese steel rails.

Chemical composition of the surfacing layer (mass fraction): %

	C	Mn	Si	Mo	P	S
Example value	0.10-0.50	10.00-13.00	0.50-1.00	0.10-0.20	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 33-38

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

BC-D507

产品说明:

- D507 是 CO₂ 气体保护的偏碱性渣系堆焊药芯焊丝，堆焊时电弧稳定，易脱渣，成形好。采用直流反接。
- 属 Cr13 系堆焊焊丝，适用于修复各种阀门及中低碳钢，也可用于耐中低温工件的表面堆焊。

堆焊层化学成分 (质量分数) : %

	C	Cr	Mn	Si	Ni	P	S
例值	0.10-0.15	11.00-15.00	0.50-1.50	0.50-1.50	0.10-0.20	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 40-42

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

BC-D507

Product Description:

- D507 is a flux-cored wire for surfacing with a slightly alkaline slag system protected by CO gas. During surfacing, it features a stable arc, easy slag removal, and good formation. DC reverse polarity connection is applied.
- It belongs to the Cr13 series surfacing welding wire, suitable for repairing various valves and medium/low carbon steel, and can also be used for surface surfacing of workpieces resistant to medium and low temperatures.

Chemical composition of the surfacing layer (mass fraction): %

	C	Cr	Mn	Si	Ni	P	S
Example value	0.10-0.15	11.00-15.00	0.50-1.50	0.50-1.50	0.10-0.20	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 40-42

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

BC-D507Mo

产品说明:

- D507Mo 是 CO₂ 气体保护的偏碱性渣系堆焊药芯焊丝，堆焊时电弧稳定，易脱渣，成形好。采用直流反接。
- 属 Cr13 系堆焊焊丝，适用于修复各种阀门及中低碳钢，也可用于耐中低温工件的表面堆焊。

堆焊层化学成分 (质量分数) : %

	C	Cr	Mn	Si	Ni	Mo	P	S
例值	0.10-0.20	11.00-14.00	0.80-1.50	0.40-0.80	0.20-0.40	0.20-0.40	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 40-42

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

BC-D507Mo

Product Description:

- D507Mo is a flux-cored wire for surfacing with a slightly alkaline slag system under CO₂ gas shielding. It features stable arcing, easy slag detachment, and good bead formation during the surfacing process. DC reverse polarity connection is recommended.
- It belongs to the Cr13 series of surfacing welding wires, suitable for repairing various valves and medium/low carbon steel, and can also be used for surface surfacing of workpieces resistant to medium and low temperatures.

Chemical composition of the surfacing layer (mass fraction): %

	C	Cr	Mn	Si	Ni	Mo	P	S
Example value	0.10-0.20	11.00-14.00	0.80-1.50	0.40-0.80	0.20-0.40	0.20-0.40	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 40-42

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

BC-D517

产品说明:

- D517 是 CO² 气体保护的偏碱性渣系堆焊药芯焊丝，堆焊时电弧稳定，易脱渣，成形好。采用直流反接。
- 属 Cr13 系堆焊焊丝，较 D507 堆焊硬度有所增加，适用于修复各种阀门及中低碳钢，也可用于耐中低温工件的表面堆焊。

堆焊层化学成分 (质量分数) : %

	C	Cr	Mn	Si	Ni	P	S
例值	0.15-0.25	11.00-15.00	0.50-1.50	0.50-1.50	0.10-0.20	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 43-45

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

BC-D517

Product Description:

- D517 is a flux-cored wire for surfacing with a slightly alkaline slag system protected by CO² gas. During the surfacing process, it features a stable arc, easy slag removal, and good formation. DC reverse polarity connection is applied.
- It belongs to the Cr13 series of surfacing welding wires. With higher hardness than D507, it is suitable for repairing various valves and medium/low carbon steel, and can also be used for surface surfacing of workpieces resistant to medium and low temperatures.

Chemical composition of the surfacing layer (mass fraction): %

	C	Cr	Mn	Si	Ni	P	S
Example value	0.15-0.25	11.00-15.00	0.50-1.50	0.50-1.50	0.10-0.20	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 43-45

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

堆焊药芯焊丝

BC-D688

产品说明:

- D688 是 CO₂ 气体保护的金属粉型堆焊药芯焊丝，堆焊时电弧稳定，焊层无渣，成形好。采用直流反接。
- 用于受磨损的中低碳钢及合金钢的表面堆焊，抗裂较好，可机加工。

堆焊层化学成分（质量分数）：%

	C	Cr	Mn	Si	Mo	Cu	P	S
例值	0.50-0.70	7.00-9.00	1.50-2.50	1.50-2.50	0.50-0.80	0.30-0.60	≤ 0.04	≤ 0.03

堆焊层硬度:

- HRC 55-59

参考电流: (DC⁺)

焊丝直径 (mm)	1.2	1.6
电流 (A)	150-300	180-350
电压 (V)	16-33	19-37

Overlay Flux-Cored Welding Wire

BC-D688

Product Description:

- D688 is a metal powder type flux-cored wire for CO₂ gas shielded surfacing. During surfacing, the arc is stable, the weld layer is slag-free, and the forming is good. DC reverse polarity is adopted.
- It is used for surface surfacing of worn medium-low carbon steel and alloy steel, has good crack resistance, and can be machined.

Chemical composition of the surfacing layer (mass fraction): %

	C	Cr	Mn	Si	Mo	Cu	P	S
Example value	0.50-0.70	7.00-9.00	1.50-2.50	1.50-2.50	0.50-0.80	0.30-0.60	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 55-59

Reference current: (DC⁺)

Diameter (mm)	1.2	1.6
Electric Current (A)	150-300	180-350
Voltage (V)	16-33	19-37

BC-D707

产品说明 /Product Description

- D707 是 CO₂ 气体保护的石墨型堆焊药芯焊丝，堆焊时电弧稳定，焊层无渣，成形好。采用直流反接。
- 高碳化钨堆焊焊丝，耐高温、耐磨性极强，用于堆焊修复强烈磨损工件。

堆焊层化学成分（质量分数）：%

	C	W	Mn	Si	P	S
例值	2.00-4.00	40.00-50.00	0.50-1.50	0.50-1.50	≤ 0.04	≤ 0.03

堆焊层硬度：

- HRC 60-65

参考电流：（DC⁺）

焊丝直径（mm）	1.2	1.6
电流（A）	150-300	180-350
电压（V）	16-33	19-37

BC-D707

产品说明 /Product Description

- D707 is a graphite-type flux-cored wire for CO₂ gas shielded surfacing. During surfacing, the arc is stable, the weld layer is slag-free, and the formation is good. DC reverse polarity is adopted.
- High-tungsten carbide surfacing welding wire, with extremely high temperature resistance and wear resistance, is used for surfacing repair of severely worn workpieces.

Chemical composition of the surfacing layer (mass fraction): %

	C	W	Mn	Si	P	S
Example value	2.00-4.00	40.00-50.00	0.50-1.50	0.50-1.50	≤ 0.04	≤ 0.03

Hardness of the surfacing layer:

- HRC 60-65

Reference current:（DC⁺）

Diameter（mm）	1.2	1.6
Electric Current（A）	150-300	180-350
Voltage（V）	16-33	19-37

BCM-49-1

产品说明:

- 49-1 是普通碳钢用 MIG 焊丝, 适用于单道及多道焊和普通钢结构的焊接。

符合标准:

- GB/T 8110:ER49-1

保护气体:

- 100%CO₂

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P
标准值	≤ 0.11	1.8-2.1	0.65-0.95	≤ 0.03	≤ 0.03
例值	0.071	1.91	0.79	0.012	0.018

熔敷金属力学性能典型值 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)- 室温
标准值	≥ 490	≥ 372	≥ 20	≥ 47
例值	560	460	26	110

参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCM-49-1

Product Description:

- 49-1 is MIG welding wire for ordinary carbon steel, which is suitable for single-pass and multi-pass welding and welding of ordinary steel structures.

Compliant with standards:

- GB/T 8110:ER49-1

Protective gas:

- 100%CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P
Standard Value	≤ 0.11	1.8-2.1	0.65-0.95	≤ 0.03	≤ 0.03
Example Value	0.071	1.91	0.79	0.012	0.018

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) - Room Temperature
Standard Value	≥ 490	≥ 372	≥ 20	≥ 47
Example Value	560	460	26	110

Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-49-1

产品说明:

- 49-1 是普通碳钢用 TIG 焊丝, 适用于造船、石油化工、核能等高压设备管道。

符合标准:

- GB/T 8110:ER49-1·AWS A5.18:ER70S-G

保护气体:

- 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P
标准值	≤ 0.11	1.8-2.1	0.65-0.95	≤ 0.03	≤ 0.03
例值	0.083	1.94	0.78	0.011	0.013

熔敷金属力学性能典型值 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-室温
标准值	≥ 490	≥ 372	≥ 20	≥ 47
例值	560	460	30	280

参考电流: (DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-49-1

Product Description:

- 49-1 is TIG welding wire for ordinary carbon steel, which is suitable for high-pressure equipment pipelines such as shipbuilding, petrochemical industry, and nuclear energy.

Compliant with standards:

- GB/T 8110:ER49-1·AWS A5.18:ER70S-G

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P
Standard Value	≤ 0.11	1.8-2.1	0.65-0.95	≤ 0.03	≤ 0.03
Example Value	0.083	1.94	0.78	0.011	0.013

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) - Room Temperature
Standard Value	≥ 490	≥ 372	≥ 20	≥ 47
Example Value	560	460	30	280

Reference current: (DC)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCM-50-G

产品说明：

- 50-G 是普通碳钢用 MIG 焊丝，适用于单道及多道焊，可焊接薄板，高速焊接及普通结构焊。

符合标准：

- GB/T 8110:ER50-G·AWS A5.18:ER70S-G·JIS Z3312:YGW15

保护气体：

- 100%CO₂

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	S	P	Ti
标准值	0.02-0.15	1.0-1.6	0.4-1.0	≤ 0.03	≤ 0.03	0.02-0.15
例值	0.08	1.44	0.73	0.009	0.012	0.14

熔敷金属力学性能典型值（焊态）：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-20°C
标准值	490-670	≥ 400	≥ 18	≥ 47
例值	565	485	30	102

参考电流：（DC⁺）

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCM-50-G

Product Description:

- 50-G is a MIG welding wire for ordinary carbon steel, suitable for single and multi-pass welding, welding thin plates, high-speed welding and ordinary structural welding.

Compliant with standards:

- GB/T 8110:ER50-G·AWS A5.18:ER70S-G·JIS Z3312:YGW15

Protective gas:

- 100%CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ti
Standard Value	0.02-0.15	1.0-1.6	0.4-1.0	≤ 0.03	≤ 0.03	0.02-0.15
Example Value	0.08	1.44	0.73	0.009	0.012	0.14

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) -20°C
Standard Value	490-670	≥ 400	≥ 18	≥ 47
Example Value	565	485	30	102

Reference current：（DC⁺）

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-50-G

产品说明:

- 50-G 是普通碳钢用 TIG 焊丝, 适用于造船、石油化工、核能等高压设备管道。

符合标准:

- GB/T 8110:ER50-G·AWS A5.18:ER70S-G

保护气体:

- 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数): %

	C	Mn	Si	S	P
标准值	-	-	-	-	-
例值	0.07	1.48	0.83	0.015	0.015

熔敷金属力学性能典型值 (焊态):

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-30°C
标准值	≥ 480	≥ 400	≥ 22	-
例值	550	460	30	160

参考电流: (DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-50-G

Product Description:

- 50-G is TIG welding wire for ordinary carbon steel, which is suitable for high-pressure equipment pipelines such as shipbuilding, petrochemical industry, and nuclear energy.

Compliant with standards:

- GB/T 8110:ER50-G·AWS A5.18:ER70S-G

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P
Standard Value	-	-	-	-	-
Example Value	0.07	1.48	0.83	0.015	0.015

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) -30°C
Standard Value	≥ 480	≥ 400	≥ 22	-
Example Value	550	460	30	160

Reference current: (DC)

Diameter(mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCM-50-3

产品说明：

- 50-3 是普通碳钢用 MIG 焊丝，适用于工程机械、汽车、钢结构、管道、集装箱，锅炉及压力容器，弧焊机械人焊接。

符合标准：

- GB/T 8110:ER50-3·AWS A5.18:ER70S-3·JIS Z3312:YGW16

保护气体：

- 80%Ar+20%CO₂

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	S	P
标准值	0.06-0.15	0.90-1.40	0.45-0.75	≤ 0.035	≤ 0.025
例值	0.081	1.29	0.55	0.013	0.013

熔敷金属力学性能典型值（焊态）：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-20°C
标准值	≥ 400	≥ 480	≥ 22	≥ 27
例值	455	555	27	110

参考电流：（DC⁺）

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCM-50-3

Product Description:

- 50-3 is MIG welding wire for ordinary carbon steel, suitable for construction machinery, automobiles, steel structures, pipelines, containers, boilers and pressure vessels, arc welding robot welding.

Compliant with standards:

- GB/T 8110:ER50-3·AWS A5.18:ER70S-3·JIS Z3312:YGW16

Protective gas:

- 80%Ar+20%CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P
Standard Value	0.06-0.15	0.90-1.40	0.45-0.75	≤ 0.035	≤ 0.025
Example Value	0.081	1.29	0.55	0.013	0.013

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J)-20°C
Standard Value	≥ 400	≥ 480	≥ 22	≥ 27
Example Value	455	555	27	110

Reference current：（DC⁺）

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-50-3

产品说明：

- 50-3是普通碳钢用TIG焊丝，适用于薄板焊接以及打底焊接应用。

符合标准：

- GB/T 8110:ER50-3·AWS A5.18:ER70S-3

保护气体：

- 100%Ar

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	S	P
标准值	0.06-0.15	0.90-1.40	0.45-0.75	≤ 0.035	≤ 0.025
例值	0.081	1.94	0.61	0.012	0.015

熔敷金属力学性能典型值（焊态）：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)- 20°C
标准值	≥ 480	≥ 400	≥ 22	≥ 27
例值	540	440	29	156

参考电流：（DC）

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-50-3

Product Description:

- 50-3 is a TIG welding wire for ordinary carbon steel, which is suitable for thin plate welding as well as root welding applications.

Compliant with standards:

- GB/T 8110:ER50-3·AWS A5.18:ER70S-3

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction):%

	C	Mn	Si	S	P
Standard Value	0.06-0.15	0.90-1.40	0.45-0.75	≤ 0.035	≤ 0.025
Example Value	0.081	1.94	0.61	0.012	0.015

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J)-20°C
Standard Value	≥ 480	≥ 400	≥ 22	≥ 27
Example Value	540	440	29	156

Reference current：（DC）

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCM-50-6

产品说明:

- 50-6 是普通碳钢用 MIG 焊丝，适用于工程机械、汽车、钢结构、管道、集装箱和弧焊机器人焊接。

符合标准:

- GB/T 8110:ER50-6·AWS A5.18:ER70S-6·JIS Z3312:YGW12

保护气体:

- 100%CO₂,80%Ar+20%CO₂

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P
标准值	0.06-0.15	1.4-1.85	0.8-1.15	≤ 0.035	≤ 0.025
例值	0.073	1.49	0.88	0.011	0.01

熔敷金属力学性能典型值 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-30°C
标准值	≥ 480	≥ 400	≥ 22	≥ 27
例值	565	460	30	88

参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCM-50-6

Product Description:

- 50-6 is a MIG welding wire for ordinary carbon steel, which is suitable for construction machinery, automobiles, steel structures, pipelines, containers and arc welding robot welding.

Compliant with standards:

- GB/T 8110:ER50-6·AWS A5.18:ER70S-6·JIS Z3312:YGW12

Protective gas:

- 100%CO₂,80%Ar+20%CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction):%

	C	Mn	Si	S	P
Standard Value	0.06-0.15	1.4-1.85	0.8-1.15	≤ 0.035	≤ 0.025
Example Value	0.073	1.49	0.88	0.011	0.01

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J)-30°C
Standard Value	≥ 480	≥ 400	≥ 22	≥ 27
Example Value	565	460	30	88

Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-50-6

产品说明：

- 50-6 是普通碳钢用 TIG 焊丝，适用于造船、石油化工、核能等高压设备管道。

符合标准：

- GB/T 8110:ER50-6·AWS A5.18:ER70S-6

保护气体：

- 100%Ar

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	S	P
标准值	0.06-0.15	1.4-1.85	0.8-1.15	≤ 0.035	≤ 0.025
例值	0.07	1.48	0.83	0.015	0.015

熔敷金属力学性能典型值（焊态）：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)-30°C
标准值	≥ 480	≥ 400	≥ 22	≥ 27
例值	550	460	30	160

参考电流：(DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-50-6

Product Description:

- 50-6 is TIG welding wire for ordinary carbon steel, which is suitable for high-pressure equipment pipelines such as shipbuilding, petrochemical industry, and nuclear energy.

Compliant with standards:

- GB/T 8110:ER50-6·AWS A5.18:ER70S-6

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P
Standard Value	0.06-0.15	1.4-1.85	0.8-1.15	≤ 0.035	≤ 0.025
Example Value	0.07	1.48	0.83	0.015	0.015

Typical Values of Mechanical Properties of Deposited Metal (As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J)-30°C
Standard Value	≥ 480	≥ 400	≥ 22	≥ 27
Example Value	550	460	30	160

Reference current: (DC)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

低合金钢实心焊丝

BCM-55-B2

产品说明:

- 55-B2 是低合金钢用 MIG 焊丝, 适用于锅炉及压力容器、动力管道、化工装置。

符合标准:

- GB/T 8110:ER55-B2-MnV·AWS A5.28:ER80S-G

保护气体:

- Ar/ (5%-25%) CO₂

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
标准值	0.06-0.1	1.20-1.60	0.60-0.90	≤ 0.025	≤ 0.030	≤ 0.25	1.00-1.30	0.50-0.70	≤ 0.35	0.20-0.40
例值	0.083	1.36	0.66	0.012	0.011	0.042	1.1	0.59	0.18	0.30

熔敷金属力学性能: (焊后热处理 730°C *1h)

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J) 室温
标准值	≥ 550	≥ 440	≥ 19	≥ 27
例值	650	565	25	106

参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

Solid welding wire for low-alloy steel

BCM-55-B2

Product Description:

- 55-B2 is MIG welding wire for low-alloy steel, suitable for boilers and pressure vessels, power pipelines, and chemical plants.

Compliant with standards:

- GB/T 8110:ER55-B2-MnV·AWS A5.28:ER80S-G

Protective gas:

- Ar/ (5%-25%) CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	V
Standard Value	0.06-0.1	1.20-1.60	0.60-0.90	≤ 0.025	≤ 0.030	≤ 0.25	1.00-1.30	0.50-0.70	≤ 0.35	0.20-0.40
Example Value	0.083	1.36	0.66	0.012	0.011	0.042	1.1	0.59	0.18	0.30

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment at 730°C for 1 Hour)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) at Room Temperature
Standard Value	≥ 550	≥ 440	≥ 19	≥ 27
Example Value	650	565	25	106

Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

低合金钢实心焊丝

BCT-55-B2

产品说明:

- 55-B2 是低合金钢用 TIG 焊丝, 适用于 1-1.25%Cr-0.5%Mo 抗蠕变耐热钢 TIG 焊, 应用在锅炉、压力容器、动力管道、化工装置等行业。

符合标准:

- GB/T 8110:ER55-B2-MnV·AWS A5.28:ER80S-G

保护气体:

- 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo
标准值	0.06-0.10	1.20-1.70	0.60-0.90	≤ 0.025	≤ 0.030	≤ 0.25	0.90-1.20	0.45-0.65
例值	0.06	1.68	0.75	0.001	0.016	-	0.95	0.53

熔敷金属力学性能: (焊后热处理 730°C *1h)

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J) 室温
标准值	≥ 550	≥ 440	≥ 20	≥ 27
例值	650	545	25	150

参考电流: (DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

Solid welding wire for low-alloy steel

BCT-55-B2

Product Description:

- 55-B2 is TIG welding wire for low alloy steel, suitable for TIG welding of creep resistant and heat-resistant steel with 1-1.25%Cr-0.5%Mo, which is used in boilers, pressure vessels, power pipelines, chemical plants and other industries.

Compliant with standards:

- GB/T 8110:ER55-B2-MnV·AWS A5.28:ER80S-G

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo
Standard Value	0.06-0.10	1.20-1.70	0.60-0.90	≤ 0.025	≤ 0.030	≤ 0.25	0.90-1.20	0.45-0.65
Example Value	0.06	1.68	0.75	0.001	0.016	-	0.95	0.53

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment at 730°C for 1 Hour)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) at Room Temperature
Standard Value	≥ 550	≥ 440	≥ 20	≥ 27
Example Value	650	545	25	150

Reference current: (DC)

Diameter(mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

低合金钢实心焊丝

BCM-55-G

产品说明:

- 55-G 是低合金钢用 MIG 焊丝，适用于锅炉及压力容器、动力管道、化工装置。

符合标准:

- GB/T 8110:ER55-G · AWS A5.28:ER80S-G · JIS Z3317:G55M-1CM3

保护气体:

- Ar/ (5%-25%) CO₂

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Cu	Ni	Cr	Mo
标准值	≤ 0.12	0.80-1.50	0.30-0.90	≤ 0.025	≤ 0.025	≤ 0.40	-	1.00-1.60	0.40-0.65
例值	0.08	1.31	0.7	0.014	0.014	0.12	0.02	1.22	0.51

熔敷金属力学性能: (焊后热处理: 690°C *1h)

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)0°C
标准值	≥ 550	≥ 470	≥ 17	-
例值	625	525	26	89

参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

Solid welding wire for low-alloy steel

BCM-55-G

Product Description:

- 55-G is a MIG welding wire for low-alloy steel, suitable for boilers and pressure vessels, power pipelines, and chemical plants.

Compliant with standards:

- GB/T 8110:ER55-G · AWS A5.28:ER80S-G · JIS Z3317:G55M-1CM3

Protective gas:

- Ar/ (5%-25%) CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cu	Ni	Cr	Mo
Standard Value	≤ 0.12	0.80-1.50	0.30-0.90	≤ 0.025	≤ 0.025	≤ 0.40	-	1.00-1.60	0.40-0.65
Example Value	0.08	1.31	0.7	0.014	0.014	0.12	0.02	1.22	0.51

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment: 690°C * 1h)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) 0°C
Standard Value	≥ 550	≥ 470	≥ 17	-
Example Value	625	525	26	89

Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-55-G

产品说明:

- 55-G 是低合金钢用 TIG 焊丝，适用于 1-1.25%Cr-0.5%Mo 抗蠕变耐热钢 TIG 焊，应用在锅炉、压力容器、动力管道、化工装置等行业。

符合标准:

- GB/T 8110:ER55-G · AWS A5.28:ER80S-G · JIS Z3316:YGT1CM

保护气体:

- 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo
标准值	-	-	-	-	-	-	≥ 0.30	≥ 0.20
例值	0.071	1.44	0.72	0.012	0.013	0.022	1.22	0.52

熔敷金属力学性能: (焊后热处理: 690°C * 1h)

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)0°C
标准值	≥ 550	-	-	-
例值	630	530	26	146

参考电流: (DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-55-G

Product Description:

- 55-G is TIG welding wire for low alloy steel, suitable for TIG welding of creep resistant and heat-resistant steel from 1-1.25%Cr-0.5%Mo, which is used in boilers, pressure vessels, power pipelines, chemical plants and other industries.

Compliant with standards:

- GB/T 8110:ER55-G · AWS A5.28:ER80S-G · JIS Z3316:YGT1CM

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo
Standard Value	-	-	-	-	-	-	≥ 0.30	≥ 0.20
Example Value	0.071	1.44	0.72	0.012	0.013	0.022	1.22	0.52

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment: 690°C * 1h)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) 0°C
Standard Value	≥ 550	-	-	-
Example Value	630	530	26	146

Reference current: (DC)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

低合金钢实心焊丝

BCM-62-G

产品说明：

- 62-G 是低合金钢用 MIG 焊丝，适用于锅炉及压力容器、动力管道、化工装置。

符合标准：

- GB/T 8110:ER62-G·AWS A5.28:ER90S-G·JIS Z3317:G62M-2C1M3

保护气体：

- Ar/ (5%-25%) CO₂

焊接位置：

- 全位置

焊丝化学成分（质量分数）： %

	C	Mn	Si	S	P	Cu	Ni	Cr	Mo
标准值	≤ 0.12	0.75-1.50	0.3-0.9	≤ 0.025	≤ 0.025	≤ 0.4	-	2.1-2.7	0.9-1.2
例值	0.073	1.09	0.47	0.011	0.01	0.13	0.026	2.24	0.92

熔敷金属力学性能：（焊后热处理：690°C *1h）

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)0°C
标准值	≥ 620	≥ 540	≥ 15	-
例值	660	570	23	110

参考电流：（DC⁺）

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.4	1.6
焊接电流 (A)	50-180	60-200	70-220	80-350	120-420	180-550

Solid welding wire for low-alloy steel

BCM-62-G

Product Description:

- 62-G is a MIG welding wire for low-alloy steel, suitable for boilers and pressure vessels, power pipelines, and chemical plants.

Compliant with standards:

- GB/T 8110:ER62-G·AWS A5.28:ER90S-G·JIS Z3317:G62M-2C1M3

Protective gas:

- Ar/ (5%-25%) CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cu	Ni	Cr	Mo
Standard Value	≤ 0.12	0.75-1.50	0.3-0.9	≤ 0.025	≤ 0.025	≤ 0.4	-	2.1-2.7	0.9-1.2
Example Value	0.073	1.09	0.47	0.011	0.01	0.13	0.026	2.24	0.92

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment: 690°C * 1h)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) 0°C
Standard Value	≥ 620	≥ 540	≥ 15	-
Example Value	660	570	23	110

Reference current：（DC⁺）

Diameter (mm)	0.8	0.9	1.0	1.2	1.4	1.6
Electric Current (A)	50-180	60-200	70-220	80-350	120-420	180-550

BCT-62-G

产品说明:

- 62-G 是低合金钢用 TIG 焊丝，适用于 2.25%Cr-0.5%Mo 抗蠕变耐热钢 TIG 焊，应用在锅炉、压力容器、动力管道、化工装置等行业。

符合标准:

- GB/T 8110:ER62-G·AWS A5.28:ER90S-G·JIS Z3316:YGT2CM

保护气体:

- 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo
标准值	-	-	-	-	-	-	≥ 0.30	≥ 0.20
例值	0.09	1.15	0.65	0.01	0.016	0.03	2.3	0.97

熔敷金属力学性能: (焊后热处理: 690°C *1h)

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J)0°C
标准值	≥ 620	-	-	-
例值	670	570	24	144

参考电流: (DC)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

BCT-62-G

Product Description:

- 62-G is TIG welding wire for low-alloy steel, suitable for TIG welding of 2.25%Cr-0.5%Mo creep-resistant heat-resistant steel, which is used in boilers, pressure vessels, power pipelines, chemical plants and other industries.

Compliant with standards:

- GB/T 8110:ER62-G·AWS A5.28:ER90S-G·JIS Z3316:YGT2CM

Protective gas:

- 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo
Standard Value	-	-	-	-	-	-	≥ 0.30	≥ 0.20
Example Value	0.09	1.15	0.65	0.01	0.016	0.03	2.3	0.97

Mechanical Properties of Deposited Metal:
(Post-Weld Heat Treatment: 690°C × 1h)

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) 0°C
Standard Value	≥ 620	-	-	-
Example Value	670	570	24	144

Reference current: (DC)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	90-150	100-160	120-180	140-200	160-240	180-260	220-280	240-300

不锈钢实心焊丝

BCM-307·BCT-307

产品说明:

- 307 为 21Cr-9Ni-4Mn 纯奥氏体不锈钢 MIG/TIG 焊丝，焊缝金属无磁、裂纹敏感度低。
- 用于焊接非磁性、高锰钢、硬化性耐蚀钢，也可用于焊接难焊且易开裂的异种钢材。

符合标准:

- GB/T29713 S307·AWS A5.9 ER307·ISO 14343-B-SS307

保护气体:

- MIG: Ar+ (3%-10%) O₂
- TIG: Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S
例值	0.075	4.50	0.43	20.02	9.52	0.97	0.012	0.011

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	伸长率 A(%)
例值	600	39

Stainless Steel Solid Wire

BCM-307·BCT-307

Product Description:

- 307 is 21Cr-9Ni-4Mn pure austenitic stainless steel MIG/TIG welding wire, the weld metal is non-magnetic and has low crack sensitivity.
- It is used for welding non-magnetic, high-maintenance steel, hardening corrosion-resistant steel, and can also be used to weld dissimilar steel that is difficult to weld and easy to crack.

Compliant with standards:

- GB/T29713 S307·AWS A5.9 ER307·ISO 14343-B-SS307

Protective gas:

- MIG: Ar+ (3%-10%) O₂
- TIG: Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo	P	S
Example Value	0.075	4.50	0.43	20.02	9.52	0.97	0.012	0.011

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Elongation A(%)
Example Value	600	39

不锈钢实心焊丝

BCM-307Si

产品说明：

- 307Si 为一种奥氏体不锈钢 MIG 焊丝，采用直流反接，焊接工艺优良。
- 用于异种钢接头（碳锰钢与不锈钢），非磁性钢，加工硬化锰钢，装甲钢，焊接工艺性差的钢材，堆焊应用的过渡层，汽车排气系统和造船行业。

符合标准：

- ISO 14343-A-G 18 8Mn

保护气体：

- Ar (1%-5%) CO₂, Ar (1%-2%) O₂

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.2	5.0-8.0	≤ 1.2	17.0-20.0	7.0-10.0	≤ 0.50
例值	0.08	7.3	0.68	19.1	9.68	0.03

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	CVN 冲击韧性 (J) 20°C
标准值	≥ 500	≥ 350	≥ 25	-
例值	615	400	39	75

参考电流：（DC⁺）

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

Stainless Steel Solid Wire

BCM-307Si

Product Description:

- 307Si is an austenitic stainless steel MIG welding wire. Adopting DC reversed polarity, it features excellent welding process performance.
- This wire is applicable to dissimilar steel joints (carbon-manganese steel and stainless steel), non-magnetic steel, work-hardened manganese steel, armor steel, steels with poor weldability, transition layers for surfacing applications, as well as automotive exhaust systems and the shipbuilding industry.

Compliant with standards:

- ISO 14343-A-G 18 8Mn

Protective gas:

- Ar (1%-5%) CO₂, Ar (1%-2%) O₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.2	5.0-8.0	≤ 1.2	17.0-20.0	7.0-10.0	≤ 0.50
Example Value	0.08	7.3	0.68	19.1	9.68	0.03

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J) 20°C
Standard Value	≥ 500	≥ 350	≥ 25	-
Example Value	615	400	39	75

Reference current：（DC⁺）

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

不锈钢实心焊丝

BCM-308·BCT-308

产品说明：

- BCM-308 为不锈钢 MIG 焊丝，应用于石化设备，汽车排气系统，电站建设，食品机械，船舶和海洋工程。
- BCT-308 为不锈钢 TIG 焊丝，适于焊接含 18%Cr,8%Ni 不锈钢及相近合金成分的不锈钢，如：ASTM304,304N,301,302,305。

符合标准：

- AWS A5.9 ER308

保护气体：

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar
- 焊接位置：
- 全位置

焊丝化学成分（质量分数）：%

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.08	1.0-2.5	0.3-0.65	19.5-22.0	9.0-11.0	≤ 0.75
MIG 例值	0.027	1.85	0.49	19.9	10.3	0.014
TIG 例值	0.034	1.85	0.49	19.9	10.3	0.03

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 550	-	≥ 35
MIG 例值	620	450	38
TIG 例值	620	450	40

MIG 参考电流：(DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流：(DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-308·BCT-308

Product Description:

- BCM-308 is a stainless steel MIG welding wire, which is applied in petrochemical equipment, automobile exhaust systems, power station construction, food machinery, ships and marine engineering.
- BCT-308 is a stainless steel TIG welding wire, suitable for welding stainless steels containing 18% chromium and 8% nickel as well as stainless steels with similar alloy compositions, such as ASTM 304, 304N, 301, 302 and 305.

Compliant with standards:

- AWS A5.9 ER308

Protective gas:

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.08	1.0-2.5	0.3-0.65	19.5-22.0	9.0-11.0	≤ 0.75
MIG Example Value	0.027	1.85	0.49	19.9	10.3	0.014
TIG Example Value	0.034	1.85	0.49	19.9	10.3	0.03

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 550	-	≥ 35
MIG Example Value	620	450	38
TIG Example Value	620	450	40

MIG Reference current：(DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current：(DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

BCM-308L · BCT-308L

产品说明:

- BCM-308L 为不锈钢用 MIG 焊丝, 应用于石化设备, 汽车排气系统, 电站建设, 食品机械, 船舶和海洋工程。
- BCT-308L 为不锈钢用 TIG 焊丝, 适用于焊接 ASTM304L,308L,304LN 不锈钢。

符合标准:

- AWS A5.9 ER308L

保护气体:

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.3-0.65	19.5-22.0	9.0-11.0	≤ 0.75
MIG 例值	0.02	2.1	0.5	19.9	9.7	0.03
TIG 例值	0.02	2.1	0.5	19.9	9.7	0.03

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 520	-	≥ 35
MIG 例值	640	455	36.5
TIG 例值	600	455	41

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

BCM-308L · BCT-308L

Product Description:

- BCM-308L is a MIG welding wire for stainless steel, used in petrochemical equipment, automotive exhaust systems, power plant construction, food machinery, and marine engineering.
- BCT-308L is a TIG welding wire for stainless steel, suitable for welding ASTM 304L, 308L, and 304LN stainless steels.

Compliant with standards:

- AWS A5.9 ER308L

Protective gas:

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.3-0.65	19.5-22.0	9.0-11.0	≤ 0.75
MIG Example Value	0.02	2.1	0.5	19.9	9.7	0.03
TIG Example Value	0.02	2.1	0.5	19.9	9.7	0.03

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 520	-	≥ 35
MIG Example Value	640	455	36.5
TIG Example Value	600	455	41

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-308LSi·BCT-308LSi

产品说明:

- BCM-308LSi 为不锈钢用 MIG 焊丝，应用于石化设备，汽车排气系统，电站建设，食品机械，船舶和海洋工程。
- BCT-308LSi 为不锈钢用 TIG 焊丝，适用于焊接 ASTM304L,308L,304LN 不锈钢。

符合标准:

- AWS A5.9 ER308LSi

保护气体:

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.65-1.00	19.5-22.0	9.0-11.0	≤ 0.75
MIG 例值	0.02	2.25	0.78	19.8	10.5	0.035
TIG 例值	0.02	2.25	0.78	19.8	10.5	0.02

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 520	-	≥ 35
MIG 例值	610	445	41.5
TIG 例值	585	445	40

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-308LSi·BCT-308LSi

产品说明 /Product Description

- BCM-308LSi is a MIG welding wire for stainless steel, used in petrochemical equipment, automotive exhaust systems, power plant construction, food machinery, and marine engineering.
- BCT-308LSi is a TIG welding wire for stainless steel, suitable for welding ASTM 304L, 308L, and 304LN stainless steels.

Compliant with standards:

- AWS A5.9 ER308LSi

Protective gas:

- MIG: Ar+2% O₂ or Ar+5% CO₂

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.65-1.00	19.5-22.0	9.0-11.0	≤ 0.75
MIG Example Value	0.02	2.25	0.78	19.8	10.5	0.035
TIG Example Value	0.02	2.25	0.78	19.8	10.5	0.02

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 520	-	≥ 35
MIG Example Value	610	445	41.5
TIG Example Value	585	445	40

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-309 · BCT-309

产品说明:

- BCM-309 为不锈钢用 MIG 焊丝, 应用于石化设备、压力容器、电站建设、食品机械, 铬镍、铬镍钼不锈钢与碳钢异种钢焊接。
- BCT-309 为不锈钢用 TIG 焊丝, 适于焊接含 24%Cr,13%Ni 不锈钢及相近合金成分的不锈钢, 如: 304、304N、305、308、309, 也用于不锈钢与碳钢间的异种钢过渡焊接。

符合标准:

- AWS A5.9 ER309

保护气体:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.12	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	≤ 0.75
MIG 例值	0.027	2.28	0.53	23.62	13.75	0.026
TIG 例值	0.043	1.75	0.46	23.62	12.54	0.026

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 550	-	≥ 30
MIG 例值	630	465	38
TIG 例值	600	450	38

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-309 · BCT-309

Product Description:

- BCM-309 is a MIG welding wire for stainless steel, used in petrochemical equipment, pressure vessels, power plant construction, food machinery, and for welding dissimilar joints between Cr-Ni or Cr-Ni-Mo stainless steels and carbon steels.
- BCT-309 is a TIG welding wire for stainless steel whose weld metal exhibits good mechanical properties and crack resistance.

Compliant with standards:

- GB/T 29713 S309·YB/T 5092 H10Cr24Ni13·AWS A5.9 ER309
- ISO 14343-B-SS309

Protective gas:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.12	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	≤ 0.75
MIG Example Value	0.027	2.28	0.53	23.62	13.75	0.026
TIG Example Value	0.043	1.75	0.46	23.62	12.54	0.026

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 550	-	≥ 30
MIG Example Value	630	465	38
TIG Example Value	600	450	38

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-309L·BCT-309L

产品说明:

- BCM-309L 为不锈钢用 MIG 焊丝, 应用于石化设备、压力容器、电站建设、食品机械, 铬镍、铬镍钼不锈钢与碳钢异种钢焊接。
- BCT-309 为不锈钢用 TIG 焊丝, 适于焊接 309S 不锈钢, 也用于不锈钢与碳钢间的异种钢过渡焊接。

符合标准:

- AWS A5.9 ER309L

保护气体:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	≤ 0.75
MIG 例值	0.011	2.31	0.588	23.32	13.96	0.026
TIG 例值	0.025	2.22	0.58	23.32	13.66	0.026

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 520	-	≥ 30
MIG 例值	650	435	39.5
TIG 例值	595	445	39

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-309L·BCT-309L

Product Description:

- BCM-309L is a MIG welding wire for stainless steel, used in petrochemical equipment, pressure vessels, power station construction, and food machinery. It is suitable for welding Cr-Ni and Cr-Ni-Mo stainless steels, as well as dissimilar joints between stainless steel and carbon steel.
- BCT-309 is a TIG welding wire for stainless steel, suitable for welding 309S stainless steel. It is also used for transition welding between stainless steel and carbon steel.

Compliant with standards:

- AWS A5.9 ER309L

Protective gas:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.30-0.65	23.0-25.0	12.0-14.0	≤ 0.75
MIG Example Value	0.011	2.31	0.588	23.32	13.96	0.026
TIG Example Value	0.025	2.22	0.58	23.32	13.66	0.026

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 520	-	≥ 30
MIG Example Value	650	435	39.5
TIG Example Value	595	445	39

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-309LSi · BCT-309LSi

产品说明:

- 309LSi 为不锈钢 MIG/TIG 焊丝, 应用于石化设备, 压力容器, 电站建设, 食品机械, 铬镍、铬镍钼不锈钢与碳钢、异种钢焊接。

符合标准:

- AWS A5.9 ER309LSi

保护气体:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.65-1.00	23.0-25.0	12.0-14.0	≤ 0.75
MIG 例值	0.011	1.75	0.86	23.07	13.5	0.017
TIG 例值	0.019	1.75	0.86	23.62	13.5	0.017

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 520	-	≥ 30
MIG 例值	600	430	43
TIG 例值	610	450	40

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-309LSi · BCT-309LSi

Product Description:

- 309LSi is a stainless steel MIG/TIG welding wire used in petrochemical equipment, pressure vessels, power station construction, and food machinery. It is suitable for welding Cr-Ni and Cr-Ni-Mo stainless steels, as well as dissimilar joints between stainless steel and carbon steel.

Compliant with standards:

- AWS A5.9 ER309LSi

Protective gas:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.65-1.00	23.0-25.0	12.0-14.0	≤ 0.75
MIG Example Value	0.011	1.75	0.86	23.07	13.5	0.017
TIG Example Value	0.019	1.75	0.86	23.62	13.5	0.017

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 520	-	≥ 30
MIG Example Value	600	430	43
TIG Example Value	610	450	40

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-310·BCT-310

产品说明:

- 310 为不锈钢 MIG/TIG 焊丝，奥氏体型 / 高温钢用，熔敷金属具有良好的机械性能，耐高温性能稳定，可达 1200°C；送丝顺畅、电弧稳定、成型美观、铁水流动性好，飞溅少，具有优良的焊接工艺性能。
- 常应用于耐高温产品如高温炉、煤炭焦化设备等，也可用于异种材料的焊接。

符合标准:

- AWS A5.9 ER310·ISO14343- B -SS310

保护气体:

- MIG: 98%Ar+2% O₂
- TIG: Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
标准值	0.08-0.15	1-2.5	0.3-0.65	25-28	20-22.5	0.75	0.03	0.03	0.75
MIG 例值	0.102	2.11	0.39	25.76	20.52	0.07	0.011	0.009	0.09
TIG 例值	0.11	2.1	0.41	25.59	20.9	0.05	0.016	0.009	0.09

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	-	-	-
MIG 例值	630	-	34
TIG 例值	595	-	36

参考电流: (MIG: DC⁺/TIG: DC⁻)

焊丝直径 (mm)	0.8	1.0	1.2
焊接电流 (A)	70-150	100-200	140-220
	50-120	80-150	120-180

Stainless Steel Solid Wire

BCM-310·BCT-310

Product Description:

- 310 is a stainless steel MIG/TIG welding wire designed for austenitic and high-temperature steels. The deposited metal exhibits excellent mechanical properties and stable high-temperature resistance up to 1200°C. It features smooth wire feeding, a stable arc, beautiful weld bead appearance, good molten pool fluidity, and minimal spatter, providing superior welding process performance.
- It is commonly used in high-temperature applications such as heat-resistant furnaces and coal coking equipment, as well as for welding dissimilar materials.

Compliant with standards:

- AWS A5.9 ER310·ISO14343- B -SS310

Protective gas:

- MIG: 98%Ar+2% O₂
- TIG: Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
Standard Value	0.08-0.15	1-2.5	0.3-0.65	25-28	20-22.5	0.75	0.03	0.03	0.75
MIG Example Value	0.102	2.11	0.39	25.76	20.52	0.07	0.011	0.009	0.09
TIG Example Value	0.11	2.1	0.41	25.59	20.9	0.05	0.016	0.009	0.09

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	-	-	-
MIG Example Value	630	-	34
TIG Example Value	595	-	36

Reference current: (MIG: DC⁺/TIG: DC⁻)

	Diameter (mm)	0.8	1.0	1.2
Electric Current (A)	flat/horizontal welding	70-150	100-200	140-220
	vertical/overhead welding	50-120	80-150	120-180

不锈钢实心焊丝

BCM-316 · BCT-316

产品说明:

- 316 为不锈钢用 MIG/TIG 焊丝, 应用于化工机械、压力容器、电站建设、食品机械、造船和海洋工程。

符合标准:

- AWS A5.9 ER316

保护气体:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.08	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0
MIG 例值	0.05	1.78	0.36	19.6	12.5	2.5
TIG 例值	0.03	1.78	0.39	18.6	12.5	2.25

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 520	-	≥ 30
MIG 例值	580	-	38
TIG 例值	590	460	38

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-316 · BCT-316

Product Description:

- 316 is a stainless steel MIG/TIG welding wire used in chemical machinery, pressure vessels, power station construction, food machinery, shipbuilding, and offshore engineering.

Compliant with standards:

- AWS A5.9 ER316

Protective gas:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.08	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0
MIG Example Value	0.05	1.78	0.36	19.6	12.5	2.5
TIG Example Value	0.03	1.78	0.39	18.6	12.5	2.25

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 520	-	≥ 30
MIG Example Value	580	-	38
TIG Example Value	590	460	38

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-316L·BCT-316L

产品说明:

- BCM-316L 为不锈钢用 MIG 焊丝, 应用于化工机械、压力容器、电站建设、食品机械、造船和海洋工程。
- BCT-316L 为不锈钢用 TIG 焊丝, 该产品适于焊接 19%Cr-13%Ni-2%Mo 或相近合金系不锈钢, 如 :ASTM316L, 316LN。

符合标准:

- AWS A5.9 ER316L

保护气体

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0
MIG 例值	0.028	2.12	0.54	18.9	12	2.16
TIG 例值	0.022	1.97	0.54	18.9	12	2.16

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 490	-	≥ 30
MIG 例值	585	458	45.5
TIG 例值	570	455	38

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-316L·BCT-316L

Product Description:

- BCM-316L is a MIG welding wire for stainless steel, used in chemical machinery, pressure vessels, power station construction, food machinery, shipbuilding, and offshore engineering.
- BCT-316L is a TIG welding wire for stainless steel. It is suitable for welding 19%Cr-13%Ni-2%Mo stainless steels or similar alloy systems, such as ASTM 316L and 316LN.

Compliant with standards:

- AWS A5.9 ER316L

Protective gas:

- MIG: Ar/(1%-5%) CO₂,Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.30-0.65	18.0-20.0	11.0-14.0	2.0-3.0
MIG Example Value	0.028	2.12	0.54	18.9	12	2.16
TIG Example Value	0.022	1.97	0.54	18.9	12	2.16

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 490	-	≥ 30
MIG Example Value	585	458	45.5
TIG Example Value	570	455	38

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-316LSi · BCT-316LSi

产品说明:

- BCM-316LSi 为不锈钢 MIG 焊丝, 应用于化工机械, 电站建设, 食品机械, 造船和海洋工程。
- BCT-316LSi 为不锈钢 TIG 焊丝, 应用于焊接 316 系列不锈钢, 应用于化工机械, 压力容器, 电站建设, 食品机械, 造船和海洋工程。

符合标准:

- AWS A5.9 ER316LSi

保护气体:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo
标准值	≤ 0.03	1.0-2.5	0.65-1	18.0-20.0	11.0-14.0	2.0-3.0
MIG 例值	0.028	2.05	0.83	18.6	12.9	2.17
TIG 例值	0.019	2.16	0.89	19.25	12.71	2.18

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)
标准值	≥ 490	-	≥ 30
MIG 例值	575	414	40
TIG 例值	600	460	38

MIG 参考电流: (DC⁺)

焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
焊接电压 (V)	19-25	19-28	20-28	22-30	23-30
焊接电流 (A)	65-150	70-200	80-220	100-280	200-300

TIG 参考电流: (DC⁻)

焊丝直径 (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
焊接电流 (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

Stainless Steel Solid Wire

BCM-316LSi · BCT-316LSi

Product Description:

- BCM-316LSi is a stainless steel MIG welding wire used in chemical machinery, power station construction, food machinery, shipbuilding, and offshore engineering.
- BCT-316LSi is a stainless steel TIG welding wire suitable for welding 316 series stainless steels. It is used in chemical machinery, pressure vessels, power station construction, food machinery, shipbuilding, and offshore engineering.

Compliant with standards:

- AWS A5.9 ER316LSi

Protective gas:

- MIG: Ar/(1%-5%) CO₂, Ar/(1%-2%) O₂
- TIG: 100%Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo
Standard Value	≤ 0.03	1.0-2.5	0.65-1	18.0-20.0	11.0-14.0	2.0-3.0
MIG Example Value	0.028	2.05	0.83	18.6	12.9	2.17
TIG Example Value	0.019	2.16	0.89	19.25	12.71	2.18

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)
Standard Value	≥ 490	-	≥ 30
MIG Example Value	575	414	40
TIG Example Value	600	460	38

MIG Reference current: (DC⁺)

Diameter (mm)	0.8	0.9	1.0	1.2	1.6
Welding Voltage (V)	19-25	19-28	20-28	22-30	23-30
Electric Current (A)	65-150	70-200	80-220	100-280	200-300

TIG Reference current: (DC⁻)

Diameter (mm)	0.9	1.0	1.2	1.6	2.0	2.4	3.2	4.0
Electric Current (A)	70-120	80-140	100-160	120-180	140-200	160-220	200-260	220-280

不锈钢实心焊丝

BCM-2209·BCT-2209

产品说明:

- 2209 为奥氏体 - 铁素体双相型不锈钢 MIG/TIG 焊丝，主要成分是 22%Cr-9%Ni-3%Mo-N; 熔敷金属含有 40% 左右的铁素体，兼有奥氏体和铁素体不锈钢的综合性能，耐点蚀和应力腐蚀性能优异；电弧稳定、成型美观、铁水流动性好，具有优良的焊接工艺性能。
- 适用于石油化工行业对应钢材 00Cr22Ni5Mo3N(SUS2205) 等含 22%Cr 双相不锈钢的焊接。

符合标准:

- AWS A5.9 ER2209·ISO 14343-B-SS2209

保护气体:

- MIG: 98%Ar+2%O₂
- TIG: Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	C	Mn	Si	Cr	Ni	Mo	N	P	S	Cu
标准值	0.03	0.5-2.0	0.9	21.5-23.5	7.5-9.5	2.5-3.5	0.08-0.2	0.03	0.03	0.75
MIG 例值	0.016	1.85	0.51	22.59	8.72	3.02	0.16	0.023	0.012	0.10
TIG 例值	0.075	4.50	0.43	20.02	9.52	0.97	0.18	0.018	0.013	0.14

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	断后伸长率 A(%)	CVN 冲击韧性 (J)-40°C
MIG 例值	795	-	33	95
TIG 例值	805	715	30	129

参考电流: (MIG: DC⁺/TIG: DC⁻)

焊丝直径 (mm)		0.8	1.0	1.2
焊接电流 (A)	平 / 横焊	70-150	100-200	140-220
	立 / 仰焊	50-120	80-150	120-180

Stainless Steel Solid Wire

BCM-2209·BCT-2209

Product Description:

- 2209 is an austenitic-ferritic duplex stainless steel MIG/TIG wire with a nominal composition of 22%Cr-9%Ni-3%Mo-N. The deposit contains approximately 40% ferrite, offering a combination of austenitic and ferritic properties with excellent resistance to pitting and stress corrosion. It features a stable arc, good bead appearance, and smooth weld pool fluidity.
- Ideal for welding 22%Cr duplex stainless steels such as 00Cr22Ni5Mo3N (SUS2205) in the petrochemical industry.

Compliant with standards:

- AWS A5.9 ER2209·ISO 14343-B-SS2209

Protective gas:

- MIG: 98%Ar+2%O₂
- TIG: Ar

Welding position:

- all-position welding

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	Cr	Ni	Mo	N	P	S	Cu
Standard Value	0.03	0.5-2.0	0.9	21.5-23.5	7.5-9.5	2.5-3.5	0.08-0.2	0.03	0.03	0.75
MIG Example Value	0.016	1.85	0.51	22.59	8.72	3.02	0.16	0.023	0.012	0.10
TIG Example Value	0.075	4.50	0.43	20.02	9.52	0.97	0.18	0.018	0.013	0.14

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	CVN Impact Toughness (J)-40°C
MIG Example Value	795	-	33	95
TIG Example Value	805	715	30	129

Reference current: (MIG: DC⁺/TIG: DC⁻)

Diameter (mm)		0.8	1.0	1.2
Electric Current (A)	flat/horizontal welding	70-150	100-200	140-220
	vertical/overhead welding	50-120	80-150	120-180

BC-H08A

产品说明:

- BC-H08A 是镀铜低碳低锰焊丝，配合焊接 HJ431 进行埋弧自动焊，焊缝金属具有了、优良的力学性能，对母材上锈迹不敏感，焊接工艺性良好，脱渣容易，电弧燃烧稳定。单、双极，交、直流焊剂均可。
- 可焊接碳钢 (Q235、Q195 等) 和强度级别较低的合金钢如 09Mn2、16MnCu 等。

符合标准:

- GB/T5293 SU08A SU08E·GB/T 14957 H08A
- AWS A5.17 EL12/EL8·ISO 14171-B-SU11·ISO 14171-A-S1

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Cr	Ni	Cu
标准值	≤ 0.10	0.40-0.65	≤ 0.03	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
例值	0.07	0.45	0.02	0.012	0.024	0.013	0.009	0.19

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL/Rp0.2 (MPa)	伸长率 A(%)	-20°C冲击值 KV ₂ /J	焊剂
标准值	430-600	≥ 330	≥ 20	≥ 27	HJ431
例值	440	395	29	70	

BC-H08A

Product Description:

- BC-H08A is a copper-plated low-carbon and low-manganese welding wire. When used with the welding flux HJ431 for submerged arc automatic welding, the weld metal exhibits excellent mechanical properties. It is not sensitive to rust on the base metal, features good welding processability, easy slag detachment, and stable arc combustion. It can be used with single-pole or double-pole, alternating current or direct current welding fluxes.
- It can weld carbon steels (such as Q235, Q195, etc.) and low-strength alloy steels such as 09Mn2, 16MnCu, etc.

Compliant with standards:

- GB/T5293 SU08A SU08E·GB/T 14957 H08A
- AWS A5.17 EL12/EL8·ISO 14171-B-SU11·ISO 14171-A-S1

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cr	Ni	Cu
standard value	≤ 0.10	0.40-0.65	≤ 0.03	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
Example Value	0.07	0.45	0.02	0.012	0.024	0.013	0.009	0.19

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -20°C	Flux
standard value	430-600	≥ 330	≥ 20	≥ 27	HJ431
Example Value	440	395	29	70	

BC-H08MnA

产品说明:

- BC-H08MnA 是镀铜中锰低硅型埋弧焊丝，与焊剂 SJ101 配合焊接形成的焊缝金属具有优良的力学性能。
- 配合焊剂 SJ101 用于碳钢和相应强度较低的合金钢如 Q235 等的焊接。

符合标准:

- GB/T 5293 SU26·GB/T 14957 H08MnA·AWS A5.17 EM12
- ISO 14171-B-SU22·ISO 14171-A-S2

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Cr	Ni	Cu
标准值	≤ 0.10	0.80-1.10	≤ 0.07	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
例值	0.08	0.90	0.05	0.013	0.012	0.038	0.021	0.19

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL/Rp0.2 (MPa)	伸长率 A(%)	-20°C冲击值 KV ₂ /J	焊剂
标准值	430-600	≥ 330	≥ 20	≥ 27	SJ101
例值	463	395	27	75	

Submerged Arc Welding Wire

BC-H08MnA

Product Description:

- BC-H08MnA is a copper-plated medium-manganese and low-silicon submerged arc welding wire. When used in conjunction with the welding flux SJ101, the resulting weld metal exhibits excellent mechanical properties.
- Used together with the welding flux SJ101 for welding carbon steel and low-strength alloy steel with corresponding strength such as Q235, etc.

Compliant with standards:

- GB/T 5293 SU26·GB/T 14957 H08MnA·AWS A5.17 EM12
- ISO 14171-B-SU22·ISO 14171-A-S2

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cr	Ni	Cu
standard value	≤ 0.10	0.80-1.10	≤ 0.07	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
Example Value	0.08	0.90	0.05	0.013	0.012	0.038	0.021	0.19

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -20°C	Flux
standard value	430-600	≥ 330	≥ 20	≥ 27	SJ101
Example Value	463	395	27	75	

BC-H10Mn2

产品说明:

- BC-H10Mn2 是镀铜高锰埋弧焊丝，与 SJ101 焊剂配合，焊接工艺性能优良，焊道成形美观，脱渣容易，具有较好的低温冲击韧性。
- 用于如船舶、石油化工、锅炉等相应强度级别相当的碳钢、低合金钢埋弧自动焊接。

符合标准:

- GB/T 5293 SU34·GB/T 14957 H10Mn2·AWS A5.17 EH14/EL8
- ISO 14171-B-SU33·ISO 14171-A-S4·JIS Z 3351 YS-S6

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Cr	Ni	Cu
标准值	≤ 0.12	1.50-1.90	≤ 0.07	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
例值	0.08	1.65	0.04	0.014	0.013	0.034	0.02	0.19

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL / Rp0.2 (MPa)	伸长率 A(%)	-20°C冲击值 KV ₂ /J	焊剂
标准值	490-670	≥ 390	≥ 18	≥ 27	SJ101
例值	525	430	29	83	

Submerged Arc Welding Wire

BC-H10Mn2

Product Description:

- BC-H10Mn2 is a copper-plated high-manganese submerged arc welding wire. When used in combination with the SJ101 welding flux, it offers excellent welding process performance, aesthetically pleasing weld bead formation, easy slag removal, and good low-temperature impact toughness.
- It is used for submerged arc automatic welding of carbon steel and low-alloy steel with corresponding strength levels, such as those in ships, petrochemical industry, boilers, etc.

Compliant with standards:

- GB/T 5293 SU34·GB/T 14957 H10Mn2·AWS A5.17 EH14/EL8
- ISO 14171-B-SU33·ISO 14171-A-S4·JIS Z 3351 YS-S6

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cr	Ni	Cu
standard value	≤ 0.12	1.50-1.90	≤ 0.07	≤ 0.030	≤ 0.030	≤ 0.20	≤ 0.30	≤ 0.35
Example Value	0.08	1.65	0.04	0.014	0.013	0.034	0.02	0.19

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -20°C	Flux
standard value	490-670	≥ 390	≥ 18	≥ 27	SJ101
Example Value	525	430	29	83	

BC-EM12K

产品说明:

- BC-EM12K 与烧结焊剂 SJ101 配合，电弧燃烧稳定、焊道成形美观、脱渣容易，焊缝具有较高的低温冲击韧性。
- 用于化工、船舶、锅炉等相应强度级别相当的碳钢、低合金钢埋弧自动焊。

符合标准:

- GB/T 5293 SU21·AWS A5.17 EM12K·ISO 14171-A-S2Si1

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Cu
标准值	0.05-0.15	0.80-1.25	0.10-0.35	≤ 0.030	≤ 0.030	≤ 0.35
例值	0.07	1.06	0.21	0.004	0.008	0.115

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL/ Rp0.2 (MPa)	伸长率 A(%)	-40°C冲击值 KV ₂ /J	焊剂
标准值	430-560	≥ 330	≥ 22	≥ 27	SJ101
例值	492	390	27	90	

BC-EM12K

Product Description:

- When BC-EM12K is used in conjunction with the sintered flux SJ101, it provides a stable arc, aesthetically pleasing weld bead formation, easy slag removal, and welds with high low-temperature impact toughness.
- It is used for submerged arc automatic welding of carbon steel and low-alloy steel with corresponding strength levels in chemical industry, shipbuilding, boiler and other industries.

Compliant with standards:

- GB/T 5293 SU21·AWS A5.17 EM12K·ISO 14171-A-S2Si1

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cu
standard value	0.05-0.15	0.80-1.25	0.10-0.35	≤ 0.030	≤ 0.030	≤ 0.35
Example Value	0.07	1.06	0.21	0.004	0.008	0.115

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -40°C	Flux
standard value	430-560	≥ 330	≥ 22	≥ 27	SJ101
Example Value	492	390	27	90	

BC-H08MnMoA

产品说明:

- BC-H08MnMoA 焊丝是高强度、高韧性埋弧焊丝,与烧结焊剂 SJ101 匹配,熔敷金属具有优良的低温冲击热性和抗裂性。
- 广泛应用于船舶、起重机运输设备、车辆、工程机械等相应强度级别低合金钢的焊接。

符合标准:

- GB/T 5293 SUM3·ISO 14171-B-SU3M3

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ti	Cr	Ni	Mo	Cu
标准值	≤ 0.10	1.20-1.60	≤ 0.25	≤ 0.030	≤ 0.030	0.05-0.15	≤ 0.20	≤ 0.30	0.30-0.50	≤ 0.35
例值	0.067	1.54	0.18	0.012	0.017	0.065	0.032	0.028	0.42	0.114

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL/Rp0.2 (MPa)	伸长率 A(%)	-20°C冲击值 KV ₂ /J	焊剂
标准值	550-740	≥ 470	≥ 17	≥ 27	SJ101
例值	550	485	22	83	

Submerged Arc Welding Wire

BC-H08MnMoA

Product Description:

- BC-H08MnMoA is a high-strength, high-toughness submerged arc welding wire. When matched with sintered flux SJ101, the deposited metal exhibits excellent low-temperature impact toughness and crack resistance.
- It is widely used in the welding of corresponding strength grade low-alloy steels for ships, crane transportation equipment, vehicles, and construction machinery.

Compliant with standards:

- GB/T 5293 SUM3·ISO 14171-B-SU3M3

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ti	Cr	Ni	Mo	Cu
standard value	≤ 0.10	1.20-1.60	≤ 0.25	≤ 0.030	≤ 0.030	0.05-0.15	≤ 0.20	≤ 0.30	0.30-0.50	≤ 0.35
Example Value	0.067	1.54	0.18	0.012	0.017	0.065	0.032	0.028	0.42	0.114

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -20°C	Flux
Example Value	550-740	≥ 470	≥ 17	≥ 27	SJ101
Example Value	550	485	22	83	

BC-13CrMoA

产品说明：

- BC-13CrMoA 是低合金耐热钢用镀铜埋弧焊丝，配合 SJ101 焊剂，具有优良的焊接工艺性能，成型美观，脱渣容易，焊缝具有优良的机械性能。
- 用于焊接工作温度在 520°C 以下的 1%Cr-0.5%Mo 珠光耐热钢，如 15CrMo、12CrMo 等材质的锅炉管道、石化设备等。

符合标准：

- GB/T 12470 SU1CM3

焊丝化学成分（质量分数）：%

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值	0.11-0.16	0.40-0.70	0.15-0.35	≤ 0.030	≤ 0.030	0.80-1.10	≤ 0.30	0.40-0.60	≤ 0.35
例值	0.134	0.57	0.25	0.005	0.012	0.95	0.04	0.49	0.16

熔敷金属力学性能：

	抗拉强度 Rm(MPa)	屈服强度 ReL/Rp0.2 (MPa)	伸长率 A(%)	-40°C冲击值 KV ₂ /J	焊剂
标准值	550-700	≥ 470	≥ 18	≥ 27	SJ101
例值	620	535	27	120	

Submerged Arc Welding Wire

BC-13CrMoA

Product Description:

- BC-13CrMoA is a copper-plated submerged arc welding wire for low-alloy heat-resistant steels. Used in conjunction with SJ101 flux, it exhibits excellent welding process performance, beautiful bead formation, easy slag removal, and the welds have superior mechanical properties.
- It is used for welding 1%Cr-0.5%Mo pearlitic heat-resistant steels with a working temperature below 520° C, such as boiler pipes and petrochemical equipment made of materials like 15CrMo and 12CrMo.

Compliant with standards:

- GB/T 12470 SU1CM3

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
standard value	0.11-0.16	0.40-0.70	0.15-0.35	≤ 0.030	≤ 0.030	0.80-1.10	≤ 0.30	0.40-0.60	≤ 0.35
Example Value	0.134	0.57	0.25	0.005	0.012	0.95	0.04	0.49	0.16

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL/Rp0.2 (MPa)	Elongation A(%)	Impact Value KV ₂ /J -40°C	Flux
standard value	550-700	≥ 470	≥ 18	≥ 27	SJ101
Example Value	620	535	27	120	

BC-1CM

产品说明:

- BC-1CM 是一款低合金耐热钢焊丝，推荐匹配碱性焊剂。
- 用于珠光体耐热钢母材如 ASTM A387Gr.11、Gr.12、JIS SCMV2、3 在高温服役下的应用，广泛应用于石油炼化装置，锅炉受压元件及压力容器等行业。

符合标准:

- AWS A5.23:EB2*(接近)

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti	Al
例值	0.075	1.34	0.79	0.003	0.011	0.022	1.09	0.52	0.09	0.004	0.002

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	室温冲击值 KV ₂ /J	焊后热处理	焊剂
例值	655	570	26	98	690°C *1h	SJ101

参考电流: (AC 或 DC⁺)

焊丝直径	2.0	2.4	3.2	4.0	4.8
焊接电流 (A)	300-400	350-450	425-525	475-575	525-625
焊接电压 (V)	26-29	27-30	27-30	27-30	27-30
干伸长度 (mm)	13-19	19-32	25-38	25-38	25-38
焊接速度 (mm/s)	5-6	5.5-6.5	6-7	6.5-7.5	6.5-7.5

BC-1CM

Product Description:

- BC-1CM is a low-alloy heat-resistant steel welding wire, and it is recommended to be matched with alkaline flux.
- It is used for the application of pearlitic heat-resistant steel base metals such as ASTM A387 Gr.11, Gr.12 and JIS SCMV2, SCMV3 under high-temperature service conditions, and is widely applied in industries such as petroleum refining units, boiler pressure components and pressure vessels.

Compliant with standards:

- AWS A5.23:EB2*(接近)

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu	Ti	Al
Example Value	0.075	1.34	0.79	0.003	0.011	0.022	1.09	0.52	0.09	0.004	0.002

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	Room-temperature impact value KV ₂ /J	Post-weld heat treatment	Flux
Example Value	655	570	26	98	690°C *1h	SJ101

Reference current: (AC or DC⁺)

Wire diameter	2.0	2.4	3.2	4.0	4.8
Welding current (A)	300-400	350-450	425-525	475-575	525-625
Welding voltage (V)	26-29	27-30	27-30	27-30	27-30
Stick-out length (mm)	13-19	19-32	25-38	25-38	25-38
Welding speed (mm/s)	5-6	5.5-6.5	6-7	6.5-7.5	6.5-7.5

BC-2CM

产品说明:

- BC-2CM 是一款低合金耐热钢焊丝，推荐匹配碱性焊剂。
- 用于珠光体耐热钢母材，如 ASTM A387Gr.22、JIS SCMV4 在高温服役下的应用，广泛应用于石油炼化装置，锅炉受压元件及压力容器等行业。

符合标准:

- AWS A5.23:EB3*(接近)

焊丝化学成分 (质量分数) : %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu
例值	0.09	1.15	0.48	0.011	0.013	0.035	2.37	0.96	0.1

熔敷金属力学性能:

	抗拉强度 Rm(MPa)	屈服强度 ReL (MPa)	伸长率 A(%)	室温冲击值 KV ₂ /J	焊后热处理	焊剂
例值	660	580	26	88	690°C *1h	SJ101

参考电流: (AC 或 DC⁺)

焊丝直径	2.0	2.4	3.2	4.0	4.8
焊接电流 (A)	300-400	350-450	425-525	475-575	525-625
焊接电压 (V)	26-29	27-30	27-30	27-30	27-30
干伸长度 (mm)	13-19	19-32	25-38	25-38	25-38
焊接速度 (mm/s)	5-6	5.5-6.5	6-7	6.5-7.5	6.5-7.5

BC-2CM

Product Description:

- BC-2CM is a low-alloy heat-resistant steel welding wire, and alkaline flux is recommended for matching.
- It is used for pearlitic heat-resistant steel base metals such as ASTM A387 Gr.22 and JIS SCMV4 under high-temperature service conditions, and is widely applied in industries such as petroleum refining units, boiler pressure components, and pressure vessels.

Compliant with standards:

- AWS A5.23:EB3*(接近)

Welding wire chemical composition (mass fraction): %

	C	Mn	Si	S	P	Ni	Cr	Mo	Cu
Example Value	0.09	1.15	0.48	0.011	0.013	0.035	2.37	0.96	0.1

Mechanical Properties of Deposited Metal:

	Tensile Strength Rm(MPa)	Yield Strength ReL (MPa)	Elongation A(%)	Room-temperature impact value KV ₂ /J	Post-weld heat treatment	Flux
Example Value	660	580	26	88	690°C *1h	SJ101

Reference current: (AC or DC⁺)

Wire diameter	2.0	2.4	3.2	4.0	4.8
Welding current (A)	300-400	350-450	425-525	475-575	525-625
Welding voltage (V)	26-29	27-30	27-30	27-30	27-30
Stick-out length (mm)	13-19	19-32	25-38	25-38	25-38
Welding speed (mm/s)	5-6	5.5-6.5	6-7	6.5-7.5	6.5-7.5

BC-SJ101

产品说明：

- 碱度值：1.6；
- 颗粒度：10-40 目、12-60 目；
- 松装比：1.2g/cm³；
- 可用于多层、双面单道焊。90 度夹角有较好的脱渣性、焊缝成型过渡良好。适用与钢结构：轻钢（H 型）、重钢（H 型、箱型）、管道、船舶、螺旋 / 直缝管道。

符合标准：

- GB/T 5293-2018 S43A2FB-SU26 S49A4FB-SU34
- AWS A5.17M F7A2-EM12 F7A4-EH14

熔敷金属力学性能：

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性	
				-20°C (J)	-40°C (J)
SU26	500	390	32	120	/
SU34	530	420	29	/	80

BC-SJ101

Product Description:

- Basicity Index: 1.6,
- Grain size: 10-40 mesh, 12-60 mesh;
- Density: 1.2g/cm³;
- It can be used for multi-layer, double-sided single-pass welding. It has good slag removal and great weld bead forming transition under the included Angle of 90 degrees. It is suitable for steel structure: light steel(H type), heavy steel (H type, box type), pipeline, ship, spiral pipe/straight seam pipeline.

Compliant with standards:

- GB/T 5293-2018 S43A2FB-SU26 S49A4FB-SU34
- AWS A5.17M F7A2-EM12 F7A4-EH14

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch	
				-20°C (J)	-40°C (J)
SU26	500	390	32	120	/
SU34	530	420	29	/	80

BC-SJ101Q

产品说明：

- 碱度 2.4;
- 颗粒度：10-40 目；
- 松装比：1.3g/cm³；
- 桥梁专用焊剂。有一定的强度、韧性和良好的抗疲劳性能。在风塔行业中对强度和韧性有较高要求的，此焊剂可匹配使用。

符合标准：

- GB/T 5293-2018 S49A4UFB-SU34 A55A4UFB-SU4M1
- AWS A5.17M F7A4-EH14 · AWS A5.23M F8A4-EA3

熔敷金属力学性能：

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -40°C (J)
SU34	545	435	29	120
SU4M1	585	475	27	135

BC-SJ101Q

Product Description:

- Basicity Index: 2.4,
- Grain size: 10-40 mesh,
- Density: 1.3g/cm³;
- The flux is specialized for bridges and it has certain strength,toughness and good anti-fatigue performance. This flux can be applied in the wind tower industry which has higher requirements on strength and toughness.

Compliant with standards:

- GB/T 5293-2018 S49A4UFB-SU34 A55A4UFB-SU4M1
- AWS A5.17M F7A4-EH14 · AWS A5.23M F8A4-EA3

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -40°C (J)
SU34	545	435	29	120
SU4M1	585	475	27	135

BC-SJ101G

产品说明:

- 碱度值: 1.8;
- 颗粒度: 10-40 目、12-60 目;
- 松装比: 1.25g/cm³;
- 该焊剂属碱性、冶金中性、焊缝基本不增加 Si 和 Mn, 在高热输入焊接条件下, 具有良好的冲击韧性。应用于单丝或双丝焊接。具有优良的焊接工艺性能, 易脱渣, 焊缝成型美观。X70 以下的双丝管道应用, 重型钢结构的双丝应用。

符合标准:

- GB/T 5293-2018 S49A4UFB-SU34
- GB/T 12470-2018 S55A4UFB-SU1CM2
- AWS A5.17 F7A4-EH14 · AWS A5.23 F8A4-EB2 · NB47018-2018

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -40°C (J)
SU34	540	430	29	105
SU1CM2	565	455	28	95

BC-SJ101G

Product Description:

- Basicity Index: 1.8,
- Grain size: 10-40 mesh, 12-60 mesh;
- Density: 1.25g/cm³;
- The flux is alkaline flux, which belongs to the metallurgy neutral. It hardly increases Si and Mn on weld bead and it has good impact toughness under high heat input welding condition. It is used for single or double wire welding. The flux has excellent welding performance, slag removal and bead appearance. This product is suitable for the double wire welding of pipeline below grade X70 and heavy steel structure.

Compliant with standards:

- GB/T 5293-2018 S49A4UFB-SU34
- GB/T 12470-2018 S55A4UFB-SU1CM2
- AWS A5.17 F7A4-EH14 · AWS A5.23 F8A4-EB2 · NB47018-2018

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -40°C (J)
SU34	540	430	29	105
SU1CM2	565	455	28	95

BC-SJ301

产品说明:

- 碱度值: 1.1;
- 颗粒度: 8-40 目、10-40 目;
- 松装比: 1.2g/cm³;
- 适用于单道快速环缝焊接, 广泛应用于 Q235 级普碳钢焊接, 配合 SU08、ER50-6 焊接 A、B 级管线钢。配合 SU08、Su26 使用于钢结构焊接。

符合标准:

- GB/T 5293-2018 S39A0SC-SU08 S43A2SC-SU26

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性	
				-0°C (J)	-20°C (J)
H08A	435	350	30	75	/
H08MnA	485	405	29	/	85

BC-SJ301

Product Description:

- Basicity Index: 1.1,
- Grain size: 8-40 mesh、10-40 mesh,
- Density: 1.2g/cm³; It is particularly suited for circumferential joint welding and it is widely applied in the welding of grade Q235 mild steel. With SU08、ER50-6, it can be used for the welding of pipeline steel of Grade A and B. With SU08 and SU26, it can also be used for the welding of steel structure.

Compliant with standards:

- GB/T 5293-2018 S39A0SC-SU08 S43A2SC-SU26

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch	
				-0°C (J)	-20°C (J)
H08A	435	350	30	75	/
H08MnA	485	405	29	/	85

BC-SJ201

产品说明:

- SJ201 是铝钙型烧结焊剂，呈黑灰色球形颗粒。
- 碱度值：1.4；
- 颗粒度：12-60 目；
- 松装比：1.35g/cm³；
- 直流焊接时，焊丝接正极。采用该焊剂施焊时，向焊缝中稍有增硅，但增 Mn 明显，电弧稳定，成型美观，具有优良的脱渣性，焊缝金属具有较高的冲击韧性。
- 配合适当的焊丝，可焊接普通的锅炉钢、压力容器用钢等，也可用于角缝焊接，特别适合焊接厚板窄坡口、窄间隙等结构。

符合标准:

- GB/T 5293-2018 S49A2UAB-SU28 S49A4UAB-SU34
- AWS A5.17M F7A2-EM12 F7A4-EH14

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性	
				-20°C (J)	-40°C (J)
SU28	520	435	32	105	/
SU34	525	415	29	/	85

BC-SJ201

Product Description:

- SJ201 is an aluminum-calcium agglomerated flux. The flux is black and gray spherical particles.
- Basicity Index: 1.4,
- Grain size: 12-60 mesh ;
- Density: 1.35g/cm³;
- In DC welding, the welding wire is connected to the positive electrode. There is slightly increase of Si and obvious increase of Mn to the weld bead.
- It has stable arc, excellent weld bead appearance, good slag removal and high impact toughness. With appropriate wires, it can be used for the welding of boiler steel, pressure vessel steel etc. It can also be used in fillet welding and it is especially suitable for the welding of structures with thick plate, narrow groove and narrow gap.

Compliant with standards:

- GB/T 5293-2018 S49A2UAB-SU28 S49A4UAB-SU34
- AWS A5.17M F7A2-EM12 F7A4-EH14

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch	
				-20°C (J)	-40°C (J)
SU28	520	435	32	105	/
SU34	525	415	29	/	85

BC-SJ501

产品说明:

- 碱度值: 1.1;
- 颗粒度: 12-60 目;
- 松装比: 1.4g/cm³;
- 电流极性: 直流反接或交流;
- 该焊剂为酸性焊剂, 向焊缝中过渡 Si 和 Mn, 对少量的铁锈及氧化皮不敏感, 抗气孔能力强, 特别适合于焊前不严格清理母材的场合。
- 焊缝成型美观, 脱渣性能优异, 特别适用于双丝及多丝角焊缝的高速焊接。
- 具有优异的焊接性能, 电弧燃烧稳定, 最大焊接电流可达 1000A 配合适当的焊丝可焊接低碳钢、低合金钢及耐热钢, 用于船舶、锅炉压力容器的焊接。

符合标准:

- GB/T 5293-2018 S43A0AR-SU08 S49A3AR-SU26
- AWS A5.17M F6A0-EL8 F7A2-EM12K

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性	
				-20°C (J)	-29°C (J)
SU26	465	375	32	120	/
EM12K	545	435	30	/	105

BC-SJ501

Product Description:

- Basicity Index: 1.1;
- Particle Size: 12-60 mesh;
- Apparent Density: 1.4g/cm³;
- Current Polarity: DCEN (Direct Current Electrode Negative) or AC;
- This flux is an acidic type that transfers Si and Mn into the weld metal. It is insensitive to minor surface rust and scale, offering strong resistance to porosity. It is particularly suitable for applications where strict cleaning of the base metal prior to welding is not feasible.
- The weld bead appearance is aesthetically pleasing with excellent slag detachability. It is especially designed for high-speed welding of fillet joints using tandem or multi-wire systems.
- Featuring excellent welding performance and a stable arc, it can operate at a maximum current of 1000A. When combined with appropriate welding wires, it is suitable for welding carbon steel, low-alloy steel, and heat-resistant steel. Typical applications include shipbuilding, boilers, and pressure vessel manufacturing.

Compliant with standards:

- GB/T 5293-2018 S43A0AR-SU08 S49A3AR-SU26
- AWS A5.17M F6A0-EL8 F7A2-EM12K

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch	
				-20°C (J)	-29°C (J)
SU26	465	375	32	120	/
EM12K	545	435	30	/	105

BC-SJ414N**产品说明:**

- SJ414N 是高碱度惰性烧结焊剂，灰白色圆形颗粒，
- 碱度值：2.8-3.0；
- 颗粒度：10-60 目；
- 直流反接，配合 414、414N 焊丝，焊接工艺良好，焊缝成型美观，表面光滑，具有优良的高温脱渣性能及力学性能和低温冲击韧性。
- 用于多道焊接，配用碳钢、低合金钢、奥氏体不锈钢、马氏体不锈钢焊丝使用。配用相应堆焊焊丝进行堆焊，堆焊层具有较好抗高温氧化性综合性能。

符合标准:

- GB/T17854 F308-H0Cr21Ni10 F410-HCr13

BC-SJ414N**Product Description:**

- SJ414N is a high-alkalinity inert sintered flux, gray-white round particles,
- Basicity Index: 2.8-3.0,
- Grain size: 10-60 mesh ;
- DC reverse connection, with 414 and 414N welding wires, has good welding process, beautiful weld forming, smooth surface, excellent high temperature slag removal performance, mechanical properties and low temperature impact toughness.
- It is used for multi-pass welding, with carbon steel, low alloy steel, austenitic stainless steel, martensitic stainless steel welding wire. It is equipped with the corresponding surfacing welding wire for surfacing welding, and the surfacing layer has good comprehensive properties of high temperature oxidation resistance.

Compliant with standards:

- GB/T17854 F308-H0Cr21Ni10 F410-HCr13

BC-SJ102

产品说明:

- SJ102 是高碱度惰性烧结焊剂，灰白色圆形颗粒，
- 碱度值：3.0；
- 颗粒度：10-60 目；
- 焊接工艺良好，焊缝成型美观，表面光滑，具有优良的高温脱渣性能。焊剂中性不向焊缝过渡硅锰。
- 适用于多道焊接，配用碳钢、低合金钢、奥氏体不锈钢、马氏体不锈钢焊丝使用。该焊剂适用于直流反接，其焊缝具有优良的力学性能和低温冲击韧性，配用相应堆焊焊丝进行堆焊，堆焊层具有较好抗高温氧化性综合性能。

符合标准:

- GB/T17854 F308-H0Cr21Ni10 F410-H1Cr13

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性	
				-20°C (J)	-40°C (J)
H08MnMoA	≥ 470	550-700	≥ 22	≥ 34	≥ 27

BC-SJ102

Product Description:

- SJ102 is a high-alkalinity inert sintered flux, gray-white round particles,
- Basicity Index: 3.0,
- Grain size: 10-60 mesh ;
- The welding process is good, the weld forming is beautiful, the surface is smooth, and it has excellent high-temperature slag removal performance. The flux is neutral and does not transition silicon-manganese to the weld.
- It is suitable for multi-pass welding, and is used with carbon steel, low alloy steel, austenitic stainless steel, and martensitic stainless steel welding wire. The flux is suitable for DC reverse connection, and its weld has excellent mechanical properties and low-temperature impact toughness, and the corresponding surfacing welding wire is used for surfacing welding, and the surfacing layer has good comprehensive properties of high temperature oxidation resistance.

Compliant with standards:

- GB/T17854 F308-H0Cr21Ni10 F410-H1Cr13

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch	
				-20°C (J)	-40°C (J)
H08MnMoA	≥ 470	550-700	≥ 22	≥ 34	≥ 27

BC-HJ107

产品说明:

- HJ107 是熔炼型无锰中硅中氟焊剂，为蓝灰色至深灰色浮石状，颗粒度：10-60 目。采用直流电源，焊丝接正极，电弧稳定、脱渣容易、焊缝成型美观，焊接奥氏体不锈钢时，具有增碳少和铬烧损少的特点。
- 配合奥氏体不锈钢焊丝或焊带如 H0Cr21Ni10、H0Cr20Ni10Ti、H00Cr24Ni12Nb、H0Cr16Mn16 等进行堆焊或焊接，可用于石油化工设备耐腐蚀层堆焊和构件的焊接也可用于高锰钢的堆焊或补焊。

符合标准:

- GB/T 17854 SF308AAS-S308 SF308LAAS-S308L

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -196°C (J)
H0Cr21Ni10	585	—	—	55

BC-HJ107

Product Description:

- HJ107 is amanganese-free medium silicon medium fluorine fused flux .It is a blue-gray to dark gray pumice stone particle with a particle size of 10-60 mesh. Fluxes are suitable for use with D.C.power source. Filler-wire or weld strip connected to electrode positive(EP). It features good welding properties, easy slag removal,less carburization and less chromium burning loss when welding to austenitic stainless steel.
- With austenitic stainless steel welding wire or welding tape such as H0Cr21Ni10,H0Cr20Ni10Ti,H00Cr24Ni12Nb,H0Cr16Mn16, etc., it can be used for welding of nuclear containers,petrochemical equipment corrosion resistance layer and components.It can be used for high manganese steel repair welding.

Compliant with standards:

- GB/T 17854 SF308AAS-S308 SF308LAAS-S308L

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -196°C (J)
H0Cr21Ni10	585	—	—	55

BC-HJ260

产品说明:

- HJ260 是熔炼型低锰高硅中氟型焊剂，为灰色玻璃状颗粒，颗粒度：10-60 目。采用直流电源，焊丝接正极，电弧稳定，焊缝成型美观。
- 搭配奥氏体不锈钢焊丝，如 H0Cr21Ni10、H0Cr21Ni10Ti 等，焊接相应的耐酸不锈钢结构，也可配合 1Cr13 用于轧辊堆焊

符合标准:

- GB/T 17854 SF308AAS-S308 SF410AAS-S410

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -196°C (J)
H0Cr21Ni10	620	-	-	60

BC-HJ260

Product Description:

- HJ260 is a fused fluxes with low manganese high silicate and medium fluorine. It is a gray glassy particle with a particle size of 10-60 mesh. Fluxes are suitable for use with DC power, filler-wire will be connected to electrode positive. it provides stable elector-arc, nice weld appearance.
- With austenitic stainless steel welding wire, such as H0Cr21Ni10 H0Cr21Ni10Ti, it can be used for welding of corresponding acid-resistant stainless steel structure, can also be used for roll surfacing welding.

Compliant with standards:

- GB/T 17854 SF308AAS-S308 SF410AAS-S410

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -196°C (J)
H0Cr21Ni10	620	-	-	60

BC-HJ431

产品说明:

- HJ431 是熔炼型高锰高硅低氟焊剂，为棕红色至浅黄色玻璃状颗粒，颗粒度：8-40 目等，可交直流两用，直流焊接时焊丝接正极。焊接工艺性能良好，脱渣容易，成型美观。
- 搭配焊丝 H08A、H08MnA、H10MnSi 等焊丝，可焊接低碳钢及某些低合金钢（如 16Mn、15MnV），适用于锅炉、船舶、压力容器等。

符合标准:

- GB/T 5293 S43A0UMS-Su26

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -20°C (J)
SU26	475	385	28	65

BC-HJ431

Product Description:

- HJ431 is a fused fluxe with high-manganese high silicate and low fluorine elements.It is a brown to light yellow glassy particle with a particle size of 8-40 meshes.It is suitable for use with both AC & DC. When applying D.C. filler wire will be connected to electrode positive(EP).Fluxes have good welding property,easy slag removal and good bead shape.
- With welding wire HO8A,H08MnA,H10MnSi and other welding wire, it can be used forwelding of mild steel and some low alloy steel, such as 16Mn,15MnV. It can be used for welding of boilers, ships,presure vessels and etc.

Compliant with standards:

- GB/T 5293 S43A0UMS-Su26

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -20°C (J)
SU26	475	385	28	65

BC-HJ350

产品说明:

- HJ350 是熔炼型中锰中硅中氟焊剂。为棕色至浅黄色玻璃状颗粒，颗粒度: 8-40 目等。可交直流两用，直流是焊丝接正极。焊接工艺性良好，脱渣容易，成型美观。
- 配合适合焊丝，可焊接低合金钢，如 16Mn、15MnV、15MnVN 等结构，如船舶、锅炉、高压容器等。

符合标准:

- GB/T 5293 S49S2MS-Su34

熔敷金属力学性能:

配合焊丝	抗拉强度 Rm(MPa)	屈服强度 ReL /Rp0.2(MPa)	伸长率 A(%)	V 型缺口冲击韧性 -20°C (J)
SU34	490-670	≥ 390	≥ 18	55

BC-HJ350

Product Description:

- HJ350 is a fused type fluxe with medium-manganese, medium-silicate and medium fluorine elements. It is brown to light yellow glassy partical with a partical size of 8-40mesh.It is suitable for use with both AC & DC. When applying D.C.filler wire will be connected to electrode positive(EP).Fluxes have good welding property,easy slag removal and good bead shape.
- With appropriate welding wire,it can weld low alloy steel,such as 16Mn,15MnV,15MnVN,etc.It is widely used for welding of ships, boilers, high-pressure vessels, etc.

Compliant with standards:

- GB/T 5293 S49S2MS-Su34

Mechanical Properties of Deposited Metal:

Compatible welding wire	Tensile strength Rm(MPa)	Yield strength ReL /Rp0.2(MPa)	Elongation A(%)	Impact toughness of V-notch -20°C (J)
SU34	490-670	≥ 390	≥ 18	55

BCM-AI1070·BCT-AI1070

产品说明：

- AI1070 是纯铝焊丝，Al 含量 $\geq 99.7\%$ ，该焊丝具有优良的焊接工艺性能，焊接成形美观、电弧稳定、飞溅小。具有优越的导电性能、导热性和极好的可加工性能，同时有极好的抗腐蚀性能和抗裂性能。此焊缝在阳极处理后具有很好的颜色配比性。
- 用于电力、化学、食品、冶金和铁路机车等行业相关铝合金的焊接。

符合标准：

- GB/T 10858 SAI 1070(AI99.7)·AWS A5.10 ER1070
- ISO 18273-S AI 1070(AI99.7)

保护气体：

- MIG: 99.99%Ar

焊接位置：

- 全位置

物理性能：

- 熔化温度区间 (°C) : 647-658
- 密度 (g/cm³) : 2.70

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Zn
标准值	≤ 0.20	≤ 0.25	≤ 0.04	≤ 0.03	≤ 0.03	≤ 0.04
例值	0.05	0.07	0.06	0.007	0.005	0.002
	V	Ti	Al	Be	其他元素	
标准值	≤ 0.05	≤ 0.03	≥ 99.70	≤ 0.0003	单个 ≤ 0.03	
例值	0.006	0.008	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	75	30	25

参考电流: (MIG DC⁺ · TIG DC⁻)

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-26	20-28	22-32
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI1070·BCT-AI1070

Product Description:

- AI1070 is a pure aluminum welding wire with an Al content of $\geq 99.7\%$, the welding wire has excellent welding process performance, beautiful welding forming, stable arc and small spatter. It has superior electrical and thermal conductivity and excellent machinability, as well as excellent corrosion and crack resistance. This weld has a very good color ratio after anodizing.
- It is used for the welding of aluminum alloys related to electric power, chemical, food, metallurgy and railway locomotives.

Compliant with standards:

- GB/T 10858 SAI 1070(AI99.7)·AWS A5.10 ER1070
- ISO 18273-S AI 1070(AI99.7)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 647-658
- Density (g/cm³) : 2.70

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Zn
standard value	≤ 0.20	≤ 0.25	≤ 0.04	≤ 0.03	≤ 0.03	≤ 0.04
Example Value	0.05	0.07	0.06	0.007	0.005	0.002
	V	Ti	Al	Be	Other elements	
standard value	≤ 0.05	≤ 0.03	≥ 99.70	≤ 0.0003	Individual ≤ 0.03	
Example Value	0.006	0.008	Allowance	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	75	30	25

Reference current: (MIG DC⁺ · TIG DC⁻)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-26	20-28	22-32
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI1100·BCT-AI1100

产品说明:

- AI1100 是纯铝焊丝, Al 含量 $\geq 99.0\%$, 该焊丝具有优良的焊接工艺性能, 焊接成形美观、电弧稳定、飞溅小。具有优越的导电性能、导热性和极好的可加工性能, 同时有极好的抗腐蚀性能。此焊缝在阳极处理后具有很好的颜色配比性。
- 用于电力、化学、食品、冶金和铁路机车等行业相关铝合金的焊接。

符合标准:

- GB/T 10858 SAI 1100(Al 99.0Cu)·AWS A5.10 ER1100
- ISO 18273-S Al 1100(Al 99.0Cu)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 643-657
- 密度 (g/cm³) : 2.70

焊丝化学成分 (质量分数) : %

	Si+Fe	Cu	Mn	Zn	Al	Be	其他元素
标准值	≤ 0.95	0.05-0.20	≤ 0.05	≤ 0.10	≥ 99.00	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15
例值	0.26	0.080	0.006	0.008	余量	0.0001	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	95	35	24

参考电流: (MIG DC⁺·TIG AC)

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-26	20-28	22-32
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI1100·BCT-AI1100

Product Description:

- AI1100 is a pure aluminum welding wire with an Al content of $\geq 99.0\%$, the welding wire has excellent welding process performance, beautiful welding forming, stable arc and small spatter. It has excellent electrical and thermal conductivity and excellent machinability, as well as excellent corrosion resistance. This weld has a very good color ratio after anodizing.
- It is used for the welding of aluminum alloys related to electric power, chemical, food, metallurgy and railway locomotives.

Compliant with standards:

- GB/T 10858 SAI 1100(Al 99.0Cu)·AWS A5.10 ER1100
- ISO 18273-S Al 1100(Al 99.0Cu)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 643-657
- Density (g/cm³) : 2.70

Welding wire chemical composition (mass fraction): %

	Si+Fe	Cu	Mn	Zn	Al	Be	Other elements
standard value	≤ 0.95	0.05-0.20	≤ 0.05	≤ 0.10	≥ 99.00	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15
Example Value	0.26	0.080	0.006	0.008	Allowance	0.0001	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	95	35	24

Reference current: (MIG DC⁺·TIG AC)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-26	20-28	22-32
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI4043 · BCT-AI4043

产品说明:

- AI4043 是一种含硅量 5% 的铝硅合金焊丝。具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅小。
- 用于船舶、机车、化工、食品、运动器材、模具、家具、容器、集装箱、汽车工业和结构部件等相关铝合金的焊接，如 6xxx 系列铝合金。

符合标准:

- GB/T 10858 SAI 4043(AISi5) · AWS A5.10 ER4043
- ISO 18273-S AI 4043(AISi5)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 573-625
- 密度 (g/cm³) : 2.67

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Zn	Ti	Al	Be	其他元素
标准值	4.5-6.0	≤ 0.80	≤ 0.30	≤ 0.05	≤ 0.05	≤ 0.10	≤ 0.20	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15
例值	5.2	0.15	0.009	0.008	0.006	0.004	0.070	余量	0.0001	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	150	110	14

参考电流: (MIG DC⁺ · TIG AC)

	焊丝直径 (mm)	1.2	1.6	2.0
MIG	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-26	20-28	22-32
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI4043 · BCT-AI4043

Product Description:

- AI4043 is an aluminum-silicon alloy welding wire with 5% silicon content. It has excellent welding process performance, beautiful weld forming, stable arc and small spatter.
- It is used for the welding of ships, locomotives, chemicals, food, sports equipment, molds, furniture, containers, containers, automobile industry and structural components and other related aluminum alloys, such as 6xxx series aluminum alloys.

Compliant with standards:

- GB/T 10858 SAI 4043(AISi5) · AWS A5.10 ER4043
- ISO 18273-S AI 4043(AISi5)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 573-625
- Density (g/cm³) : 2.67

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg
standard value	4.5-6.0	≤ 0.80	≤ 0.30	≤ 0.05	≤ 0.05
Example Value	5.2	0.15	0.009	0.008	0.006
	Zn	Ti	Al	Be	Other elements
standard value	≤ 0.10	≤ 0.20	Allowance	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15
Example Value	0.004	0.070	Allowance	0.0001	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	150	110	14

Reference current: (MIG DC⁺ · TIG AC)

	Wire Diameter (mm)	1.2	1.6	2.0
MIG	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-26	20-28	22-32
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI4047 · BCT-AI4047

产品说明:

- AI4047 是含有 12% 硅的共晶型铝硅焊丝，比 4043 焊丝有更低的熔点和更窄的凝固区间，由于硅含量高，提高了熔池的流动性，降低了凝固收缩，并将热裂倾向降到更低，增加了角焊缝的剪切强度。该焊丝具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅小。
- 用于汽车零部件、车身板件等铝硅、铝镁硅、铝锰、铝硅镁铜系列合金的氩弧焊和钎焊。

符合标准:

- GB/T 10858 SAI 4047(AISi12) · AWS A5.10 ER4047
- ISO 18273-S AI 4047(AISi12)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 573-585
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Zn	Al	Be	其他元素
标准值	11.0-13.0	≤ 0.80	≤ 0.30	≤ 0.15	≤ 0.10	≤ 0.20	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15
例值	12.1	0.16	0.010	0.007	0.010	0.006	余量	0.0001	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	145	80	6

参考电流: (MIG DC⁺ · TIG AC)

	焊丝直径 (mm)	1.2	1.6	2.0
MIG	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-26	20-28	22-32
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI4047 · BCT-AI4047

Product Description:

- AI4047 is a eutectic Al-Si welding wire with 12% silicon. Compared with 4043 wire, it has a lower melting point and narrower solidification range. Its high silicon content improves molten pool fluidity, reduces solidification shrinkage, minimizes hot cracking tendency, and enhances fillet weld shear strength. Featuring excellent welding process performance, it ensures good weld appearance, stable arc and low spatter.
- It is suitable for TIG welding and brazing of Al-Si, Al-Mg-Si, Al-Mn and Al-Si-Mg-Cu alloys used in automotive parts and body panels.

Compliant with standards:

- GB/T 10858 SAI 4047(AISi12) · AWS A5.10 ER4047
- ISO 18273-S AI 4047(AISi12)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 573-585
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Zn	Al	Be	Other elements
standard value	11.0-13.0	≤ 0.80	≤ 0.30	≤ 0.15	≤ 0.10	≤ 0.20	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15
Example Value	12.1	0.16	0.010	0.007	0.010	0.006	All.	0.0001	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	145	80	6

Reference current: (MIG DC⁺ · TIG AC)

	Wire Diameter (mm)	1.2	1.6	2.0
MIG	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-26	20-28	22-32
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI5183·BCT-AI5183

产品说明:

- AI5183 用于焊接镁含量较高，要求具有较强抗拉强度或抗海水腐蚀的母材。该焊丝具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅少。
- 用于船舶结构、海洋平台、低温容器、铁路机车和汽车工业等相关铝合金的焊接，如 5083 和 5654 母材。

符合标准:

- GB/T 10858 SAI 5183[AlMg4.5Mn0.7(A)]·AWS A5.10 ER5183
- ISO 18273-S Al 5183[AlMg4.5Mn0.7(A)]

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 579-638
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr
标准值	≤ 0.40	≤ 0.40	≤ 0.10	0.50-10	4.3-52	0.05-0.5
例值	0.08	0.12	0.006	0.65	4.75	0.130
	Zn	Ti	Al	Be	其他元素	
标准值	≤ 0.25	≤ 0.15	余量	≤ 0.0003	单个≤ 0.05 合计≤ 0.15	
例值	0.005	0.080	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	280	150	18

参考电流: (MIG DC⁺ · TIG AC)

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-28	20-20	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5183·BCT-AI5183

Product Description:

- AI5183 is used to weld base metals with high magnesium content, high tensile strength or resistance to seawater corrosion. The welding wire has excellent welding process performance, beautiful weld forming, stable arc and less spatter.
- It is used for the welding of related aluminum alloys such as ship structures, offshore platforms, cryogenic vessels, railway locomotives and the automotive industry, such as 5083 and 5654 base metals.

Compliant with standards:

- GB/T 10858 SAI 5183[AlMg4.5Mn0.7(A)]·AWS A5.10 ER5183
- ISO 18273-S Al 5183[AlMg4.5Mn0.7(A)]

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 579-638
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr
standard value	≤ 0.40	≤ 0.40	≤ 0.10	0.50-10	4.3-52	0.05-0.5
Example Value	0.08	0.12	0.006	0.65	4.75	0.130
	Zn	Ti	Al	Be	Other elements	
standard value	≤ 0.25	≤ 0.15	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15	
Example Value	0.005	0.080	All.	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	280	150	18

Reference current: (MIG DC⁺ · TIG AC)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-28	20-20	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI5356 · BCT-AI5356

产品说明:

- AI5356 是一种含镁 5% 的铝合金焊丝，用途广泛的铝镁合金焊丝。具有优良的焊接工艺性能，电弧稳定、焊缝成形美观、飞溅少。该焊丝也能为经阳极化处理的焊接工件提供良好的配色。
- 广泛运用于自行车、运动器材、铝模板、铝托盘、机车车厢、化工压力容器、兵工生产、造船、航空等行业相关铝合金的焊接。如 5052、6061、6063 等母材的焊接。

符合标准:

- GB/T 10858 AI5356[AlMg5Cr(A)] · AWS A5.10 ER5356
- ISO 18273-S Al 5356[AlMg5Cr(A)]

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 575-633
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr
标准值	≤ 0.25	≤ 0.40	≤ 0.10	0.50-0.20	4.5-5.5	0.05-0.20
例值	0.05	0.13	0.08	0.12	4.85	0.07
	Zn	Ti	Al	Be	其他元素	
标准值	≤ 0.10	0.06-0.20	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15	
例值	0.008	0.10	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	265	150	20

参考电流: (MIG DC⁺ · TIG AC)

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
焊接电压 (V)		18-28	20-20	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5356 · BCT-AI5356

Product Description:

- AI5356 is a versatile Al-Mg alloy welding wire with 5% magnesium. It offers excellent welding performance, featuring stable arc, neat weld appearance and low spatter, and ensures good color matching for anodized welded workpieces.
- Widely applied to weld aluminum alloys (e.g., base metals 5052, 6061, 6063) in industries like bicycle, sports equipment, aluminum formwork, pressure vessel, ordnance, shipbuilding and aerospace.

Compliant with standards:

- GB/T 10858 AI5356[AlMg5Cr(A)] · AWS A5.10 ER5356
- ISO 18273-S Al 5356[AlMg5Cr(A)]

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 575-633
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr
standard value	≤ 0.25	≤ 0.40	≤ 0.10	0.50-0.20	4.5-5.5	0.05-0.20
Example Value	0.05	0.13	0.08	0.12	4.85	0.07
	Zn	Ti	Al	Be	Other elements	
standard value	≤ 0.10	0.06-0.20	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15	
Example Value	0.008	0.10	All.	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	265	150	20

Reference current: (MIG DC⁺ · TIG AC)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
Welding Voltage (V)		18-28	20-20	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI5087·BCT-AI5087

产品说明：

- AI5087 是一种含镁 4.5%，并含有少量锰、铬、锆元素的铝镁合金焊丝。具有优良的焊接工艺性能，电弧稳定、焊缝成形美观、飞溅少。
- 广泛运用于要求强度较高、抗裂性能、抗弯曲性能和耐腐蚀性能铝合金结构的焊接。如兵工生产、储罐、造船、海洋工程和航空等行业相关铝合金的焊接。

符合标准：

- GB/T 10858 AI5087 (AlMg4.5MnZr) · AWS A5.10 ER5087
- ISO 18273-S Al 5087 (AlMg4.5MnZr)

保护气体：

- MIG: 99.99%Ar

焊接位置：

- 全位置

物理性能：

- 熔化温度区间 (°C) : 581-642
- 密度 (g/cm³) : 2.66

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr	Zn
标准值	≤ 0.25	≤ 0.40	≤ 0.05	0.7-1.1	4.5-5.2	0.05-0.25	≤ 0.25
例值	0.03	0.12	0.005	1.12	4.74	0.09	0.003
	Ti	Zr	Al	Be	其他元素		
标准值	≤ 0.15	0.1-0.2	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15		
例值	0.080	0.12	余量	0.0001	-		

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	285	165	18

参考电流: (MIG DC⁺ · TIG AC) /Reference current

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
焊接电压 (V)	18-28	20-20	22-34	
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5087·BCT-AI5087

Product Description:

- AI5087 is an Al-Mg alloy welding wire containing 4.5% magnesium, plus trace amounts of manganese, chromium and zirconium. It features excellent welding process performance with stable arc, neat weld appearance and low spatter.
- It is widely used for welding high-strength aluminum alloy structures requiring good crack resistance, bending resistance and corrosion resistance, such as those in ordnance production, storage tanks, shipbuilding, marine engineering and aerospace industries.

Compliant with standards:

- GB/T 10858 AI5087 (AlMg4.5MnZr) · AWS A5.10 ER5087
- ISO 18273-S Al 5087 (AlMg4.5MnZr)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 581-642
- Density (g/cm³) : 2.66

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr	Zn
standard value	≤ 0.25	≤ 0.40	≤ 0.05	0.7-1.1	4.5-5.2	0.05-0.25	≤ 0.25
Example Value	0.03	0.12	0.005	1.12	4.74	0.09	0.003
	Ti	Zr	Al	Be	Other elements		
standard value	≤ 0.15	0.1-0.2	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15		
Example Value	0.080	0.12	All.	0.0001	-		

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	285	165	18

Reference current: (MIG DC⁺ · TIG AC)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
Welding Voltage (V)	18-28	20-20	22-34	
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI5554 · BCT-AI5554

产品说明:

- AI5554 是一种含镁 2.7%，含锰 0.7%，并含有少量铬、钛元素的铝镁合金焊丝。具有优良的焊接工艺性能，电弧稳定、焊缝成形美观、飞溅少。
- 用于 5454 等耐腐蚀低镁铝合金的焊接，如交通运输、储罐、铝挂车、车轮等行业相关铝合金的焊接。

符合标准:

- GB/T 10858 SAI 5554 (AlMg2.7Mn) · AWS A5.10 ER5554
- ISO 18273-S Al 5554 (AlMg2.7Mn)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 630-645
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr
标准值	≤ 0.25	≤ 0.40	≤ 0.10	0.5-1.0	2.4-3.0	0.05-0.20
例值	0.07	0.112	0.006	0.75	2.82	0.10
	Zn	Ti	Al	Be	其他元素	
标准值	≤ 0.25	0.05-0.20	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15	
例值	0.006	0.09	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	210	105	20

参考电流: (MIG DC⁺ · TIG AC)

	焊丝直径 (mm)	1.2	1.6	2.0
MIG	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-28	20-20	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5554 · BCT-AI5554

Product Description:

- AI5554 is an aluminum-magnesium alloy welding wire containing 2.7% magnesium, 0.7% manganese, and a small amount of chromium and titanium. It has excellent welding process performance, stable arc, beautiful weld forming and less spatter.
- It is used for the welding of corrosion-resistant and low-magnesium aluminum alloys such as 5454, such as the welding of aluminum alloys related to transportation, storage tanks, aluminum trailers, wheels and other industries.

Compliant with standards:

- GB/T 10858 SAI 5554 (AlMg2.7Mn) · AWS A5.10 ER5554
- ISO 18273-S Al 5554 (AlMg2.7Mn)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 630-645
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr
standard value	≤ 0.25	≤ 0.40	≤ 0.10	0.5-1.0	2.4-3.0	0.05-0.20
Example Value	0.07	0.112	0.006	0.75	2.82	0.10
	Zn	Ti	Al	Be	Other elements	
standard value	≤ 0.25	0.05-0.20	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15	
Example Value	0.006	0.09	All.	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	210	105	20

Reference current: (MIG DC⁺ · TIG AC)

	Wire Diameter (mm)	1.2	1.6	2.0
MIG	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-28	20-20	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Welding Current (A)	150-250	200-320	220-400

BCM-AI5556 · BCT-AI5556

产品说明:

- AI5556 是一种含镁 5%，含锰 0.8%，并含有少量铬、钛元素的铝镁合金焊丝。具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅少。
- 应用于要求强度较高、抗裂性能、抗弯曲性能和耐腐蚀性能铝合金结构的焊接。如军工、航天、造船、航洋工程和空分等行业 5083、5456 铝合金的焊接。

符合标准:

- GB/T 10858 SAI 5556 (AlMg5Mn1Ti) · AWS A5.10 ER5556
- ISO 18273-S Al 5556 (AlMg5Mn1Ti)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 572-633
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr
标准值	≤ 0.25	≤ 0.40	≤ 0.10	0.5-1.0	4.7-5.5	0.05-0.2
例值	0.05	0.11	0.007	0.81	5.12	0.09
	Zn	Ti	Al	Be	其他元素	
标准值	≤ 0.25	0.05-0.2	余量	≤ 0.0003	单个 ≤ 0.05	合计 ≤ 0.15
例值	0.005	0.09	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	286	145	19

参考电流: (MIG DC⁺ · TIG AC)

MIG	焊丝直径 (mm)	1.2	1.6	2.0
	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-28	20-20	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5556 · BCT-AI5556

Product Description:

- AI5556 is an Al-Mg alloy welding wire with 5% Mg, 0.8% Mn, and trace Cr and Ti. It boasts excellent welding process performance, with good-looking weld formation, stable arc and low spatter.
- It is applicable for welding high-strength Al alloy structures requiring good crack resistance, bending resistance and corrosion resistance, such as welding 5083 and 5456 Al alloys in military, aerospace, shipbuilding, marine engineering and air separation industries.

Compliant with standards:

- GB/T 10858 SAI 5556 (AlMg5Mn1Ti) · AWS A5.10 ER5556
- ISO 18273-S Al 5556 (AlMg5Mn1Ti)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 572-633
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr
standard value	≤ 0.25	≤ 0.40	≤ 0.10	0.5-1.0	4.7-5.5	0.05-0.2
Example Value	0.05	0.11	0.007	0.81	5.12	0.09
	Zn	Ti	Al	Be	Other elements	
standard value	≤ 0.25	0.05-0.2	All.	≤ 0.0003	Individual ≤ 0.05	Total ≤ 0.15
Example Value	0.005	0.09	All.	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	286	145	19

Reference current: (MIG DC⁺ · TIG AC)

MIG	Wire Diameter (mm)	1.2	1.6	2.0
	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-28	20-20	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-AI5556A·BCT-AI5556A

产品说明:

- AI5556A 是一种镁 5.3%，含锰 0.8%，并含有少量铬、铁元素的铝镁合金焊丝。具有优良的焊接工艺性能，电弧稳定、焊缝成形美观、飞溅少。
- 应用于要求强度较高、抗裂性能、抗弯曲性能和耐腐蚀性能铝合金结构的焊接。如军工、航天、造船、航洋工程和空分等行业 5083、5456 铝合金的焊接。

符合标准:

- GB/T 10858 AI5556A (AlMg5Mn) · ISO 18273-S AI 5556A (AlMg5Mn)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

物理性能:

- 熔化温度区间 (°C) : 572-633
- 密度 (g/cm³) : 2.65

焊丝化学成分 (质量分数) : %

	Si	Fe	Cu	Mn	Mg	Cr
标准值	≤ 0.25	≤ 0.40	≤ 0.10	0.6-1.0	5.0-5.5	0.05-0.20
例值	0.06	0.10	0.08	0.80	5.21	0.10
	Zn	Ti	Al	Be	其他元素	
标准值	≤ 0.20	0.05-0.2	余量	≤ 0.0003	单个 ≤ 0.05 合计 ≤ 0.15	
例值	0.005	0.09	余量	0.0001	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)
例值	291	152	18

参考电流: (MIG DC⁺ · TIG AC)

	焊丝直径 (mm)	1.2	1.6	2.0
MIG	焊接电流 (A)	180-300	200-400	240-450
	焊接电压 (V)	18-28	20-20	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-AI5556A·BCT-AI5556A

Product Description:

- AI5556A is an aluminum-magnesium alloy welding wire with 5.3% magnesium, 0.8% manganese, and a small amount of chromium and iron. It has excellent welding process performance, stable arc, beautiful weld forming and less spatter.
- It is used in the welding of aluminum alloy structures that require high strength, crack resistance, bending resistance and corrosion resistance. Such as the welding of 5083 and 5456 aluminum alloys in military, aerospace, shipbuilding, aviation engineering and air separation industries.

Compliant with standards:

- GB/T 10858 AI5556A (AlMg5Mn) · ISO 18273-S AI 5556A (AlMg5Mn)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Physical properties:

- Melting Temperature Range (°C) : 572-633
- Density (g/cm³) : 2.65

Welding wire chemical composition (mass fraction): %

	Si	Fe	Cu	Mn	Mg	Cr
standard value	≤ 0.25	≤ 0.40	≤ 0.10	0.6-1.0	5.0-5.5	0.05-0.20
Example Value	0.06	0.10	0.08	0.80	5.21	0.10
	Zn	Ti	Al	Be	Other elements	
standard value	≤ 0.20	0.05-0.2	All.	≤ 0.0003	Individual ≤ 0.05 Total ≤ 0.15	
Example Value	0.005	0.09	All.	0.0001	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)
Example Value	291	152	18

Reference current: (MIG DC⁺ · TIG AC)

	Wire Diameter (mm)	1.2	1.6	2.0
MIG	Welding Current (A)	180-300	200-400	240-450
	Welding Voltage (V)	18-28	20-20	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-Cu1898 · BCT-Cu1898

产品说明:

- Cu1898 是含有少量硅、锰、磷等脱氧元素的紫铜焊丝，锡用于改善熔池的流动性。该焊丝具有焊接工艺性能优良、焊缝成型美观、抗裂性好等特点。
- 用于脱氧铜和紫铜的氩弧焊及氧 - 乙炔气焊。

符合标准:

- GB/T 9460 S Cu1898 (CuSn1) · AWS A5.7 ERCu
- ISO 24373-S Cu 1898 (CuSn1)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Sn	Mn	Si	Al	Pb	P	其他元素
标准值	≥ 98.0	≤ 1.0	≤ 0.5	≤ 0.5	≤ 0.01	≤ 0.02	≤ 0.15	≤ 0.5
例值	98.37	0.93	0.35	0.25	0.001	0.002	0.005	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	285	175	32	72

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
1020-1050	8.90	26-34

参考电流: (MIG DC⁺ · TIG DC⁻)

MIG	焊丝直径 (mm)	1.0	1.2	1.6
	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400
预热		母材厚度大于 3mm 时, 预热 350-550°C		

BCM-Cu1898 · BCT-Cu1898

Product Description:

- Cu1898 is a copper welding wire containing a small amount of deoxidizing elements such as silicon, manganese, phosphorus, etc., and tin is used to improve the fluidity of the molten pool. The welding wire has the characteristics of excellent welding process performance, beautiful weld forming and good crack resistance.
- It is used for argon arc welding and oxy-acetylene gas welding of deoxidized copper and copper.

Compliant with standards:

- GB/T 9460 S Cu1898 (CuSn1) · AWS A5.7 ERCu
- ISO 24373-S Cu 1898 (CuSn1)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Sn	Mn	Si	Al	Pb	P	Other elements
Standard value	≥ 98.0	≤ 1.0	≤ 0.5	≤ 0.5	≤ 0.01	≤ 0.02	≤ 0.15	≤ 0.5
Example Value	98.37	0.93	0.35	0.25	0.001	0.002	0.005	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	285	175	32	72

Physical properties:

Melting temperature range (°C)	Density (g/cm ³)	Electrical conductivity (%IACS)
1020-1050	8.90	26-34

Reference current: (MIG DC⁺ · TIG DC⁻)

MIG	Wire Diameter (mm)	1.0	1.2	1.6
	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400
Preheating		Preheat the base metal to 350-550°C when its thickness exceeds 3 mm.		

BCM-Cu6560 · BCT-Cu6560

产品说明:

- Cu6560 是含硅和少量锰的硅青铜焊丝，具有良好的焊接工艺性能，焊缝成形美观、飞溅少、电弧稳定性好、铜水流动性好等特点。熔敷金属具有一定的抗腐蚀性能和耐磨性能。
- 用于硅青铜、紫铜、黄铜、铝青铜和镀锌钢板的氩弧焊，也可用于铜和铸铁的氩弧焊及堆焊，铜于刚的焊接。如汽车门框、摩托车零件等镀锌钢板的 MIG 电弧钎焊。

符合标准:

- GB/T 9460 SCu6560 (CuSi3Mn) · AWS A5.7 ERCuSi-A
- ISO 24373 -S Cu6560 (CuSi3Mn)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Sn	Fe	Mn	Si	Al	Pb	其他元素
标准值	余量	≤ 1.0	≤ 1.0	≤ 0.50	≤ 1.5	2.8-4.0	≤ 0.01	≤ 0.02	≤ 0.5
例值	余量	0.05	0.06	0.024	0.96	2.93	0.002	0.004	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	380	260	35	95

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
965-1035	8.50	6-7

参考电流: (MIG DC⁺ · TIG DC⁻)

MIG	焊丝直径 (mm)	0.8	0.9	1.0	1.2	1.6
	焊接电流 (A)	140-260	150-270	160-280	180-300	200-350
	焊接电压 (V)	16-26	17-27	18-28	20-30	22-34
TIG	焊丝直径 (mm)	1.6-2.5		2.5-4.0		4.0-5.0
	焊接电流 (A)	150-250		200-320		220-400

BCM-Cu6560 · BCT-Cu6560

Product Description:

- Cu6560 is a silicon bronze welding wire with silicon and a small amount of manganese. It boasts excellent welding process performance, featuring good weld appearance, low spatter, stable arc and high fluidity of molten copper. The deposited metal has certain corrosion and wear resistance.
- It is used for argon arc welding of silicon bronze, copper, brass, aluminum bronze and galvanized steel plate, and can also be used for argon arc welding and surfacing welding of copper and cast iron, and copper to rigid welding. MIG arc brazing of galvanized steel sheets such as automobile door frames and motorcycle parts.

Compliant with standards:

- GB/T 9460 SCu6560 (CuSi3Mn) · AWS A5.7 ERCuSi-A
- ISO 24373 -S Cu6560 (CuSi3Mn)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Sn	Fe	Mn	Si	Al	Pb	Other elements
Standard value	All.	≤ 1.0	≤ 1.0	≤ 0.50	≤ 1.5	2.8-4.0	≤ 0.01	≤ 0.02	≤ 0.5
Example Value	All.	0.05	0.06	0.024	0.96	2.93	0.002	0.004	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	380	260	35	95

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
965-1035	8.50	6-7

Reference current: (MIG DC⁺ · TIG DC⁻)

MIG	Wire Diameter (mm)	0.8	0.9	1.0	1.2	1.6
	Welding Current (A)	140-260	150-270	160-280	180-300	200-350
	Welding Voltage (V)	16-26	17-27	18-28	20-30	22-34
TIG	Wire Diameter (mm)	1.6-2.5		2.5-4.0		4.0-5.0
	Welding Current (A)	150-250		200-320		220-400

BCM-Cu5180·BCT-Cu5180

产品说明:

- Cu5180 是含 5% 左右的锡和大约 0.15% 左右的磷的锡青铜焊丝。磷用于脱氧, 锡用于增加熔池的流动性。熔敷金属具有抗磨损和耐腐蚀等特点。
- 适用于铜锡合金的焊接, 尤其适用于黄铜和刚的链接焊, 也适合铜铸件的补焊。

符合标准:

- GB/T 9460 S Cu5180 (CuSn5P) · AWS A5.7 ERCuSn-A
- ISO 24373-S Cu 5180 (CuSn5P)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Sn	Al	Pb	P	其他元素
标准值	余量	4.0-6.0	≤ 0.01	≤ 0.02	0.1-0.4	≤ 0.5
例值	余量	5.54	0.005	0.006	0.12	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	340	240	25	80

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
910-1040	8.7	10-12

参考电流: (MIG DC⁺ · TIG DC⁻)

	焊丝直径 (mm)	0.9	1.0	1.2	1.6
MIG	焊丝直径 (mm)	0.9	1.0	1.2	1.6
	焊接电流 (A)	150-270	160-280	180-300	200-350
	焊接电压 (V)	17-27	18-28	20-30	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0	
	焊接电流 (A)	150-250	200-320	220-400	

BCM-Cu5180·BCT-Cu5180

Product Description:

- Cu5180 is a tin bronze wire containing about 5% tin and about 0.15% phosphorus. Phosphorus is used for deoxidation and tin is used to increase the fluidity of the melt pool. Deposited metal is resistant to wear and corrosion.
- It is suitable for the welding of copper-tin alloys, especially for the link welding of brass and rigids, and also for the repair welding of copper castings.

符合标准:

- GB/T 9460 S Cu5180 (CuSn5P) · AWS A5.7 ERCuSn-A
- ISO 24373-S Cu 5180 (CuSn5P)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Sn	Al	Pb	P	Other elements
Standard value	All.	4.0-6.0	≤ 0.01	≤ 0.02	0.1-0.4	≤ 0.5
Example Value	All.	5.54	0.005	0.006	0.12	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	340	240	25	80

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
910-1040	8.7	10-12

Reference current: (MIG DC⁺ · TIG DC⁻)

	Wire Diameter (mm)	0.9	1.0	1.2	1.6
MIG	Wire Diameter (mm)	0.9	1.0	1.2	1.6
	Welding Current (A)	150-270	160-280	180-300	200-350
	Welding Voltage (V)	17-27	18-28	20-30	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0	
	Welding Current (A)	150-250	200-320	220-400	

BCM-Cu5210·BCT-Cu5210

产品说明：

- Cu5210 是含 8% 左右的锡和大约 0.15% 左右的磷的锡青铜焊丝。磷用于脱氧，锡用于增加熔池的流动性。熔敷金属具有抗磨损和耐腐蚀等特点。
- 用于铜或铜锡合金的堆焊或补焊，以及铜锌合金和钢的连接焊。

符合标准：

- GB/T 9460 SCu5210 (CuSn8P) · AWS A5.7 ERCuSn-C
- ISO 24373 -S Cu5210 (CuSn8P)

保护气体：

- MIG: 99.99%Ar

焊接位置：

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Sn	Fe	Ni+Co	Pb	P	其他元素
标准值	余量	≤ 0.2	7.5-8.5	≤ 0.1	≤ 0.2	≤ 0.02	0.01-0.4	≤ 0.2
例值	余量	0.03	8.05	0.005	0.007	0.002	0.15	-

熔敷金属力学性能 (焊态)：

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	384	248	25	95-105

物理性能：

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
875-1025	8.80	10-14

参考电流： (MIG DC⁺ · TIG DC⁻)

	焊丝直径 (mm)	1.0	1.2	1.6
MIG	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊接电流 (A)	150-250	200-320	220-400

BCM-Cu5210·BCT-Cu5210

Product Description:

- Cu5210 is a tin bronze wire containing about 8% tin and about 0.15% phosphorus. Phosphorus is used for deoxidation and tin is used to increase the fluidity of the melt pool. Deposited metal is resistant to wear and corrosion.
- It is used for hardfacing or repair welding of copper or copper-tin alloys, as well as link welding of copper-zinc alloys and steels.

Compliant with standards:

- GB/T 9460 SCu5210 (CuSn8P) · AWS A5.7 ERCuSn-C
- ISO 24373 -S Cu5210 (CuSn8P)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Sn	Fe	Ni+Co	Pb	P	Other elements
Standard value	All.	≤ 0.2	7.5-8.5	≤ 0.1	≤ 0.2	≤ 0.02	0.01-0.4	≤ 0.2
Example Value	All.	0.03	8.05	0.005	0.007	0.002	0.15	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	384	248	25	95-105

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
875-1025	8.80	10-14

Reference current： (MIG DC⁺ · TIG DC⁻)

	Wire Diameter (mm)	1.0	1.2	1.6
MIG	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Welding Current (A)	150-250	200-320	220-400

BCM-Cu6100 · BCT-Cu6100

产品说明:

- Cu6100 是一种不含铁的铝青铜焊丝，具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅少。熔敷金属具有良好的抗海水腐蚀性能和耐磨性能。
- 适用于铜铝合金、镀铝钢材、灰口铸铁的连接焊及堆焊。如铜铝合金防腐管和特殊黄铜的连接焊；船用螺旋桨、滑轨、滑面和承载面等的堆焊。

符合标准:

- GB/T 9460 S Cu6100 (CuAl7) · AWS A5.7 ERCuAl-A1
- ISO 24373-S Cu 6100 (CuAl7)

保护气体:

- MIG: 99.99%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Mn	Si	Al	Pb	其他元素
标准值	余量	≤ 0.2	≤ 0.5	≤ 0.1	6.0-8.5	-	≤ 0.5
例值	余量	0.005	0.32	0.08	7.20	0.002	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	450	270	34	105

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
1030-1040	7.70	12-15

参考电流: (MIG DC⁺ · TIG DC⁻)

	焊丝直径 (mm)	1.0	1.2	1.6
MIG	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊接电流 (A)	150-250	200-320	220-400

BCM-Cu6100 · BCT-Cu6100

Product Description:

- Cu6100 is an iron-free aluminum-bronze welding wire, which has excellent welding process performance, beautiful weld forming, stable arc and less spatter. The deposited metal has good resistance to seawater corrosion and wear.
- It is suitable for connection welding and surfacing welding of copper and aluminum alloys, aluminized steel and gray cast iron. Such as copper-aluminum alloy anti-corrosion pipe and special brass link welding; Surfacing welding of marine propellers, slide rails, slip surfaces and bearing surfaces, etc.

Compliant with standards:

- GB/T 9460 S Cu6100 (CuAl7) · AWS A5.7 ERCuAl-A1
- ISO 24373-S Cu 6100 (CuAl7)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Mn	Si	Al	Pb	Other elements
Standard value	All.	≤ 0.2	≤ 0.5	≤ 0.1	6.0-8.5	-	≤ 0.5
Example Value	All.	0.005	0.32	0.08	7.20	0.002	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	450	270	34	105

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
1030-1040	7.70	12-15

Reference current: (MIG DC⁺ · TIG DC⁻)

	Wire Diameter (mm)	1.0	1.2	1.6
MIG	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Welding Current (A)	150-250	200-320	220-400

BCM-Cu6180 · BCT-Cu6180

产品说明:

- Cu6180 是含铁的铝青铜焊丝, 具有优良的焊接工艺性能, 焊缝成形美观、电弧稳定、飞溅少。熔敷金属具有良好的抗海水腐蚀性能和耐磨性能。
- 适用于铝青铜、锰硅青铜、某些铜镍合金、镀铝钢材、铁基合金及堆焊。适用于耐磨和耐腐蚀表面的堆焊, 也可用于火焰喷涂。

符合标准:

- GB/T 9460 SCu6180 (CuAl10Fe) · AWS A5.7 ERCuAl-A2
- ISO 24373 -S Cu6180 (CuAl10Fe)

保护气体:

- MIG: 99.99%Ar

焊接位置 /Welding position

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Fe	Si	Al	Pb	其他元素
标准值	余量	≤ 0.2	≤ 1.5	≤ 0.1	8.5-11.0	≤ 0.02	≤ 0.5
例值	余量	0.001	0.79	0.03	9.25	0.002	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	510	330	36	150

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
1030-1040	7.6	11-13

参考电流: (MIG DC⁺ · TIG DC⁻)

	焊丝直径 (mm)	1.0	1.2	1.6
MIG	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-Cu6180 · BCT-Cu6180

Product Description:

- Cu6180 is an aluminum-bronze welding wire containing iron, which has excellent welding process performance, beautiful weld forming, stable arc and less spatter. The deposited metal has good resistance to seawater corrosion and wear.
- It is suitable for aluminium bronze, manganese silicon bronze, some copper-nickel alloys, aluminized steel, iron-based alloys and surfacing welding. It is suitable for hardfacing welding on wear-resistant and corrosion-resistant surfaces, and can also be used for flame spraying.

Compliant with standards:

- GB/T 9460 SCu6180 (CuAl10Fe) · AWS A5.7 ERCuAl-A2
- ISO 24373 -S Cu6180 (CuAl10Fe)

Protective gas:

- MIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Fe	Si	Al	Pb	Other elements
Standard value	All.	≤ 0.2	≤ 1.5	≤ 0.1	8.5-11.0	≤ 0.02	≤ 0.5
Example Value	All.	0.001	0.79	0.03	9.25	0.002	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	510	330	36	150

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
1030-1040	7.6	11-13

Reference current: (MIG DC⁺ · TIG DC⁻)

	Wire Diameter (mm)	1.0	1.2	1.6
MIG	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-Cu6810A·BCT-Cu6810A

产品说明:

- Cu6810A 是含有少量锡、硅的特殊黄铜焊丝，锡能改善熔融的流动性，而硅可有效的控制锌的蒸发、消除气孔和得到满意的机械性能。具有优良的焊接工艺性能，铜水流动性好、焊接成型美观、抗裂性好。
- 广泛应用于铜、钢、铜镍合金、灰口铸铁气焊及碳弧焊，以及镶嵌硬质合金刀具等。

符合标准:

- GB/T 9460 SCu6810A (CuZn40SnSi)

焊接方法:

- OFW

焊接位置

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Sn	Mn	Fe	Si	Al	Pb	其他元素
标准值	58.0-62.0	余量	≤ 1.0	≤ 0.3	≤ 0.2	0.1-0.5	≤ 0.01	≤ 0.03	≤ 0.2
例值	59.5	余量	0.97	0.008	0.006	0.26	0.0005	0.004	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	430	350	23	100-120

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
890-910	8.4	23-26

BCM-Cu6810A·BCT-Cu6810A

Product Description:

- Cu6810A is a special brass welding wire containing a small amount of tin and silicon, which can improve the fluidity of melting, and silicon can effectively control the evaporation of zinc, eliminate porosity and obtain satisfactory mechanical properties. It has excellent welding process performance, good copper fluidity, beautiful welding forming, and good crack resistance.
- It is widely used in copper, steel, copper-nickel alloy, gray cast iron gas welding and carbon arc welding, as well as inlaid carbide tools.

Compliant with standards:

- GB/T 9460 SCu6810A (CuZn40SnSi)

Welding method:

- OFW

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Sn	Mn	Fe	Si	Al	Pb	Other elements
Standard value	58.0-62.0	All.	≤ 1.0	≤ 0.3	≤ 0.2	0.1-0.5	≤ 0.01	≤ 0.03	≤ 0.2
Example Value	59.5	All.	0.97	0.008	0.006	0.26	0.0005	0.004	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	430	350	23	100-120

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
890-910	8.4	23-26

BCT-Cu6810

产品说明:

- Cu6810 是含有少量铁、锡、硅和锰元素的黄铜焊丝，流动性较好，可有效地控制锌的蒸发、消除气孔，从而得到良好的焊缝，获得满意的机械性能。
- 适用于黄铜、紫铜气焊时作为填充材料，广泛应用于铜及铜合金、钢、铜镍合金、灰口铸铁以及镶嵌硬质合金刀具等。

符合标准:

- GB/T 9460 SCu6810 (CuZn40Fe1Sn1)

焊接方法:

- OFW

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Sn	Mn	Fe	Al	Pb	其他元素
标准值	56.0-60.0	余量	0.8-1.1	0.01-0.50	0.04-0.25	≤ 0.01	≤ 0.05	≤ 0.5
例值	59.45	余量	0.95	0.25	0.18	0.0005	0.004	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	400	310	25	100-120

物理性能:

熔化温度区间 (°C)	密度 (g/cm³)	电导率 (%IACS)
865-890	8.4	23-26

BCT-Cu6810

Product Description:

- Cu6810 is a brass welding wire containing a small amount of iron, tin, silicon and manganese elements, which has good fluidity, can effectively control the evaporation of zinc and eliminate porosity, so as to obtain a good weld and obtain satisfactory mechanical properties.
- It is suitable for brass and copper gas welding as a filling material, and is widely used in copper and copper alloys, steel, copper-nickel alloys, gray cast iron and inlaid carbide tools.

Compliant with standards:

- GB/T 9460 SCu6810 (CuZn40Fe1Sn1)

Welding method:

- OFW

Welding position:

- All-position Welding

	Cu	Zn	Sn	Mn	Fe	Al	Pb	Other elements
Standard value	56.0-60.0	All.	0.8-1.1	0.01-0.50	0.04-0.25	≤ 0.01	≤ 0.05	≤ 0.5
Example Value	59.45	All.	0.95	0.25	0.18	0.0005	0.004	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	400	310	25	100-120

Physical properties:

Melting temperature range (°C)	Density(g/cm³)	Electrical conductivity(%IACS)
865-890	8.4	23-26

BCT-Cu4700

产品说明:

- Cu4700 是不含硅的锡青铜焊丝，锡能改善熔融铜的流动性，由于不含硅，焊接时可完全避免焊丝里的硅与母材交界面形成脆性化合物，获得满意的机械性能。具有优良的焊接工艺性能，铜水流动性好、焊缝成型美观、抗裂性好。
- 广泛应用于耐腐蚀性要求不高的铜及铜合金、钢、铜镍合金、镍基合金和灰口铸铁的气焊、感应钎焊和炉中钎焊，以及镶嵌硬质合金刀具等。

符合标准:

- GB/T 9460 S Cu4700 (CuZn40Sn)

焊接方法:

- OFW

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Zn	Sn	Al	Pb	其他元素
标准值	57.0-61.0	余量	0.25-1.0	≤ 0.01	≤ 0.05	≤ 0.5
例值	59.4	余量	0.85	0.0005	0.004	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	405	305	25	100-120

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
890-900	8.4	23-26

BCT-Cu4700

Product Description:

- Cu4700 is a silicon-free tin brass welding wire, tin can improve the fluidity of molten copper, because it does not contain silicon, it can completely avoid the formation of brittle compounds at the interface between silicon and base metal in the welding wire, and obtain satisfactory mechanical properties. It has excellent welding process performance, good copper fluidity, beautiful weld forming and good crack resistance.
- It is widely used in gas welding, induction brazing and furnace brazing of copper and copper alloys, steel, copper-nickel alloys, nickel-based alloys and gray cast iron with low corrosion resistance requirements, as well as inlaid carbide tools.

Compliant with standards:

- GB/T 9460 S Cu4700 (CuZn40Sn)

Welding method:

- OFW

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Sn	Al	Pb	Other elements
Standard value	57.0-61.0	All.	0.25-1.0	≤ 0.01	≤ 0.05	≤ 0.5
Example Value	59.4	All.	0.85	0.0005	0.004	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	405	305	25	100-120

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
890-900	8.4	23-26

BCM-Cu7730·BCT-Cu7730

产品说明：

- Cu7730 是一种铜锌镍焊丝，镍的加入可提高焊接过程对碳化钨的润湿性。该焊丝相比 Cu4700、Cu6810A 等普通黄铜焊丝具有更高的强度，在海水等苛刻介质下适用具有更佳的耐腐蚀性。
- 适用于钎焊钢、镍及镍基合金和硬质合金。除真空钎焊外，所有的钎焊方法均可适用于该材料。

符合标准：

- GB/T 9460 SCu7730 (CuZn40Ni10)

焊接方法：

- OFW

焊接位置：

- 全位置

焊丝化学成分（质量分数）：%

	Cu	Zn	Sn	Ni+Co	Al	Pb	其他元素
标准值	46.0-50.0	余量	0.04-0.25	9.0-11.0	≤ 0.01	≤ 0.05	≤ 0.5
例值	48.45	余量	0.15	10.25	0.004	0.002	-

熔敷金属力学性能（焊态）：

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	伸长率 A(%)	硬度 (HB)
例值	605	495	16	160

物理性能：

熔化温度区间 (°C)	密度 (g/cm ³)
890-920	8.7

BCM-Cu7730·BCT-Cu7730

Product Description:

- Cu7730 is a copper-zinc-nickel welding wire, the addition of nickel can improve the wettability of tungsten carbide during the welding process. Compared with ordinary brass wires such as Cu4700 and Cu6810A, this wire has higher strength, and has better corrosion resistance when applied to harsh media such as seawater.
- Suitable for brazing steels, nickel and nickel-based alloys and cemented carbides. With the exception of vacuum brazing, all brazing methods can be applied to this material.

Compliant with standards:

- GB/T 9460 SCu7730 (CuZn40Ni10)

Welding method:

- OFW

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Zn	Sn	Ni+Co	Al	Pb	Other elements
Standard value	46.0-50.0	All.	0.04-0.25	9.0-11.0	≤ 0.01	≤ 0.05	≤ 0.5
Example Value	48.45	All.	0.15	10.25	0.004	0.002	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	Tensile Strength Rm(MPa)	Yield Strength Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	605	495	16	160

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)
890-920	8.7

BCM-Cu7158·BCT-Cu7158

产品说明：

- Cu7158 是一种含镍 30% 的白铜焊丝，镍的加入可以强化焊缝金属并改善抗腐蚀性能，特别是抗海水腐蚀。该焊丝具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅少。熔敷金属在热态和冷态塑性均较好。
- 适用于含镍量 30% 以下铜镍合金的连接焊、钎焊及堆焊，如耐海水腐蚀的容器、冷凝器导管、冷却器、换热器的氩弧焊。

符合标准：

- GB/T 9460 S Cu7158 (CuNi30Mn1FeTi) · AWS A5.7 ERCuNi
- ISO 24373-S Cu7158 (CuNi30Mn1FeTi)

保护气体：

- TIG: 99.99%Ar

焊接位置：

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Mn	Fe	Si	Ni+Co	P
标准值	余量	0.5-1.5	0.4-0.7	≤ 0.25	29.0-32.0	≤ 0.02
例值	余量	0.85	0.57	0.04	30.15	0.006
	Pb	Ti	S	C	其他元素	
标准值	≤ 0.02	0.2-0.5	≤ 0.01	-	≤ 0.5	
例值	0.008	0.36	0.004	0.005	-	

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	断后伸长率 A(%)	硬度 (HB)
例值	415	260	34	78

物理性能：

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
1180-1240	8.90	5-6

参考电流：(MIG DC⁺ · TIG DC⁻)

MIG	焊丝直径 (mm)	1.0	1.2	1.6
	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
TIG	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	焊接电流 (A)	150-250	200-320	220-400

BCM-Cu7158·BCT-Cu7158

Product Description:

- Cu7158 is a cupronickel welding wire with 30% nickel content. Nickel addition strengthens weld metal and enhances corrosion resistance, especially seawater corrosion resistance. It features excellent welding process performance, presenting nice weld appearance, stable arc and low spatter. The deposited metal has good plasticity in both hot and cold conditions.
- It is suitable for joining, brazing and surfacing of Cu-Ni alloys with ≤ 30% nickel, such as TIG welding of seawater-resistant vessels, condenser tubes, coolers and heat exchangers.

Compliant with standards:

- GB/T 9460 S Cu7158 (CuNi30Mn1FeTi) · AWS A5.7 ERCuNi
- ISO 24373-S Cu7158 (CuNi30Mn1FeTi)

Protective gas:

- TIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Mn	Fe	Si	Ni+Co	P
Standard value	All.	0.5-1.5	0.4-0.7	≤ 0.25	29.0-32.0	≤ 0.02
Example Value	All.	0.85	0.57	0.04	30.15	0.006
	Pb	Ti	S	C	Other elements	
Standard value	≤ 0.02	0.2-0.5	≤ 0.01	-	≤ 0.5	
Example Value	0.008	0.36	0.004	0.005	-	

Mechanical Properties of Deposited Metal(As-Welded Condition):

	T S Rm(MPa)	Y S Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	415	260	34	78

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity(%IACS)
1180-1240	8.90	5-6

Reference current：(MIG DC⁺ · TIG DC⁻)

MIG	Wire Diameter (mm)	1.0	1.2	1.6
	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
TIG	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
	Welding Current (A)	150-250	200-320	220-400

BCM-Cu7061 · BCT-Cu7061

产品说明:

- Cu7061 是一种含镍 10% 的白铜焊丝，镍的加入可以强化焊缝金属并改善抗腐蚀性能，特别是抗海水腐蚀。该焊丝具有优良的焊接工艺性能，焊缝成形美观、电弧稳定、飞溅少。熔敷金属在热态和冷态塑性均较好。
- 适用于含镍量 10% 铜镍合金的连接焊、钎焊及堆焊，如耐海水腐蚀的容器、冷凝器导管、冷却器、换热器的氩弧焊。

符合标准:

- GB/T 9460 S Cu7061 (CuNi10) · ISO 24373-S Cu7061 (CuNi10)

保护气体:

- TIG: 99.99%Ar

焊接位置:

- 全位置

焊丝化学成分 (质量分数) : %

	Cu	Mn	Fe	Si	Ni+Co	P	Pb	Ti	S	其他元素
标准值	余量	0.5-1.5	0.5-2.0	≤ 0.20	9.0-11.0	≤ 0.02	≤ 0.02	0.1-0.5	≤ 0.02	≤ 0.4
例值	余量	0.76	0.94	0.006	10.05	0.002	0.001	0.27	0.001	-

熔敷金属力学性能 (焊态) :

	抗拉强度 Rm(MPa)	屈服强度 Rp0.2 (MPa)	断后伸长率 A(%)	硬度 (HB)
例值	310	195	31	80

物理性能:

熔化温度区间 (°C)	密度 (g/cm ³)	电导率 (%IACS)
1100-1145	8.90	5-6

参考电流: (MIG DC⁺ · TIG DC⁻)

	焊丝直径 (mm)	1.0	1.2	1.6
MIG	焊接电流 (A)	160-280	180-300	200-350
	焊接电压 (V)	18-28	20-30	22-34
	焊丝直径 (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	焊接电流 (A)	150-250	200-320	220-400

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Product Description:

- Cu7061 is a white copper wire containing 10% nickel, the addition of nickel can strengthen the weld metal and improve the corrosion resistance, especially the resistance to seawater corrosion. The welding wire has excellent welding process performance, beautiful weld forming, stable arc and less spatter. The plasticity of deposited metal in both hot and cold states is good.
- It is suitable for connection welding, brazing and surfacing welding of copper-nickel alloy with a nickel content of 10%, such as argon arc welding of seawater corrosion-resistant vessels, condenser conduits, coolers and heat exchangers.

Compliant with standards:

- GB/T 9460 S Cu7061 (CuNi10) · ISO 24373-S Cu7061 (CuNi10)

Protective gas:

- TIG: 99.99%Ar

Welding position:

- All-position Welding

Welding wire chemical composition (mass fraction): %

	Cu	Mn	Fe	Si	Ni+Co	P	Pb	Ti	S	Other elements
Standard value	All.	0.5-1.5	0.5-2.0	≤ 0.20	9.0-11.0	≤ 0.02	≤ 0.02	0.1-0.5	≤ 0.02	≤ 0.4
Example Value	All.	0.76	0.94	0.006	10.05	0.002	0.001	0.27	0.001	-

Mechanical Properties of Deposited Metal(As-Welded Condition):

	T S Rm(MPa)	Y S Rp0.2 (MPa)	Elongation A(%)	Hardness (HB)
Example Value	310	195	31	80

Physical properties:

Melting temperature range (°C)	Density(g/cm ³)	Electrical conductivity (%IACS)
1100-1145	8.90	5-6

Reference current: (MIG DC⁺ · TIG DC⁻)

	Wire Diameter (mm)	1.0	1.2	1.6
MIG	Welding Current (A)	160-280	180-300	200-350
	Welding Voltage (V)	18-28	20-30	22-34
	Wire Diameter (mm)	1.6-2.5	2.5-4.0	4.0-5.0
TIG	Welding Current (A)	150-250	200-320	220-400