

PipeMark 610

相當規格:

AWS A5.1 E6010

EN ISO 2560-A-E 38 3 C 21

特性與用途:

PipeMark 610 是立下及立上、直流(DC+及 DC-)專用的纖維系鐸條，適用於大型管件、壓力管件、油槽以及鍋爐的鐸接，具有優異的操作性，尤其是打底部分更能顯示出良好的滲透性。建議打底使用 DC-，而填充覆面使用 DC+更能發揮效果。電弧穩定性良好及鐸渣剝離性佳。

注意事項:

(1) 母材表面的水份、銹漬、油污、要充分去除。

(2) 鐸條使用前不允許再乾燥。

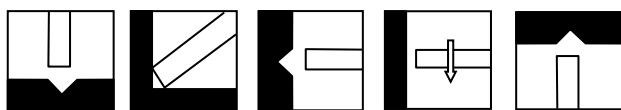
鐸道化學成份之一例(wt%) :

	C	Mn	Si	P	S
AWS	≤0.20	≤1.20	≤1.00	-	-
EN ISO	≤0.20	≤1.20	≤1.00	-	-
例值	0.12	0.5	0.15	0.015	0.010

鐸道機械性質之一例 :

	降伏強度 MPa(ksi)	抗拉強度 MPa(ksi)	伸長率 %	衝擊值 J (ft-lbf) -30°C (-20°F)
AWS	≥330(48)	≥430(60)	≥22	≥27(20)
EN ISO	≥330(48)	≥430(60)	≥22	≥27(20)
例值	500(73)	580(84)	22	40(30)

鐸接位置 :



適用電流範圍 : (DC±)

直徑 (mm)	2.4	2.6	3.2	4.0	4.8
長度(mm)	350		350	350	350
電流範圍	50-70		60-100	90-140	140-200

適用母材 :

EN: S235JR, S275JR, S235J2G3, S275J2G3, S355J2G3, P235GH, P265GH, P355T1, P235T2-P335T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH. Root pass up to L555NB, L555MB

API 5 L: A, B, X42, X46, X52, X56. Root pass up to X80.

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