

TOKO TECHNOLOGY (WUXI) CO., LTD

TOKO®

收货单位 Customer:

证书号 Certificate: TOKO20200704F

日期 Date: 2020年07月04日

牌号 No.	执行标准 Executed standard	焊剂型号 Model of fluxes	目数 Mesh No.	批号 Lot no. 0704021	重量 Weight		
HJ260	GB/T17854-1999	F308-HOCr21Ni10	10-40		10 Tons		
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
29.88	22.44	21.2	21.44	0.02	0.025	0.030	0.1
熔敷金属力学性能 Mechanical properties of deposited metal							
试验项目 Test items	抗拉强度σ _b Mpa Tensile strength	屈服强度σ _s Mpa Yield strength	伸长率δ ₅ % Elongation	冲击吸收功, J Impact energy, J	X探伤 X-Ray		
保证值 Standard value	480-650	≥ 400	≥22	0°C. ≥27	I		
实测值 Test value	544.0	423.0	30.0	98.0	I		
注意事项 Remarks: 焊前须经 250-300°C左右烘培二小时. Fluxes need to be baked for 2 hours around 250-300°C before welding. 焊接处须清除钢锈、油污、水分等杂质. Removal of rust,oil,water,impurities etc.in weld-areas.			TOKO TECHNOLOGY(WUXI) CO.,LTD Tel: (+86)510-8359 7138 Email: office@tokoc.com Website: www.tokoc.com/welding.htm				

