焊剂 焊丝 [illegible]

TFS-30[illegible]/TW-309L

艺注意事项之外还使用注意事项[illegible]

焊丝化学[illegible] (wt%)

[illegible] GB/T 29713	[illegible]	C	Mn	Si	P	S	Cr	Ni	Mo	Cu
	AWS标准	0.03	1.0-2.5	0.30-0.65	0.03	0.03	23.0-25.0	12.0-14.0	0.75	0.75
TW-309L	ER 309L S309L	[illegible]	[illegible]	1.0-2.5	0.65	0.03	0.03	[illegible]	[illegible]	[illegible]

AWS A5.39	[illegible]	[illegible]	MPa	%	冲击值 J -110°C	-196°C	侧向膨胀量 mm	[illegible]
		GB/T标准	≥510	≥25	-	-	-	
S F309L FB S309L	[illegible] 9L/309L	AWS标准	[illegible]	[illegible]	-	≥27	≥0.38	S F308L FB S3
		例值	545	38	60	35	0.43	