

TOKO TECHNOLOGY(WUXI) CO.,LTD

TOKO®

收货单位 Customer: X TECH CORPORATION LTD

证书号 Certificate: TOKO20220806F

日期 Date: 2022-08-06

牌号 NO.	执行标准 Executed standard		焊剂型号 Model of fluxes		目数 Mesh numbers		批号 Lot no.	重量 Weight			
SJ101	GB/T5293-2018 NB/T 47018.4-2011		S49S2FB-SU34		10-60		20220728	1000 KGS			
焊剂参考成分 Typical compositions of fluxes in %:											
SiO ₂ +TiO ₂	MnO+Al ₂ O ₃	CaO+MgO	CaF ₂	S	P	H ₂ O	杂质 Impurity	焊缝 X 探伤 X-Ray			
24	21	30	20.5	0.022	0.021	0.03	0.03	I			
熔敷金属力学性能 Mechanical properties of deposited metal											
焊剂-焊丝组合 Flux + Welding Wire SJ101+EH11K	C	Si	Mn	Cr	Ni	S	P	抗拉强度 σ_b Mpa Tensile strength	屈服强度 σ_s Mpa Yield Strength	伸长率 δ % Elongation	冲击吸收功, J Ipack Energy, J
								415-550	≥330	≥22	-20°C . ≥27
实测值 Test value	0.08	0.51	0.87	-	-	0.012	0.015	498	375	29.5	78
TOKO TECHNOLOGY(WUXI) CO.,LTD Tel: (+86)510-8359 7138 Email: office@tokoc.com Website: www.tokoc.com/welding.htm						注意事项 Remarks: 焊前须经 300-350°C左右烘培二小时. Flux Need to be baked for 2 hours at around 300-350°C before welding. 焊接处须清除铁锈、油污, 水分等杂质. Removal of rust,oil,water,impurities etc.in weld-areas.					

