

# 燃煤火力发电锅炉用焊接材料

## Welding Materials for Coal-fired Steam Boiler

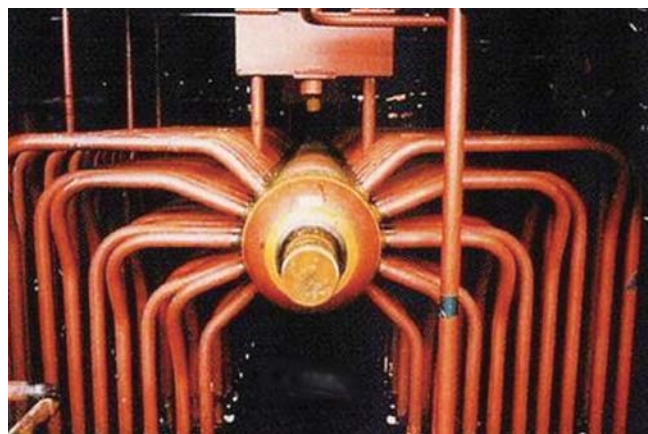
强大的技术创新能力

### 应用领域 / Application

适用于在高温高压环境下燃煤火力发电厂的过热器管道与管道接头的焊接



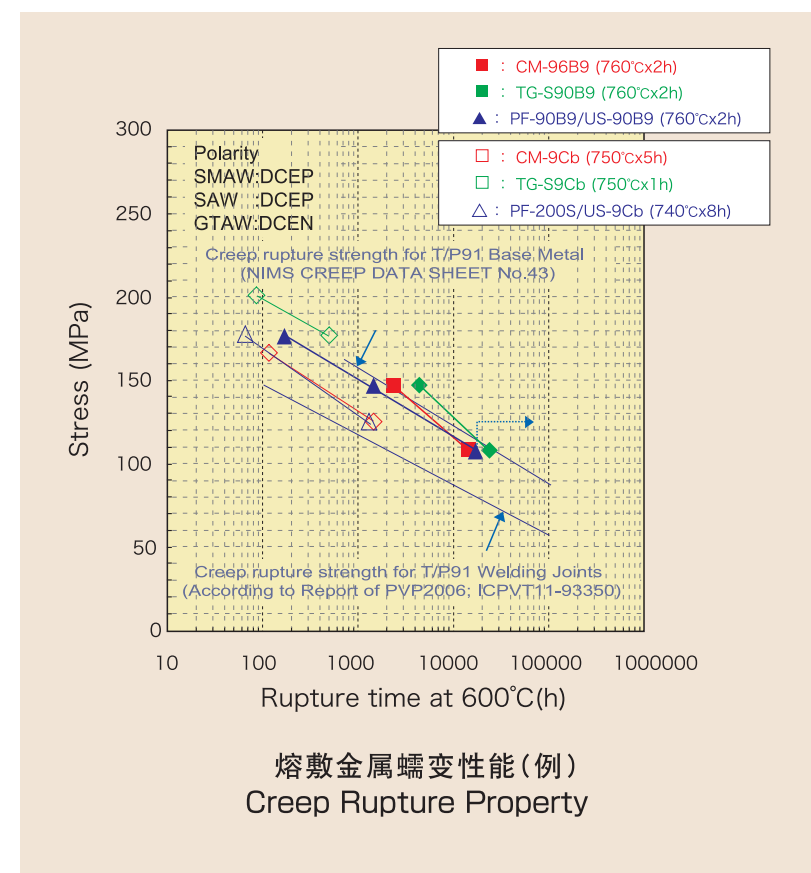
燃煤火力发电厂  
Coal-fired Steam Boiler Plant



管道接头 / Header

### 铁素体耐热钢用焊接材料 / Welding materials for ferritic heat-resistant Low-Alloy steel

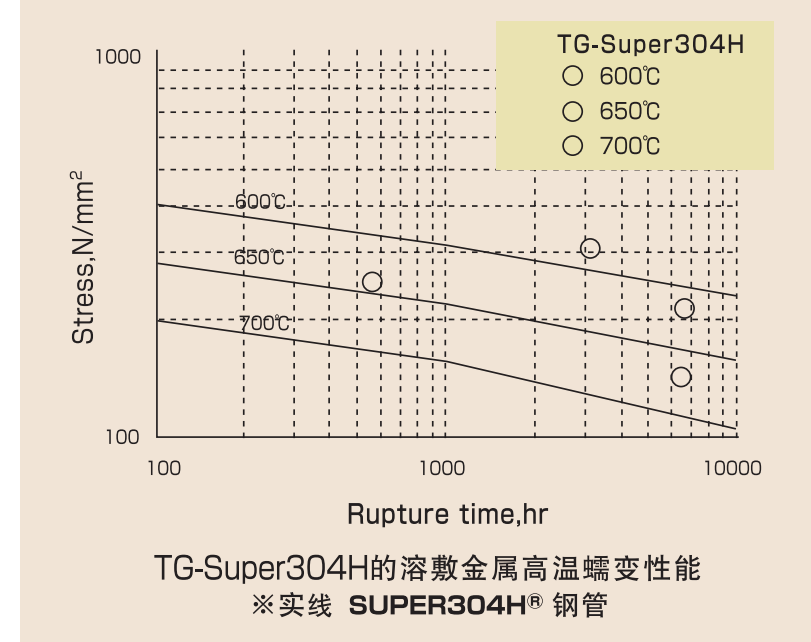
钢种 / 钢种标准 Metal/Metal Standard	焊接方法 Process	牌 号 Product	标 准 ASME / AWS	电源极性 Polarity
9Cr-1Mo-Nb-V钢 ASTM A335 Gr.P91	SAW (Flux/Wire)	TRUSTARC™ PF-200S / TRUSTARC™ US-9Cb	SFA / A 5.23 F10PZ-EG-G	AC or DCEP
		TRUSTARC™ PF-90B9 / TRUSTARC™ US-90B9	SFA / A 5.23 F9PZ-EB9-B9	DCEP
	SMAW	TRUSTARC™ CM-9Cb	SFA / A 5.5 E9016-G	AC or DCEP
		TRUSTARC™ CM-96B9	SFA / A 5.5 E9016-B9	AC or DCEP
	GTAW	TRUSTARC™ TG-S9Cb	SFA / A 5.28 ER90S-G	DCEN
		TRUSTARC™ TG-S90B9	SFA / A 5.28 ER90S-B9	
9Cr-W-Nb-V钢 ASTM A335 Gr.P92  12Cr-W-Nb-V钢 ASTM A335 Gr.P122	SAW (Flux/Wire)	TRUSTARC™ PF-200S / TRUSTARC™ US-12CRSD	—	DCEP
	SMAW	TRUSTARC™ CR-12S	—	AC or DCEP
	GTAW	TRUSTARC™ TG-S12CRS	—	DCEN



### 奥氏体耐热钢用焊接材料 / Welding materials for austenitic heat-resistant stainless steel

用于奥氏体系列超々临界锅炉钢管的焊接材料

牌 号 Product	钢 管 Applicable base metal	焊接种类 Type of filler metal	焊材成分 Chemistry of filler metal
PREMIARC™ <b>NEW</b> TG-Super304H	SUPER304H® ASTM A213 S30432, 火SUS304J1HTB	Filler wire for GTAW	19Cr-16Ni-3Cu-3Mn-2W -0.5Nb-0.2N-0.1C
PREMIARC™ NC-B1AS	TEMPALOY® AA-1 ASTM A213 S30434, 火SUS321J2HTB	Covered electrode for SMAW	19Cr-14Ni-3Cu-2.4Mo -1.6Mn-0.4Nb-0.13C
PREMIARC™ TG-S1AS		Filler wire for GTAW	
PREMIARC™ NC-B3A	TEMPALOY® A-3 ASTM A213 S30942, 火SUS309J4HTB	Covered electrode for SMAW	22r-16Ni-1.4Mn -0.6Nb-0.13N
PREMIARC™ TG-S3A		Filler wire for GTAW	



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