

TOKO TECHNOLOGY(WUXI) CO.,LTD



收货单位 Customer:

证书号 Certificate mark: TOKO20210816F

日期 Date: 2021-08-16

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>SJ301</b>	GB/T5293-2018 NB/T 47018.4-2017	F7A2-H08A	10-60	2230	22 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
32.2	31.99	22	7.6	0.022	0.021	0.03	0.04	I

熔敷金属力学性能 Mechanical properties of deposited metal

焊剂-焊丝组合 Flux + Welding Wire Sj501+EM12K	C	Si	Mn	Cr	Ni	S	P	抗拉强度 $\sigma_b$ Mpa Tensile strength	屈服强度 $\sigma_s$ Mpa Yield Strength	伸长率 $\delta$ % Elongation	冲击吸收功, J Ipack Energy , J
实测值 Test value	0.08	0.52	0.87	-	-	0.022	0.025	415-550	$\geq 330$	$\geq 22$	-20°C. $\geq 27$

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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.