

压力容器用焊接材料 Welding Materials for Pressure Vessel

领先世界的产品和技术

内层堆焊用焊接材料 / Welding materials for overlay welding

| 钢种 Metal | 焊接方法 Process | 电源极性 Polarity | 牌号 Product | 标准 ASME / AWS |
|---------------|--------------------|------------------|------------------------------|----------------------------|
| 1.25Cr-0.5Mo钢 | SAW (Flux/Wire) | DCEP | TRUSTARC™ PF-200D / US-511ND | SFA / A5.23 F8P2-EG-B2 |
| | SMAW | DCEP | TRUSTARC™ CM-A96MBD / CM-A96 | SFA / A5.5 E8016-B2 |
| | GTAW | DCEN | TRUSTARC™ TG-S1CM | SFA / A5.28 ER80S-G |
| 2.25Cr-1Mo钢 | SAW (Flux/Wire) | DCEP | TRUSTARC™ PF-200D / US-521S | SFA / A5.23 F9P2-EG-B3 |
| | SMAW | DCEP | TRUSTARC™ CM-A106ND | SFA / A5.5 E9016-B3 |
| | GTAW | DCEN | TRUSTARC™ TG-S2CM | SFA / A5.28 ER90S-G |
| 2.25Cr-1Mo-V钢 | SAW (Flux/Wire) | AC | TRUSTARC™ PF-500 / US-521H | (ASME Sec.VIII Div.2-2007) |
| | SMAW | DCEP | TRUSTARC™ CM-A106HD | (ASME Sec.VIII Div.2-2007) |
| | GTAW | DCEN | TRUSTARC™ TG-S2CMH | (ASME Sec.VIII Div.2-2007) |

应用范围 / Application



石油精炼相关设备

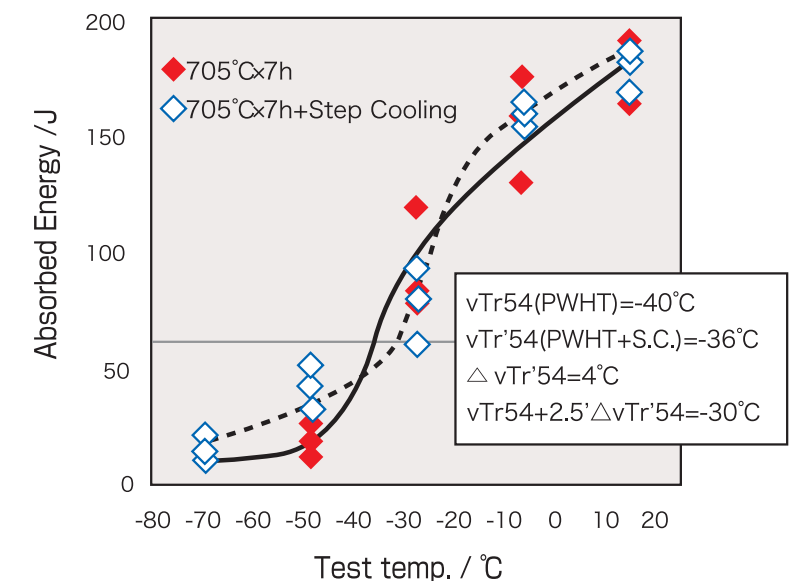
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| 钢种 Metal | 层数 Layer | 埋弧焊 SAW | 电渣焊 ESW |
|-------------|-------------|-------------------------------|--------------------------------|
| 316系 | 第一层 | — | PREMIARC™ PF-B7FK / US-B309L |
| | 第二层 | — | PREMIARC™ PF-B7FK / US-B316EL |
| 317系 | 第一层 | — | PREMIARC™ PF-B7FK / US-B309L |
| | 第二层 | — | PREMIARC™ PF-B7FK / US-B317L |
| 347系 | 第一层 | PREMIARC™ PF-B1FP / US-B347LP | PREMIARC™ PF-B7FK / US-B309LCb |
| | 第二层 | PREMIARC™ PF-B1FK / US-B347LD | PREMIARC™ PF-B7FK / US-B347LD |



PF-B7FK / US-B309LCb单层堆焊实例 / Overlay welding with PF-B7FK / US-B309LCb



PF-500/US-521H 焊缝金属回火脆化试验结果
Temper embrittlement property of PF-500/US-521H