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实心焊丝
Welding Wires

实心气保护焊丝一览表 *Solid Gas-Shielded Welding Wires*

类别 Grade	焊丝牌号 Model of Wires	型号 Model		主要用途 Purpose
		GB	AWS	
碳钢 Carbon Steel	LT • ER49-1	G49AYUCIS10	—	焊接低碳钢及某些低合金钢结构 Used for welding low-carbon steel and some low-alloy steel structures.
	LT • ER50-3	G49A2C13	ER70S-3	适用于碳素钢及低合金钢的焊接 Used for welding low-carbon steel and some low-alloy steel
	LT • ER50-4	G49AZC1S4	ER70S-4	适用于碳素钢的焊接 Used for welding carbon steel
	LT • ER50-6	G49A3C1S6 G49A4M21S6	ER70S-6	焊接低碳钢及500MPa抗拉强度等级的低合金钢 Used for welding low-carbon steel and all kinds of 500MPa low alloy steel
	LT • ER50-6N	G49A3C1S6N G49A4M21S6N	ER70S-6	无镀铜环保型气保实心焊丝，焊接低碳钢及500MPa的低合金钢 Non copper coating welding wire, Used for welding low-carbon steel and all kinds of 500MPa low alloy steel
	LT • ER50-Ti	—	ER70S-G	焊接低碳钢，适宜于大电流焊接 Used for welding low-carbon steel with strengthened current
耐候钢 Weathering Steel	LT • H08MnSiCuCrNiII	ER44-G	—	用于相同强度级别的耐候钢的焊接 Suitable for welding the same strength level of weathering steel
	LT • TH500-NQ-II	ER50-G	—	用于500MPa抗拉强度等级的耐候钢结构 Suitable for welding 500MPa high strength weathering steel
	LT • TH550-NQ-II	G55A4M21SNCC1	ER80S-G	焊接550MPa抗拉强度等级的耐候钢结构 Suitable for welding 550MPa high strength weathering steel
高强度 High Strength Steel	LT • ER60-G	—	ER90S-G	焊接620MPa抗拉强度等级的高强钢 Suitable for welding 620MPa high strength steel structures,
	LT • ER70-G	—	ER100S-G	焊接690MPa抗拉强度等级的高强钢 Suitable for welding 690MPa high strength steel structures,
	LT • ER80-G	—	ER110S-G	焊接790MPa抗拉强度等级的高强钢 Suitable for welding 790MPa high strength steel structures,



LT · ER49-1

符合GB/T 8110 ER49-1 相当ISO 14341-A-G424CZ

Conform to Standard: GB/T 8110 ER49-1 Equivalent to : ISO 14341-A-G424CZ

说明: 碳钢气保焊丝, 具有优良的焊接工艺性能。焊丝中含锰量高, 具有良好的抗气孔性能和抗裂性。
用途: 适用于强度级别相当的低碳钢及某些低合金钢结构焊接。

Specification: LT · ER49-1 welding wire has excellent welding performance. While welding, it has stable arc, low spatters and excellent blowhole-resistance.

Purpose: Used for welding low-carbon steel and some low-alloy steel structures.

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
保证值 Guarantee Value	≤0.11	1.80~2.10	0.65~0.95	≤0.025	≤0.025	≤0.20	≤0.30	≤0.50
例值 General Result	0.070	1.95	0.72	0.013	0.016	0.024	0.008	0.120

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -40°C
标准值 Guarantee Value	490-670	≥390	≥18	≥47
例值 General Result	545	425	29	78、82、81

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25

LT · ER50-3

符合GB/T 8110 ER50-3 相当JIS YGW16 AWS A5.18 ER70S-3 符合ISO 14341-B-GS3

Conform to Standard :GB/T 8110 ER50-3 Equivalent to : JIS YGW16 / AWS A5.18 ER70S-3 Conform to Standard :ISO 14341-B-GS3

说明: 气体保护用焊丝, 具有优良的焊接工艺性能, 焊道平滑、美观, 焊接飞溅小。
用途: 1.低碳钢薄板焊接。
2.表面处理较彻底的低碳钢部件焊接。

Specification: LT · ER50-3 is a kind of CO₂ gas-shielded welding wire. It has excellent welding performance, smooth and beautiful bead and low spatters.

Purpose: 1.Used for welding low-carbon steel & thin plates.
2. Used for welding low-carbon steel parts with thorough surface treatment.

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

项目 Test Item	C	Mn	Si	S	P	Cr	Mo	V	Cu
保证值 Guarantee Value	0.06~0.15	0.90~1.40	0.45~0.75	≤0.025	≤0.025	≤0.15	≤0.15	≤0.03	≤0.50
例值 General Result	0.074	1.15	0.63	0.011	0.020	0.021	0.023	0.004	0.12

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -20°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	525	430	28	103、97、100

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25



LT · ER50-4

符合GB/T 8110 ER50-4 符合ISO 14341-B-GS4 AWS A5.18 ER70S-4 相当JIS YGW12

Conform to Standard :GB/T 8110 ER50-4 Conform to Standard :ISO 14341-B-GS4 AWS A5.18 ER70S-4 Equivalent to : JIS YGW12

说明：焊丝采用CO₂或Ar+CO₂ 5%~20%气体保护进行焊接，具有优良的焊接工艺性能。一次成型好。富氩保护焊接时，焊道精致美观。

Specification: LT · ER50-4 welding wire has CO₂ or Ar+CO₂ 5%–20% as shielding gas. It has excellent welding performance. It has good one-time shaping performance. When used in argon-rich mixed gases arc welding, the bead is delicate and beautiful.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
保证值 Guarantee Value	0.06~0.15	1.00~1.50	0.65~0.85	≤0.025	≤0.025	≤0.15	≤0.15	≤0.15	≤0.03	≤0.50
例值 General Result	0.085	1.05	0.718	0.014	0.014	0.005	0.018	0.006	0.003	0.106

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -30°C
标准值 Guarantee Value	490-670	≥390	≥18	不要求
例值 General Result	540	450	30	93、87、95

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25

LT · ER50-6

符合GB/T 8110 ER50-6 符合ISO 14341-A-G424C13Si1 AWS A5.18 ER70S-6 相当JIS YGW12

Conform to Standard :GB/T 8110 ER50-6 Conform to Standard :ISO 14341-A-G424C13Si1 AWS A5.18 ER70S-6 Equivalent to : JIS YGW12

说明：焊丝采用CO₂或Ar+CO₂混合气体保护进行焊接，抗母材表面氧化皮、油污能力强，气孔敏感性小。

用途：1. 各种 500MPa 抗拉强度等级结构钢部 件焊接。
2. 各种 500MPa 抗拉强度等级板材、管材焊接。

Specification: LT · ER50-6 is a kind of carbon steel shielded welding wire. It has stable arc, low spatters and beautiful appearance. Good corrosion-resistant on surface of base material. Decrease the probability of blowhole formation. All position welding has good performance CO₂ or Ar+CO₂ can be used as shielded gas.

Purpose: 1. Used for welding all kinds of 500MPa structural steel parts.
2. Used for welding all kinds of 500MPa plates and pipes.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
标准值 Guarantee Value	0.06~0.15	1.40~1.85	0.80~1.15	≤0.025	≤0.025	≤0.15	≤0.15	≤0.15	≤0.03	≤0.50
例值 General Result	0.077	1.45	0.87	0.013	0.012	0.017	0.031	0.002	0.004	0.125

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -40°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	555	450	29	77、95、83

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25



LT · ER50-6N

符合GB/T 8110 ER50-6 符合ISO 14341-A-G424C13Si1 AWS A5.18 ER70S-6 相当JIS YGW12

Conform to Standard :GB/T 8110 ER50-6 Conform to Standard :ISO 14341-A-G424C13Si1 AWS A5.18 ER70S-6 Equivalent to : JIS YGW12

说明: LT·ER50-6N是环保型无镀铜气保实心焊丝,生产过程采用无酸洗、无镀铜的环保型工艺处理,焊丝外层涂敷环保型涂层。该焊丝从焊接飞溅、焊接烟尘、导电嘴磨损、抗锈性能等四方面进行评价,可达到同种型号的镀铜焊丝技术水平。

用途:适用于焊接500MPa强度级别的母材,可应用于钢结构、汽车制造、工程机械、桥梁、压力容器制造等行业。

Specification: LT·ER50-6N is an environment-friendly welding wire without copper plating. The production process adopts environment-friendly process without acid pickling and copper plating, and the outer layer is coated with environment-friendly coating. Evaluated from four aspects, such as welding spatter, welding dust, wear of contact tube and rust resistance, it reaches the technical quality of the same type of copper-plated welding wire.

Purpose: It is suitable for welding base metal with strength level of 500MPa. Suitable for welding steel structures, such as construction machinery, hoisting machinery, automobile manufacturing, engineering machinery bridges, pressure vessels, etc.

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.12	1.40~1.85	0.08~1.15	≤0.025	≤0.025	≤0.15	≤0.30	≤0.15	≤0.20
例值 General Result	0.007	1.54	0.88	0.011	0.012	0.011	0.008	0.010	0.15

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -40°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	542	446	29	144、134、149

LT · ER50-Ti

符合GB/T 8110 ER50-G 符合ISO 14341-B-GS11 AWS ER70S-G JIS YGW11

Conform to Standard :GB/T 8110 ER50-G Conform to Standard :ISO 14341-B-GS11 AWS ER70S-G JIS YGW11

说明:可大电流焊接,提高了焊接效率。由于熔敷金属的晶粒得到细化,其抗拉强度、屈服强度等机械性能得到明显优化。

用途:1.各种500MPa抗拉强度等级结构钢部件、厚板、厚管线焊接。

2.各种500MPa抗拉强度等级母材的高速焊接。

Specification: The welding current has been strengthened to a great extent and the welding efficiency has been improved. Because the grains of the deposited metal have been refined, both the tensile strength and the yield strength will be improved too.

Purpose: 1.Used for welding all kinds of 500MPa structural steel parts.
2.It can be applied for high-speed welding steel plate of 500MPa

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

项目 Test Item	C	Mn	Si	S	P	Ti+Zr	Cu
标准值 Guarantee Value	≤0.15	1.40~1.90	0.55~1.10	≤0.030	≤0.030	≤0.30	≤0.50
例值 General Result	0.061	1.44	0.73	0.012	0.009	0.16	0.124

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -40°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	545	455	29	114、131、127

参考范围(DC+) Reference Current (DC+)

焊丝规格(mm) Size (mm)	焊接电流(A) Current range (A)	气体流量(L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25



LT · H08MnSiCuCrNi II

符合TB/T 2374 ER44-G

Conform to Standard :TB/T 2374 ER44-G

说明：采用富氩气体保护，焊丝具有优良的焊接工艺性能，焊道精致美观。其熔敷金属具有良好的抗大气腐蚀性、抗裂性能及良好的塑形和韧性。

用途：用于相应强度等级耐候钢结构的焊接，如机车车辆、近海工程、桥梁等结构的焊接。

Specification: This welding wire has excellent welding performance, and with exquisite welding bead. The deposited metal has good atmospheric corrosion resistance, crack resistance, good shaping and toughness.

Purpose: Used for welding of weathering steel structure of corresponding strength grade, such as vehicles, offshore projects, bridges and other structures

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Cu
保证值 Guarantee Value	≤0.10	0.90 ~ 1.30	0.35 ~ 0.65	≤0.025	≤0.025	0.20 ~ 0.50	0.20 ~ 0.50	0.20 ~ 0.50
例值 General Result	0.057	1.21	0.56	0.008	0.016	0.32	0.31	0.31

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{P0.2} (MPa)	A(%)	KV ₂ (J) -40°C
标准值 Guarantee Value	≥440	≥340	≥22	≥60
例值 General Result	525	430	26	139、143、135

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm)	焊接电流 (A)	气体流量 (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25

LT · TH500-NQ-II

符合TB/T 2374 ER50-G

Conform to Standard :TB/T 2374 ER50-G

说明：采用富氩气体保护，具有优良的焊接工艺性能，焊道精致美观。其熔敷金属具有良好的抗大气腐蚀性能、抗裂性能及良好的塑形和韧性。

用途：用于500MPa抗拉强度等级耐候钢结构的焊接，如机车车辆、近海工程、桥梁等结构的焊接。

Specification: The welding current has been strengthened to a great extent and the welding efficiency has been improved. Because the grains of the deposited metal have been refined, both the tensile strength and the yield strength will be improved too.

Purpose: Suitable for welding 500MPa high strength weathering steel, such as vehicles, offshore projects, bridges, etc.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Cu
标准值 Guarantee Value	≤0.10	0.60 ~ 1.20	≤0.60	≤0.020	≤0.025	0.20 ~ 0.60	0.3 ~ 0.90	0.20 ~ 0.50
例值 General Result	0.068	0.80	0.34	0.01	0.007	0.25	0.38	0.45

熔敷金属力学性能 (Ar+20%CO₂气保护) Mechanical Properties of Deposited Metal (Ar+20%CO₂)

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{P0.2} (MPa)	A(%)	KV ₂ (J) -40°C
标准值 Guarantee Value	≥500	≥400	≥22	≥60
例值 General Result	530	435	24	117、102、124

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25



LT·TH550-NQ-II

符合TB/T 2374 ER55-G GB ER55-1

Conform to Standard :TB/T2374 ER55-G GB ER55-1

说明：采用富氩气体保护。其熔敷金属具有良好的抗大气腐蚀性能、抗裂性能及良好的塑形和韧性。
用途：用于550MPa抗拉强度等级耐候钢结构的焊接，如机车车辆、近海工程、桥梁等结构的焊接。

Specification: It comes with Argon – rich gases protection. The deposited metal has good atmospheric corrosion resistance, crack resistance, good shaping and toughness.

Purpose: Suitable for welding 500MPa high strength weathering steel, such as vehicles, offshore projects, bridges, etc.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Cu
标准值 Guarantee Value	≤0.10	1.20~1.60	≤0.60	≤0.020	≤0.025	0.20~0.60	0.30~0.90	0.20~0.50
例值 General Result	0.057	1.40	0.46	0.008	0.016	0.33	0.48	0.30

熔敷金属力学性能 (Ar+20%CO₂气保护) Mechanical Properties of Deposited Metal (Ar+20%CO₂)

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -40°C
标准值 Guarantee Value	≥550	≥450	≥22	≥60
例值 General Result	590	495	28	112、120、118

参考范围 (DC +) Reference Current (DC +)

焊丝规格 (mm) Size (mm)	焊接电流 (A) Current range (A)	气体流量 (L/min) GAS flow rate (L/min)
Φ0.8	50~200	15
Φ1.0	50~250	15~20
Φ1.2	80~350	15~25
Φ1.6	170~550	20~25

LT·ER60-G

符合GB/T 8110 ER60-G AWS ER90S-G

Conform to Standard :GB/T 8110 ER60-G AWS ER90S-G

说明：LT·ER60-G是620MPa级高韧性低合金钢气保焊丝，采用富氩气体保护，具有良好的全位置焊接工艺性能。
用途：适用于焊接620MPa抗拉强度等级高强度钢结构，如工程机械、管线、船舶、压力容器等的焊接。

Specification: LT·ER60-G is a kind of 620MPa high toughness low-alloy steel gas-shielded welding wire. It has excellent all-position welding performance.

Purpose: Suitable for welding 620MPa high strength steel structures, such as construction machinery, pipelines, ships, pressure vessels, etc.

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

项目 Test Item	C	Mn	Si	S	P	Mo	Ti	Cu
标准值 Guarantee Value	≤0.10	1.40~1.90	0.50~0.95	≤0.025	≤0.025	0.20~0.60	≤0.12	≤0.50

熔敷金属力学性能 (Ar+20%CO₂气保护) Mechanical Properties of Deposited Metal (Ar+20%CO₂)

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -20°C
标准值 Guarantee Value	≥620	≥490	≥19	≥47
例值 General Result	660	545	25	103、111、121



LT · ER70-G

符合GB/T 8110 ER70-G AWS ER100S-G

Conform to Standard :GB/T 8110 ER70-G AWS ER100S-G

说明: Ni、Mo、Cr合金化型690MPa级高韧性低合金钢气保焊丝,采用富氩气体保护,具有良好的全位置焊接工艺性能。电弧稳定,飞溅少。

用途:适用于焊接690MPa抗拉强度等级高强钢结构,如工程机械、起重机械、船舶、桥梁、管线和压力容器等的焊接。

Specification:LT · ER70-G is a kind of Ni、Mo、Cr type 690MPa high toughness low-alloy steel gas-shielded welding wire. It has excellent all-position welding performance, stable arc and low spatters.

Purpose: Suitable for welding 690MPa high strength steel structures, such as construction machinery, hoisting machinery, bridges, pipelines, shipbuilding, pressure vessels, etc.

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

项目 Test Item	C	Mn	Si	S	P	Ni	Mo	Ti	Cr	Cu
标准值 Guarantee Value	≤0.11	1.40~1.90	≤0.80	≤0.025	≤0.025	0.50~1.55	0.20~0.60	≤0.16	≤0.30	≤0.50

熔敷金属力学性能(Ar+20%CO₂气保护) Mechanical Properties of Deposited Metal (Ar+20%CO₂)

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
标准值 Guarantee Value	≥670	≥610	≥16	≥27
例值 General Result	740	645	23	121、128、126

LT · ER80-G

符合GB/T 8110 ER80-G AWS ER110S-G

Conform to Standard :GB/T 8110 ER80-G AWS ER110S-G

说明: 高强度用气体保护焊丝,保护气体可用Ar+20%CO₂混合气体。电弧柔和,燃烧稳定,飞溅少。焊缝低温冲击韧性较好。

用途:适用于焊接抗拉强度为790MPa抗拉强度等级的高强度结构,可用于焊接压力容器、工程机械、起重机械、船舶、矿山机械等重要结构。

Specification:LT · ER80-G is a kind of high strength gas-shielded welding wire. The mixed gas Ar+20% CO₂ can be used as shielding gas. It has soft arc, stable burning and low spatters. The bead has higher impact toughness.

Purpose: Suitable for welding high strength structures with tensile strength of 790MPa. It can be used for welding some key structures, such as pressure vessels, construction machinery, and hoisting machinery, shipbuilding, mining machinery

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.11	1.40~1.85	0.40~1.00	≤0.025	≤0.025	0.25~0.60	1.20~2.40	0.20~0.60	≤0.50

熔敷金属力学性能(Ar+20%CO₂气保护) Mechanical Properties of Deposited Metal (Ar+20%CO₂)

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
标准值 Guarantee Value	≥790	≥690	≥16	≥17
例值 General Result	840	730	24.5	85、93、75

注意事项:

1.严格控制保护气体中的杂质含量,保证气体的纯度。

2.焊接时气体流量一般在20-25L/min。

3.干伸长度控制在15-20mm之间。

Notes:

1.Shield gas: Must ensure not to operate with impurity shield Gas

2.Operation flow rate of shield gas: 20-25L/min.

3.Electrode extension: 15-25mm



焊条
Electrodes

碳钢焊条产品一览表 Carbon Steel Electrodes

焊条牌号 Model	国标型号 GB Size	药皮类型 Type of Coating	焊接电源 Reference Current	主要用途 Purpose
LT·J422	E4303	钛钙型 Calcium-Titanium	交直流 (AC、DC)	焊接低碳钢结构和强度等级相同的低合金钢结构 It is used for welding of low carbon steel structure and low strength grade of low alloy steel structure. Such as Q235, 09Mnv, 09Mn2 etc.
LT·J421	E4313	钛型 Titanium	交直流 (AC、DC)	焊接低碳钢结构, 尤其宜薄板小件, 间断焊和要求表面光洁的盖面焊 It is suitable for welding structures made of low carbon steel, performs very well in welding thin and small size steel plates and also has very good performance in the situation that requires nice and clean bead appearance..
LT·J502	E5003	钛钙型 Calcium-Titanium	交直流 (AC、DC)	焊接16Mn及相应强度的低合金钢结构 Used for welding 16Mn and low-alloy structures
LT·J506	E5016	低氢型 Low-Hydrogen	交直流 (AC、DC +)	用于中碳钢和低合金钢重要结构的焊接 It is applied in welding medium-carbon steel and low-alloy structures
LT·J507	E5015	低氢型 Low-Hydrogen	直流反接 (DCEP)	用于中碳钢和低合金钢重要结构的焊接 It is applied in welding medium-carbon steel and low-alloy structures

LT·J422

符合GB/T 5117 E4303 ISO 2560-B-E 43 03 A
Conform to Standard GB/T 5117 E4303 ISO 2560-B-E 43 03 A

说明: 钛钙型药皮的碳钢焊条, 交直流两用。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, 脱渣容易, 焊缝成形美观; 可进行全位置焊接。
用途: 用于低碳钢结构和强度等级低的低合金钢结构, 如Q235、09MnV、09Mn2等。

Specification: LT·J422 is calcium-titanium coated carbon steel electrode. It has very good welding usability that enables it to operate on AC/DC, performs all-position welding, has stable arc, removal of slag is easy and has good bead appearance. Its good mechanical properties give it very good low temperature toughness. During the application, its characteristic of easy maneuverability offers easy striking, easy re-striking and good control of welding speed, which enables the welders to have desired weld path and penetration of the arc.

Purpose: It is used for welding of low carbon steel structure and low strength grade of low alloy steel structure. Such as Q235, 09Mnv, 09Mn2 etc.

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

试验项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
例值 General Result	0.077	0.42	0.18	0.018	0.023	0.020	0.032	0.008	0.005

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

试验项目 Test Item	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J)	
				0°C	-20°C
标准值 Guarantee Value	≥430	≥330	≥20	≥27	≥47
例值 General Result	469	385	30	97	70

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

参考电流 (AC、DC) Reference Current (AC、DC)

焊条直径 (mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	40~70	60~100	80~140	140~220	180~230



LT · J421

符合GB/T 5117 E4313 AWS A5.1 E6013 ISO 2560-B-E 43 13 A

Conform to Standard GB/T 5117 E4313 AWS A5.1 E6013 ISO 2560-B-E 43 13A

说明：氧化钛型药皮的碳钢焊条，交直流两用。具有优异的焊接工艺性能，操作性能良好，电弧稳定，焊缝成形美观，可进行全位置焊接。

用途：焊接低碳钢结构，特别适于薄板小件及要求焊缝表面美观和光洁的盖面焊。

Specification: LT · J421 is rutile-based carbon steel electrode. It has very good welding usability that enables it to perform all-position welding, operates on AC/DC, removal of slag is easy, has stable arc and also has very good bead appearance. It is easy to operate, which makes re-striking the arc easy.

Purpose: It is suitable for welding structures made of low carbon steel, performs very well in welding thin and small size steel plates and also has very good performance in the situation that requires nice and clean bead appearance.

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

试验项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.20	≤1.20	≤1.00	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
例值 General Result	0.075	0.38	0.21	0.018	0.024	0.020	0.032	0.005	0.010

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

试验项目 Test Item	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J) 0°C
标准值 Guarantee Value	≥430	≥330	≥16	≥47
例值 General Result	485	380	28.5	86

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

参考电流 (AC、DC) Reference Current (AC、DC)

焊条直径 (mm) Diameter (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	60~100	80~140	140~220	180~240

LT · J502

符合GB/T 5117 E5003 ISO 2560-B-E 49 03A

Conform to Standard GB/T 5117 E5003 ISO 2560-B-E 49 03A

说明：钛钙型药皮的碳钢焊条。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，交直流两用，可进行全位置焊接。

用途：用于490MPa抗拉强度等级的低合金钢结构的焊接。

Specification: LT · J502 is calcium-titanium coated carbon steel electrode. It has very good welding usability that enables it to operate on AC/DC, performs all-position welding, has stable arc, removal of slag is easy and has good bead appearance. Its good mechanical properties give it very good low temperature toughness. During the application, its characteristic of easy maneuverability offers easy striking, easy re-striking and good control of welding speed, which enables the welders to have desired weld path and penetration of the arc.

Purpose: Used for welding all kinds of 490MPa low-alloy structures

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

试验项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.15	≤1.25	≤0.90	≤0.035	≤0.040	≤0.30	≤0.20	≤0.30	≤0.08
例值 General Result	0.095	0.72	0.27	0.015	0.022	0.025	0.036	0.010	0.008

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

试验项目 Test Item	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J) 0°C
标准值 Guarantee Value	≥490	≥400	≥20	≥47
例值 General Result	530	440	26	85

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

参考电流 (AC、DC) Reference Current (AC、DC)

焊条直径 (mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	40~70	60~100	80~140	140~220	180~240



LT · J506

符合GB/T 5117 E5016 AWS A5.1 E7016 ISO 2560-B-E 49 16 A

Conform to Standard GB/T 5117 E5016 AWS A5.1 E7016 ISO 2560-B-E 49 16 A

说明：低氢钾型药皮的碳钢焊条。具有良好的焊接工艺性能，电弧稳定，飞溅少，易脱渣，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。交直流两用，可进行全位置焊接。

用途：用于焊接中碳钢和低合金钢结构，如16Mn、09Mn2Si和船舶用A、B、D、E级钢等。

Specification: LT · J506 is low-hydrogen potassium coated carbon steel electrode. It has very good welding usability that enables it to operate on AC/DC, performs all-position welding, has stable arc, removal of slag is easy and has low spatter. The deposited metal has good mechanical performance and crack-resistance

Purpose: It is applied in welding medium-carbon steel and low-alloy structures such as 16Mn, 09Mn2Si, 09Mn2V and the steels used in shipbuilding such as A, B, D, E.

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

试验项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.15	≤1.60	≤0.75	≤0.035	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08
例值 General Result	0.080	1.05	0.51	0.012	0.020	0.012	0.030	0.007	0.016

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

试验项目 Test Item	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J)	
				-20°C	-30°C
标准值 Guarantee Value	≥490	≥400	≥20	≥47	≥27
例值 General Result	540	430	32	175	169

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

参考电流 (AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径 (mm) Diameter (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	60~100	80~140	110~210	160~230

注意事项：
1. 焊前焊条须经350°C烘焙1h，随烘随用。2. 焊前必须清除焊件的铁锈、油污、水分等杂质。3. 焊接时须用短弧操作，以窄焊道为宜。

Notes: 1. The electrode must be preheated at the temperature of 350°C for 1 hour. Preheat the rod whenever it is used.
2. The impurities such as rust, oil stains and moisture must be cleared off of the work piece.
3. Short arc is required to perform welding. Narrow weld path is preferred.

LT · J507

符合GB/T 5117 E5015 AWS A5.1 E7015 ISO 2560-B-E 49 15 A

Conform to Standard GB/T 5117 E5015 AWS A5.1 E7015 ISO 2560-B-E 49 15 A

说明：低氢钠型药皮的碳钢焊条。具有优良的焊接工艺性能，电弧稳定，飞溅少，易脱渣，熔敷金属具有优良的力学性能和抗裂性能。直流反接，可进行全位置焊接。

用途：用于焊接重要的中碳钢和低合金钢结构（受压、动载）。

Specification: LT · J507 is low-hydrogen sodium coated carbon steel electrode. It must be operated on DCEP. It has very good welding usability that enables it to perform all-position welding, has stable arc, removal of slag is easy and has low spatter. The deposited metal has good mechanical performance and crack-resistance

Purpose: It is applied in welding medium-carbon steel and low-alloy structures

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

试验项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.15	≤1.60	≤0.90	≤0.035	≤0.035	≤0.30	≤0.20	≤0.30	≤0.08
例值 General Result	0.082	1.10	0.58	0.012	0.021	0.011	0.028	0.007	0.016

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

试验项目 Test Item	R _m (MPa)	R _{eL} (MPa)	A(%)	KV ₂ (J)	
				-20°C	-30°C
标准值 Guarantee Value	≥490	≥400	≥20	≥47	≥27
例值 General Result	550	450	32	150	142

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

参考电流 (AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径 (mm) Diameter (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	60~100	80~140	110~210	160~230

注意事项：
1. 焊前焊条须经350°C烘焙1h，随烘随用。2. 焊前必须清除焊件的铁锈、油污、水分等杂质。3. 焊接时须用短弧操作，以窄焊道为宜。

Notes: 1. The electrode must be preheated at the temperature of 350°C for 1 hour. Preheat the rod whenever it is used.
2. The impurities such as rust, oil stains and moisture must be cleared off of the work piece.
3. Short arc is required to perform welding. Narrow weld path is preferred.



不锈钢焊条产品一览表Stainless Steel Electrodes

焊条牌号 Model	国标型号 GB Size	药皮类型 Type of Coating	焊接电源 Reference Current	主要用途 Purpose
LT · A102	E308-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于工作温度低于300℃的06Cr19Ni10及06Cr18Ni11Ti的不锈钢结构的焊接 Used for welding the corrosion resistant stainless steel structure, such as 06Cr19Ni10 and 06Cr18Ni11Ti and their working temperature should be below 300℃
LT · A132	347-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于重要耐腐蚀含钛稳定的06Cr18Ni11Ti型不锈钢的焊接 Used for welding important corrosion resistant stainless steel this contains stable Ti such as 06Cr18Ni11Ti.
LT · A302	E309-16	钛钙型 Calcium-Titanium	交直流 (AC、DC)	用于06Cr24Ni13类型不锈钢、异种钢、高铬钢、高锰钢等结构焊 Used in similar type stainless steel, dissimilar stainless steel and high chromium steel and high manganese steel such as 06Cr24Ni13

LT · A102

符合GB/T 983 E308-16 AWS A5.4 E308-16 ISO 3581-A-E(19 9) R 3 2 ISO 3581-B-ES 308-16

Conform to Standard GB/T 983 E308-16 AWS A5.4 E308-16 ISO 3581-A-E(19 9) R 32 ISO 3581-B-ES 308-16

说明：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。有优良的焊接工艺性能和抗气孔性能，药皮强度好。可交直流两用。

用途：用于焊接工作温度低于300℃的耐腐蚀的06Cr19Ni10及06Cr18Ni11Ti的不锈钢结构。

Specification: LT · A102 is a kind of Titanium calcium type coating Cr19Ni10 stainless steel electrode. The deposited metal has good mechanical properties and inter granular corrosion resistance. It has good welding performance and porosity resistance. Heat resistance coating and crack resistance. AC/DC both can be applied.

Purpose: Used for welding the corrosion resistant stainless steel structure, such as 06Cr19Ni10 and 06Cr18Ni11Ti and their working temperature should be below 300℃

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.08	0.50 ~ 2.50	≤1.00	≤0.030	≤0.040	18.0 ~ 21.0	9.0 ~ 11.0	≤0.75	≤0.75
例值 General Result	0.041	1.35	0.69	0.008	0.022	19.5	9.6	0.064	0.10

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

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥550	30
例值 General Result	600	42

参考电流 (AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径 (mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项:

1.焊前焊条须经300℃烘焙1h。2.尽可能采用直流电源，电流不宜过大。

Notes:

1.The electrode must be preheated at the temperature of 300° C for 1 hour. Preheat the rod whenever it is used

2.Preferred DC power supply, electric current should not be high.



LT · A132

符合GB/T 983 E347-16 AWS A5.4 E347-16 ISO 3581-A-E(19 9Nb) R 3 2 ISO 3581-B-ES 347-16

Conform to Standard GB/T 983 E347-16 AWS A5.4 E347-16 ISO 3581-A-E(19 9Nb) R 32 ISO 3581-B-ES 347-16

说明：钛钙型药皮含铌稳定剂的Cr19Ni10Nb不锈钢焊条，具有优良的抗晶间腐蚀性能和良好的力学性能。有优良的焊接工艺性能和抗气孔性能，药皮不易发红、药皮强度高。可交直流两用。

用途：用于焊接重要的耐腐蚀含Ti稳定剂的06Cr18Ni11Ti型不锈钢。

Specification: LT · A132 is a kind of Titanium calcium type coating Cr19Ni10Nb which contains the Nb stabilizing property. It has good mechanical properties and inter granular corrosion resistance. Good welding performance and porosity resistance. Heat resistance coating and crack resistance. AC/DC both can be applied.

Purpose: Used for welding important corrosion resistant stainless steel this contains stable Ti such as 06Cr18Ni11Ti.

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb+Ta
标准值 Guarantee Value	≤0.08	0.50~2.50	≤1.00	≤0.030	≤0.040	18.0~21.0	9.0~11.0	≤0.75	≤0.75	8×C~1.00
例值 General Result	0.045	1.68	0.76	0.008	0.021	19.80	9.70	0.066	0.105	0.45

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

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥520	≥25
例值 General Result	630	41

参考电流 (AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径 (mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项：
1.焊前焊条须经300℃烘焙1h。2.尽可能采用直流电源，电流不宜过大。

Notes:
1.The electrode must be preheated at the temperature of 300° C for 1 hour. Preheat the rod whenever it is used
2.Preferred DC power supply, electric current should not be high.

LT · A302

符合GB/T 983 E309-16 AWS A5.4 E309-16 ISO 3581-A-E(22 12) R 3 2 ISO 3581-B-ES 309-16

Conform to Standard GB/T 983 E309-16 AWS A5.4 E309-16 ISO 3581-A-E(22 12) R 32 ISO 3581-B-ES 309-16

说明：钛钙型药皮的Cr23Ni13不锈钢焊条，熔敷金属具有良好的抗裂性能及抗氧化性能。可交直流两用，有良好的操作工艺性能。

用途：用于焊接相同类型的不锈钢、不锈钢衬里、异种钢 (Cr19Ni9同低碳钢) 以及高铬钢、高锰钢。

Specification: LT · A302 is a, calcium-titanium coated, Cr23Ni13 stainless steel electrode. The deposited metal has good crack-resistance and oxidation resistance. The electrode can operate on AC/DC. It is easy to operate.

Purpose: It is used in similar type stainless steel, dissimilar stainless steel and high chromium steel and high manganese steel.

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

试验项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Mo	Cu
标准值 Guarantee Value	≤0.15	0.50~2.50	≤1.00	≤0.030	≤0.040	22.0~25.0	12.0~14.0	≤0.75	≤0.75
例值 General Result	0.055	1.25	0.65	0.009	0.021	24.25	12.52	0.30	0.10

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

试验项目 Test Item	R _m (MPa)	A(%)
标准值 Guarantee Value	≥550	≥25
例值 General Result	590	38

参考电流 (AC、DC⁺) Reference Current (AC、DC⁺)

焊条直径 (mm) Diameter (mm)	Φ2.0	Φ2.5	Φ3.2	Φ4.0	Φ5.0
焊接电流 (A) Amperage (A)	40~80	50~100	70~130	100~160	140~200

注意事项：
1.焊前焊条须经300℃烘焙1h。2.焊前必须对焊件进行油污、水分处理。

Notes:
1.The electrode must be preheated at the temperature of 300° C for 1 hour.
2.The impurities such as rust, oil stains and moisture must be cleared off of the work piece.



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

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

LT·H08A

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

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

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

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

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

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

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.10	0.40~0.65	≤0.03	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
例值 General Result	0.060	0.45	0.012	0.014	0.020	0.017	0.022	0.113

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

试验项目 Test Item 配合焊剂 Flux	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20℃
LT·SJ301	430~600	≥330	≥22	≥27

焊丝规格 Size of Welding Wires

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



LT · H08MnA

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

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

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

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

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

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

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.10	0.80 ~ 1.10	≤0.07	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
例值 General Result	0.066	0.96	0.038	0.007	0.010	0.027	0.011	0.110

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

试验项目 Test Item 配合焊剂 Flux	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
LT · SJ101	430~600	≥330	≥22	≥27

焊丝规格Size of Welding Wires

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

LT · H10Mn2

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

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

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

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

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

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

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.12	1.50 ~ 1.90	≤0.070	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
例值 General Result	0.066	1.62	0.011	0.011	0.011	0.013	0.007	0.12

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

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

焊丝规格Size of Welding Wires

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



LT · H10MnSi

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

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

说明: 锰、硅含量适中, 与低锰、硅的焊剂相匹配, 对母材上的锈迹不敏感, 焊道成形及脱渣性能优良。焊接效率高。
用途: 与烧结型焊剂101配合, 420MPa抗拉强度等级母材的高速焊接及填充焊接均可。多用于锅炉、压力容器、桥梁、船舶等工程的焊接。

Specification: It is a kind of welding wire with appropriate manganese and silicon content, It matches with low-manganese and low-silicon type welding flux, Insensitive to the rust on the base metal. It has excellent bead molding, excellent slag detach ability.
Purpose: Using with sintered flux LT · SJ101, it can be applied both for high-speed welding steel plate of tensile strength 420MPa and filling welding. It is widely used for welding boiler, pressure vessels, bridges, shipbuilding etc.

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

项目 Test Item	C	Mn	Si	S	P	Cr	Ni	Cu
标准值 Guarantee Value	≤0.14	0.80 ~ 1.10	0.60 ~ 0.90	≤0.030	≤0.030	≤0.20	≤0.30	≤0.35
例值 General Result	0.089	0.98	0.67	0.023	0.032	0.015	0.034	0.11

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

试验项目 Test Item 配合焊剂	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
LT · SJ101	415~550	≥330	≥22	≥27

焊丝规格Size of Welding Wires

焊丝直径 (mm)	Φ2.5	Φ3.2	Φ4.0	Φ5.0

LT · ER49-1

符合GB/T 8110 ER49-1

Conform to Standard :GB/T 8110 ER49-1

说明: LT · ER49-1是碳钢氩弧焊丝, 具有优良的塑形、韧性和抗裂性能。
用途: 适于碳钢及500MPa级结构钢的焊接。

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

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

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Cu
标准值 Guarantee Value	≤0.11	1.80 ~ 2.10	0.65 ~ 0.95	≤0.025	≤0.025	≤0.30	≤0.20	≤0.50
例值 General Result	0.063	1.93	0.79	0.010	0.015	0.007	0.015	0.112

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) 常温
标准值 Guarantee Value	490~670	≥390	≥18	≥47
例值 General Result	550	455	78	148、159、147

焊丝规格Size of Welding Wires

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



LT · TIG50

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

Conform to Standard :GB/T 8110ER50-6 Equivalent to : AWSA5.18-ER70S-6

说明: LT · TIG50是碳钢氩弧焊丝, 具有优良的塑形、韧性和抗裂性能, 尤其低温冲击韧性较高。
用途: 用于各种位置的管道手工钨极氩弧焊打底及弧焊, 都能获得满意的焊接接头。可焊接碳钢和某些低合金钢。

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

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

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

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

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -30°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	546	467	27	116

焊丝规格 Size of Welding Wires

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

药芯 Flux-Cored

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

类别 Types	焊丝牌号 Model of Wires	型号 Model			主要用途 Purpose
		GB	AWS	JIS	
低合金钢气体 保护药芯 焊丝 Co ₂ gas shielded flux-cored wires for low-carbon steel and high- strength structural steel	LT · E501	T492T1-1C1/M21A	E71T-1	T492T1-1CA	低碳钢及相应强度低合金结构钢焊接用 Used for welding low-carbon steel and some low-alloy steel structures.
	LT · E501Ni	T494T1-1C1A	E71T1-C1A4-Ni1	T493T1-1CA-N2	低温钢和低合金结构钢的焊接 Welding of low-temperature steel and low-alloy steel structures.
	LT · E711	T492T1-1C1/M21A	E71T-1	T492T1-1CA	低碳钢及相同强度低合金结构钢焊接用 Used for welding low-carbon steel and some low-alloy steel structures.
不锈钢药芯焊丝 Stainless steel flux-cored wire	LT · 308L	E308LT1-1	E308LT1-1		用于焊接工作温度低于300°C的耐腐蚀的06Cr19Ni10, 07Cr19Ni11Ti的不锈钢结构 Used for welding corrosion-resistant 06Cr19Ni10, 07Cr19Ni11Ti stainless steel structures and the working temperature should be below 300°C.
	LT · 309L	E309LT1-1	E309LT1-1		用于相同类型的不锈钢结构及复合钢、异种钢等构件, 也可用于过渡层堆焊 Used for the same type of stainless steel structure, composite steel, dissimilar steel and other components, it can also be used for transition surfacing.
自保护药芯焊丝 Self-shielded flux-cored wire	LT · E71T-GS	T49TG-1NS	E71T-GS		细直径自保护药芯焊丝, 用于多种碳钢母材(主要是薄板和镀锌板)全位置半自动焊接 Small diameter self-shielded flux-cored wire, used for semi-automatic welding of various carbon steel base materials (mainly sheet and galvanized sheet) in full position.

LT · E501

符合GB/T 10045 T492T1-1C1/M21A 相当AWS A5.20 E71T-1 相当JIS Z3313 E492T1-1CA
相当ISO 17632-B-T492T1-1CA

Conform to Standard :GB/T 10045 T492T1-1C1/M21A Equivalent to : AWS A5.20 E71T-1C JIS Z3313 E492T1-1CA ISO 17632-B-T492T1-1CA

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

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

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

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

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

项目 Test Item	C	Mn	Si	S	P
标准值 Guarantee Value	≤0.18	≤2.0	≤0.90	≤0.030	≤0.030
例值 General Result	0.05	1.36	0.41	0.008	0.012

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J) -20°C
标准值 Guarantee Value	490~670	≥390	≥18	≥27
例值 General Result	560	480	28	145

熔敷金属扩散氢含量 (热导法): ≤10ml/100g Diffusion hydrogen content of the deposited metal (Mercury Method): ≤10ml/100g
X射线探伤要求: II级 X-Ray Radiographic Test Requirements: Grade II

参考范围 (DC⁺) Reference Current (DC⁺)

焊丝直径 (mm) Size (mm)		Φ 1.0	Φ 1.2	Φ 1.4	Φ 1.6
电流 范围 (A) Current Range (A)	平焊 Flat Position	120~250	120~300	150~400	180~450
	向上立焊、仰焊 Vertical Upward welding/ Overhead position	120~210	120~260	150~270	180~280
	向下立焊 Vertical Downward welding/ Overhead position	200~250	200~300	220~300	250~300
	横焊 Horizontal Welding	120~230	120~280	150~320	180~350

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

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

LT · E501Ni

符合GB/T10045T494T1-1C1A 相当AWS A5.36 E71T1-C1A4-Ni1 相当JIS Z3313 T493T1-1CA-N2
相当ISO 17632-B-T493T1-1CA-N2

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

说明: LT · E501Ni为氧化钛型气体保护药芯焊丝, 焊接工艺性能优良, 电弧柔和稳定, 飞溅小, 脱渣容易, 焊缝成形美观。
适用于平焊和横焊, 可进行全位置焊接, 焊接效率高。熔敷金属经微量元素钝化处理, 具有优良的低温韧性, 抗裂性好。
用途: 适用于造船、机械制造、石油机械、化工机械、起重机械等碳钢、低合金结构钢重要位置的焊接。

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

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

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

项目 Test Item	C	Mn	Si	S	P	Ni	Cr	Mo	V
标准值 Guarantee Value	≤0.12	≤2.0	≤0.90	≤0.030	≤0.030	≤0.50	≤0.15	≤0.35	≤0.05
例值 General Result	0.04	1.28	0.38	0.006	0.011	0.40			

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A (%)	KV ₂ (J)	
				-30°C	-40°C
标准值 Guarantee Value	490~670	≥390	≥18	≥27	≥27
例值 General Result	570	510	27	135	120

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

参考范围 (DC⁺) Reference Current (DC⁺)

焊丝直径 (mm) Size (mm)		Φ 1.0	Φ 1.2	Φ 1.4	Φ 1.6
电流 范围 (A) Current Range (A)	平焊 Flat Position	120~250	120~300	150~400	180~450
	向上立焊、仰焊 Vertical Upward welding/ Overhead position	120~210	120~260	150~270	180~280
	向下立焊 Vertical Downward welding/ Overhead position	200~250	200~300	220~300	250~300
	横焊 Horizontal Welding	120~230	120~280	150~320	180~350

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

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



LT · E711

符合GB/T 10045 T492T1-1C1/M21A 相当AWS A5.20 E71T-1 相当JIS Z3313 E492T1-1CA
相当ISO 17632-B-T 492T1-1CA

Conform to Standard :GB/T 10045 T492T1-1C1/M21A Equivalent to : AWS A5.20 E71T-1 JIS Z3313 E492T1-1CA ISO 17632-B-T492T1-1CA

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

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

Specification: LT · E711A is a kind of titanium oxide type gas-shielded flux-cored welding wire for low carbon steel and 490MPa high strength steel. It has excellent welding performance, soft and stable arc, lower spatters, good slag detachability and beautiful appearance of weld; suitable for all-position welding. It has high welding efficiency. The weld metal has been given toughening treatment by microelements, so it has excellent low temperature toughness, good crack-resistance, stable and reliable inherent quality.

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

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

项目 Test Item	C	Mn	Si	S	P
标准值 Guarantee Value	≤0.18	≤2.0	≤0.90	≤0.030	≤0.030
例值 General Result	0.05	1.28	0.39	0.010	0.016

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{p0.2} (MPa)	A(%)	KV ₂ (J) -20°C
标准值 Guarantee Value	490-670	≥390	≥18	≥27
例值 General Result	550	470	27	115

熔敷金属扩散氢含量(热导法): ≤10ml/100g Diffusion hydrogen content of the deposited metal (Mercury Method): ≤10ml/100g
X射线探伤要求: II级 X-Ray Radiographic Test Requirements: Grade II

参考范围(DC⁺) Reference Current (DC⁺)

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

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

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

LT · 308L

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

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

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

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

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

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

保护气体: CO₂ Shielding Gas: CO₂

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

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

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

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

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



LT · 309L

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

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

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

用途: 用于合成纤维、石油化工等设备制造的相同类型的不锈钢结构及复合钢、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。

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

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

保护气体: CO₂ Shielding Gas: CO₂

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

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

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

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

供货规格: Φ 1.2mm Φ 1.4mm Φ 1.6mm Specification of supply: Φ 1.2mm Φ 1.4mm Φ 1.6mm

LT · E71T-GS

符合GB/T 10045 T49TG-1NS AWS 520E71T-GS

Conform to Standard :GB/T 17493-2008 E501T11-G AWS A5.20 E71T-GS

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

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

Specification: LT · E71T-GS It is a small diameter self-shielded flux-cored wire with direct current connection. Soft and stable arc, small splash, beautiful forming, easy slag removal, small amount of smoke, easy operation, with good welding operation performance.

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

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

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

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

试验项目 Test Item	R _m (MPa)	R _{eL} /R _{P0.2} (MPa)	A(%)
标准值 Guarantee Value	480~655	0	0
例值 General Result	620	0	0

参考范围 (DC⁺) Reference Current (DC⁺)

焊丝直径 (mm)	焊接电流 (A)	焊接电压 (V)
Φ 0.8	60~130	14~21
Φ 0.9	60~150	15~22
Φ 1.0	60~150	15~22

供货规格: Φ 0.8mm Φ 0.9mm Φ 1.0mm Specification of supply: Φ 1.2mm Φ 1.4mm Φ 1.6mm

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