

MIG-309L

相当规格

AWS	A5.9 ER309L
GB/T	29713 S309L
EN ISO	14343-A G 23 12 L
YB/T	5092 H022Cr24Ni13

特性与用途 |

填充金属C \leq 0.03%，由于碳含量低，故在不含铌、钛等稳定化元素时也能抵抗因碳化物析出而产生的晶间腐蚀。适用范围：合金钢、不锈钢。

- 1、保护气体：98%Ar+2%O₂，使用前请确认气体纯度，Ar纯度 \geq 99.997%，O₂纯度 \geq 99.5%。
- 2、焊接前必须对工件表面清除铁锈、油污、水分等杂质。
- 3、气体流量：20-25L/min；干伸长度：15-25mm。
- 4、焊接时，请根据具体工况选择最佳的过渡方式及热输入，以确保获得理想的性能和力学性能。



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