

TOKO TECHNOLOGY(WUXI) CO.,LTD

TOKO®

收货单位 Customer: ----- LNG EQUIPMENT LTD.

证书号 Certificate: TOKO20250218F

日期 Date: 2025-02-18

牌号 NO.	执行标准 Executed standard		焊剂型号 Model of fluxes		目数 Mesh Numbers				重量 Weight		
SJ101G	GB/T5293-2018 NB/T 47018.4-2022		F5A4-H10Mn2		10-60				15000.00 KGS		
焊剂参考成分 Typical compositions of fluxes in %:											
SiO2+TiO2	MnO+Al2O3	CaO+ MgO	CaF2	S	P	H2O	杂质 Impurity	焊缝 X 探伤 X-Ray			
18-25	23-30	28-35	16-25	≤00.03	≤0.03	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 SJ501+EM12K	C	Si	Mn	Cr	Ni	S	P	抗拉强度 σb Mpa Tensile Strength	屈服强度 σs Mpa Yield Strength	伸长率 δ % Elongation	冲击吸收功, J Ipack Energy, J
								415-550	≥400	≥22	-40℃ . ≥27
实测值 Test value	0.08	0.52	0.87	-	-	0.012	0.015	550	439	29.5	78
TOKO TECHNOLOGY(WUXI) CO.,LTD Tel: (+86)510-8359 7138 Email: office@tokoc.com Website: www.weldrods.com/aws.htm						注意事项 Remarks: 焊前须经 300-350℃左右烘培二小时. Flux Need to be baked for 2 hours at around 300-350℃ 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.					