热强钢用

DC+/AC双极与AC/AC双极焊接，并在[illegible]焊缝焊

搭配线材	AWS A5.23	GB/T 12[illegible]	[illegible]	Si	Mn	P	S	Cr	Mo	V	Cu	X factor
[illegible] ppm	TSW-E23V	F9P2-EGR-G	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
			AWS标准	0.05-0.15	≤0.80	[illegible]	≤0.01	≤0.01	2[illegible]0-2.50	0.90-1.20	≤[illegible]	≤15ppm
TSW-E23R	F9P2-EB3R-B3	[illegible]	GB/T标准	0.05-0.15	≤0.80	≤1.2	≤0.01	≤0.01	2.00-2.50	0.90-1.20	≤0.35	[illegible]

例值	515	600	28
AWS标准	≥540	62[illegible]	[illegible]60