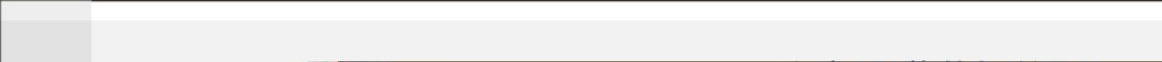

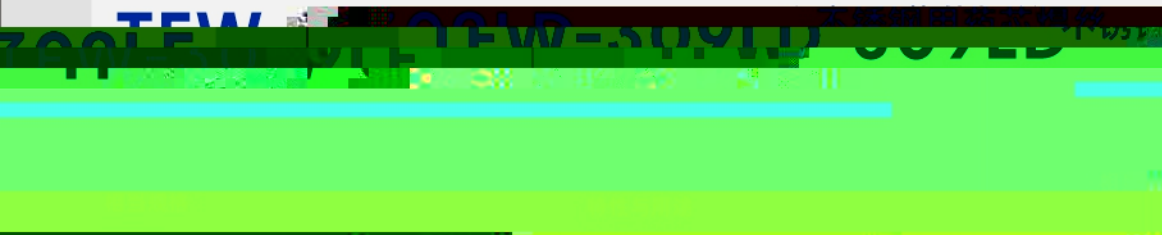

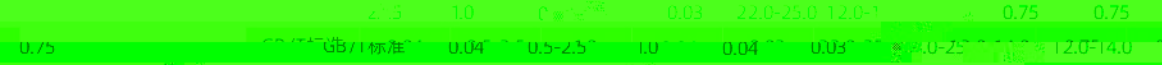

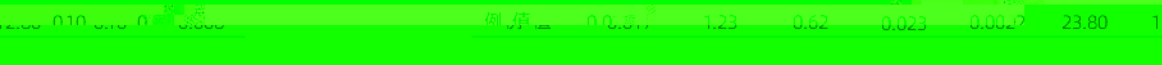

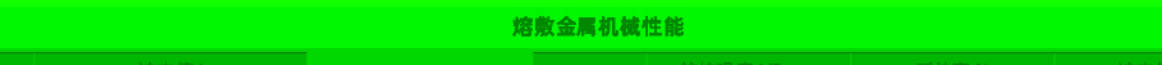

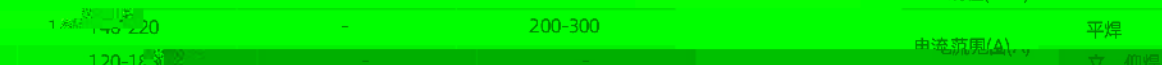

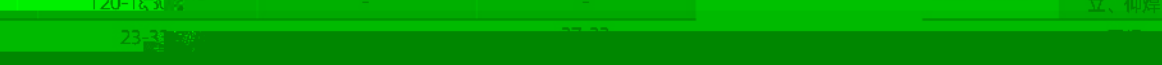

TEW-309LD

	2.5	1.0	[illegible]	0.03	22.0-25.0	12.0-1		0.75	0.75
GB/T标准	0.04	0.5-2.5	1.0	0.04	0.03	[illegible]0-25	12.0-14.0	0.75	
例 值	[illegible]	1.23	0.62	0.023	[illegible]	23.80	1		

熔敷金属机械性能

	抗拉强度 MPa	延伸率 %	冲击值
AWS	[illegible]20	>30	-
GB/T标准	≥520	≥25	-
例 值	583	42	-

适用焊[illegible]

推荐焊接参数：(DCEP)

线径(mm)		1.2	1.4	1.6
电流范围(A)	平焊	140-220	-	200-300
	立、仰焊	120-18[illegible]	-	-
		23-3[illegible]		27-33