

# TOKO TECHNOLOGY(WUXI) CO.,LTD

**TOKO®**

收货单位 Customer:

证书号 Certificate mark: TOKO20211103F

日期 Date: 2021-11-03

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						
<b>HJ107</b>	GB/T17854-1999	F316L-H0Cr19Ni12Mo2	10-40	1636	15 Tons						
焊剂参考成分 Typical compositions of fluxes in %:											
SiO <sub>2</sub> +TiO <sub>2</sub>	MnO+Al <sub>2</sub> O <sub>3</sub>	CaO+MgO	CaF <sub>2</sub>	S	P	H <sub>2</sub> O	杂质 Impurity	焊缝 X 探伤 X-Ray			
29.5	24.6	19.4	20.5	0.022	0.023	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 HJ107+H0Cr19Ni12 Mo2	C	Si	Mn	Cr	Ni	S	P	抗拉强度σ <sub>b</sub> Mpa	屈服强度σ <sub>s</sub> Mpa	伸长率 δ <sub>5</sub> %	冲击吸收功, J
								>520	≥330	>25	-20°C. ≥27
实测值 Test value	0.07	0.48	1.86	19.2	12.0	0.02	0.02	559		29	78.0
TOKO TECHNOLOGY(WUXI) CO.,LTD TEL: (+86)510-8359 7138 Email: <a href="mailto:office@tokoc.com">office@tokoc.com</a> Website: <a href="http://www.tokoc.com/welding.htm">www.tokoc.com/welding.htm</a>						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.					
											