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Honest Velvet, Sharing Comfort!

江苏维特高科焊业有限公司

Jiangsu Velvet Hi-tech Welding Consumables Co.,LTD

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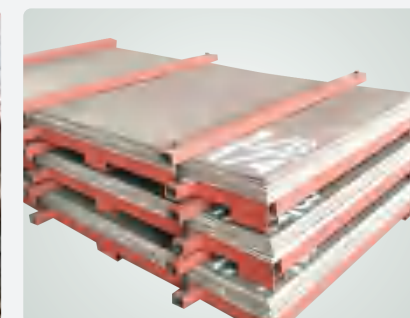


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企业简介

江苏维特高科焊业有限公司是维特集团旗下高性能药芯焊丝和耐磨板的专业生产企业，同时致力于为耐磨构件提供专业的在线、离线修复技术和服务。

本公司具备完善的质量管理体系，通过了ISO9001: 2015国际质量管理体系的认证，主要产品获得中国船级社 (CCS)、挪威船级社 (DNV)、英国劳埃德船级社 (LR)、美国验船协会 (ABS)、法国船级社 (BV) 的3Y级和4Y级认证。人员知识结构合理，具备坚实的冶金背景和实际经验，有教授级高工3人 (2位享有国务院特殊津贴)、博士4人 (2位海外留学归国)、工程师9人，硕士研究生以上学历人数占30%。

本公司已投资1.8亿元，目前已拥有7条国内领先的药芯焊丝生产线，具备碳钢、不锈钢、耐热、耐磨等多品种药芯焊丝的生产研发检测能力，年生产能力达到1.5万吨。公司技术研发部配备多通道直读光谱仪、色谱扩散氢测试仪、氮氧分析仪、高频红外碳硫仪等专业焊接材料性能检验分析设备。

本公司与中国钢研科技集团公司、中国矿业大学、南京工程学院等科研院所合作研发，不断开发高端焊接材料和特种焊材、延伸耐磨板产业链，为船舶、海洋平台、钢结构、压力容器、化工冶金、电力、矿业、地下工程等行业制造部门提供高品质的焊接耗材和配套服务。

目前，本公司已在国内5大地区中心建成维特高科焊业办事处，完善销售服务网络，重点着力于产品的开发与推广，为众多客户提供专业的抗磨损解决方案。药芯焊丝、复合耐磨板产品出口澳大利亚、加拿大、韩国、泰国等国家，受到国外客户的一致认可。

江苏维特高科焊业有限公司真诚欢迎国内外客户选择维特产品，并成为我们永久的合作伙伴。

诚信维特，共创共享！



elvet



HONEST VELVET, SHARING COMFORT!

Company Profile

Jiangsu Velvet Hi-tech Welding Consumables Co.,LTD. is a professional manufacturer of high-performance flux-cored wire and wear-resistant plate of Velvet Group. It is also committed to providing professional online and offline repair technology and services for wear-resistant components.

The company has a sound quality management system, passed the ISO 9001: 2015 international quality management system certification, the main products obtained by China Classification Society (CCS), Norwegian Classification Society (DNV), Lloyd's Register of Shipping (Lr), American Institute of Surveyors (ABS), French Bureau of Shipping (BV) 3YS and 4YS level certification.

The personnel knowledge structure is reasonable, with a solid metallurgical background and practical experience, there are 3 professor-level senior engineers (2 enjoy the State Council Special allowance), 4 doctors (2 overseas students returning to China), 9 engineers, and the number of master's degree or above accounted for 30%.

The company has invested 180 million yuan, and now has 7 domestic leading cored wire production lines, with carbon steel, stainless steel, wear resistance and other varieties of flux cored wire production R&D and testing capabilities, the annual production capacity reached 15,000T. The company's technology research and development department is equipped with multi-channel direct reading spectrometer, chromatographic diffusion hydrogen tester, nitrogen oxide analyzer, high-frequency infrared carbon sulfur analyzer and other professional welding material performance inspection and analysis equipment.

The company cooperates with China Iron and Steel Technology Group Corporation, China University of Mining and Technology, Nanjing Institute of Engineering and other research institutes to develop high-end welding materials and special welding consumables. Extends the wear-resistant plate industry chain for ships, offshore platforms, steel structures, Pressure vessel, chemical metallurgy, electric power, mining, underground engineering and other industries to provide high-quality welding consumables and ancillary services.

At present, the company has built the Velvet High-Tech Welding Office in five major regional centers in China, perfecting the sales and service network, focusing on product development and promotion, providing professional anti-wear solutions for many customers. Flux cored wire, composite resistant Grinding plate products are exported to Australia, Canada, South Korea, Thailand and other countries, and are unanimously recognized by foreign customers.

Jiangsu Velvet Hi-tech Welding Consumables Co.,LTD. sincerely welcomes domestic and foreign customers to choose Witt products and become our permanent partner.

Honest Velvet, Sharing Comfort!



CCS



ABS



DNV



LR



BV



发展历程

Development path

2010

潘际銮院士亲笔题字
Academician Pan Jiluan's
autograph inscription

2012

研发实验中心建立
R&D experiment center
established

2014

复合耐磨板车间投产
Composite wear plate workshop
put into operation

2016

复合耐磨管道车间投产
Composite pipe workshop
put into operation

2011

特种药芯焊丝车间投产
Special flux cored wire workshop
put into operation

2013

再制造修复工程开始施工
Remanufacturing and
repairing works began
construction

2015

冷作制品车间投产
Cold work shop started
production

2017

产品、服务质量不断提高，远销海外
The quality of products and services
continues to improve and is exported
overseas.



技术研究

Technical Study



坚实的技术后盾、研发能力、先进的检测设备是生产高质量产品的重要保障，可满足客户不同环境和工况下的产品开发和生产，我公司为您提供专业的产品服务。



A solid technical support, R&D ability, advanced testing equipment is the important safeguards of high-quality products. It could meet the requirement for variety working conditions, also satisfy the customer through most scientific optimization programme.

品质管理

Quality Management

公司拥有全面的质量管理体系，从市场服务、原材料采购、检测入库、小试研发、计划安排、产品制造、入库检测、售后服务等各个环节紧密相扣，有效保证每一项产品的高质和每一份服务的高效。

The company has comprehensive and effective management. It also joins closely from the market service, materials purchase, testing before storage, exploratory development, arrangement, manufacturing and after-sales service, and effectively ensure high-quality projects, high efficiency completion.





药芯焊丝
主要产品介绍

诚信维特 共创共享

HONEST VELVET, SHARING COMFORT!

碳钢、低合金钢药芯焊丝产品系列
Carbon Steel, Low Alloy Steel Flux Cored Wire

牌号 Grade	执行标准 Standard	熔敷金属化学成分 Chemical Composition of Deposited Metal				熔敷金属力学性能 Mechanical Properties of Deposited Metal			应用 Applicaton
VTE711	GB/T10045 E501T-1 AWS A5.20 E71T-1C	C : 0.05% P : 0.012%	Mn : 1.38%	Si : 0.45%	S : 0.008%	ReH : 480Mpa AKv : 129J (-20℃)	Rm : 565Mpa	A ₅ : 28%	适用于船舶、桥梁、机械制造、钢结构等的焊接。 Suitable for the welding of shipbuilding ,steel structures,bridges,etc.
VTE711Ni	GB/T10045 E501T-1L AWS A5.20 E71T-1CJ	C : 0.04% P : 0.015%	Mn : 1.28% Ni : 0.40%	Si : 0.38%	S : 0.008%	ReH : 510Mpa AKv : 98J (-40℃)	Rm : 589Mpa	A ₅ : 27%	适用于海洋平台、船舶、桥梁、机械制造、钢结构等的焊接。 Suitable for the welding of shipbuilding ,steel structures,bridges,etc.
VTJ507(Q)	GB/T10045 E500T-5 AWS A5.20 E70T-5C	C : 0.05% P : 0.015%	Mn : 1.42%	Si : 0.53%	S : 0.008%	ReH : 460Mpa AKv : 98J (-40℃)	Rm : 550Mpa	A ₅ : 30%	适用于抗裂性较高的高强钢结构等的焊接。 Suitable for the welding of high strength steel with high crack resistance.
VTJ602(Q)	GB/T17493 E621T1-K2C AWS A5.29 E91T1-K2C	C : 0.05% P : 0.013%	Mn : 1.45% Ni : 1.03%	Si : 0.40% Mo : 0.13%	S : 0.007%	ReH : 560Mpa AKv : 98J (-40℃)	Rm : 650Mpa	A ₅ : 30%	适用于 620MPa 级高强钢结构的焊接。 Suitable for the welding of high strength steel with yield strength of 620MPa.
VTJ607(Q)	GB/T17493 E620T5-K2M AWS A5.29 E90T5-K2M	C : 0.06% P : 0.016%	Mn : 1.25% Ni : 1.53%	Si : 0.45% Ti : 0.03%	S : 0.009%	ReH : 585Mpa AKv : 85J (-50℃)	Rm : 670Mpa	A ₅ : 23%	适用于抗裂性较高的 620Mpa 级高强钢结构等的焊接。 Suitable for the welding of high strength steel with high crack resistance and yield strength of 620MPa.
VTJ707(Q)	GB/T17493 E690T5-K3M AWS A5.29 E100T5-K3M	C : 0.06% P : 0.016%	Mn : 1.71% Ni : 2.23%	Si : 0.42% Mo : 0.40%	S : 0.009% Cu : 0.15%	ReH : 690Mpa AKv : 80J (-50℃)	Rm : 760Mpa	A ₅ : 21%	适用于抗裂性较高的 690Mpa 级高强钢结构等的焊接。 Suitable for the welding of high strength steel with high crack resistance and yield strength of 690MPa.
VTJ502CrNiCu(Q)	TB/T 2374 E71T1-GC AWS A5.29 E71T1-GC	C : 0.05% P : 0.015%	Mn : 1.18% Ni : 0.45%	Si : 0.48% Cr : 0.37%	S : 0.009% Cu : 0.41%	ReH : 520Mpa AKv : 98J (-30℃)	Rm : 590Mpa	A ₅ : 26%	适用于耐大气腐蚀的 490Mpa 级高强钢结构等的焊接。 Suitable for the welding of atmospheric corrosion resistant steel with yield strength of 490MPa.
VTJ502Ni1(Q)	GB/T17493 E551T1-Ni1C AWS A5.29 E81T1-Ni1C	C : 0.05% P : 0.012%	Mn : 1.16% Ni : 0.88%	Si : 0.35%	S : 0.009%	ReH : 560Mpa AKv : 78J (-50℃)	Rm : 620Mpa	A ₅ : 27%	适用于 550MPa 级低温高强钢的焊接。 Suitable for the welding of 550MPa grade low temperature resistant high strength steel.
VTJ502Ni2(Q)	GB/T17493 E551T1-Ni2C AWS A5.29 E81T1-Ni2C	C : 0.05% P : 0.012%	Mn : 1.18% Ni : 1.58%	Si : 0.48%	S : 0.009%	ReH : 550Mpa AKv : 70J (-60℃)	Rm : 625Mpa	A ₅ : 27%	适用于 550MPa 级低温高强钢的焊接。 Suitable for the welding of 550MPa grade low temperature resistant high strength steel.
VTR302(Q)	GB/T17493 E551T1-B2C AWS A5.29 E81T1-B2C	C : 0.05% P : 0.013%	Mn : 1.36% Cr : 1.25%	Si : 0.48% Mo : 0.48%	S : 0.007%	ReH : 550Mpa AKv : 40J (室温)	Rm : 633Mpa	A ₅ : 25%	适用于 1%Cr-0.5%Mo 和 1.25%Cr-0.5%Mo 耐热钢的焊接。 Suitable for the welding of 1% Cr-0.5% Mo and 1.25% Cr-0.5% Mo heat-resistant steel.
VTR307(Q)	GB/T17493 E550T5-B2C AWS A5.29 E80T5-B2C	C : 0.05% P : 0.015%	Mn : 1.38% Cr : 1.28%	Si : 0.49% Mo : 0.49%	S : 0.009%	ReH : 560Mpa AKv : 42J (室温)	Rm : 628Mpa	A ₅ : 24%	适用于 1%Cr-0.5%Mo 和 1.25%Cr-0.5%Mo 耐热钢的焊接。 Suitable for the welding of 1% Cr-0.5% Mo and 1.25% Cr-0.5% Mo heat-resistant steel.
VTR312(Q)	—	C : 0.06% P : 0.015%	Mn : 1.12% Cr : 1.25%	Si : 0.52% Mo : 0.48%	S : 0.008% V:0.12%	ReH : 540Mpa AKv : 95J (室温)	Rm : 625Mpa	A ₅ : 22%	适用于 12CrMoV 珠光体耐热钢的焊接。 Suitable for the welding of 12CrMoV pearlite heat-resistant steel.
VTR317(Q)	—	C : 0.06% P : 0.015%	Mn : 1.15% Cr : 1.26%	Si : 0.54% Mo : 0.47%	S : 0.008% V:0.13%	ReH : 580Mpa AKv : 88J (室温)	Rm : 628Mpa	A ₅ : 23%	适用于 12CrMoV 珠光体耐热钢的焊接。 Suitable for the welding of 12CrMoV pearlite heat-resistant steel.
VTR402(Q)	GB/T17493 E621T1-B3CL AWS A5.29 E91T1-B3CL	C : 0.06% P : 0.013%	Mn : 1.18% Cr : 2.25%	Si : 0.55% Mo : 0.97%	S : 0.009%	ReH : 608Mpa AKv : 85J (室温)	Rm : 688Mpa	A ₅ : 22%	适用于 2.25%Cr-1%Mo 耐热钢的焊接。 Suitable for the welding of 2.25% Cr-1% Mo heat-resistant steel.
VTR502(Q)	GB/T17493 E551T1-B8C AWSA5.29 E81T1-B8C	C : 0.07% P : 0.016%	Mn : 1.20% Cr : 5.25%	Si : 0.53% Mo : 0.87%	S : 0.008%	ReH : 523Mpa AKv : —	Rm : 620Mpa	A ₅ : 22%	适用于 5%Cr-0.5%Mo 耐热钢的焊接。 Suitable for the welding of 5% Cr-0.5% Mo heat-resistant steel.

* 上表中所示的产品成分及性能数据均系该产品的典型例值



牌号 Grade	执行标准 Standard	熔敷金属化学成分 Chemical Composition of Deposited Metal	熔敷金属力学性能 Mechanical Properties of Deposited Metal	应用 Applicaton
VTA308L(Q)	GB/T17853 E308LT1-1 AWS A5.22 E308LT1-1	C : 0.03% Mn : 1.41% Si : 0.35% S : 0.002% P : 0.018% Cr : 19.50% Ni : 9.70%	Rm : 560Mpa A5: 43%	适用于超低碳 18%Cr-8%Ni 不锈钢的焊接。 Suitable for the welding of ultra-low carbon 18% Cr-8% Ni stainless steel.
VTA309L(Q)	GB/T17853 E309LT1-1 AWS A5.22 E309LT1-1	C : 0.03% Mn : 1.40% Si : 0.36% S : 0.002% P : 0.018% Cr : 23.90% Ni : 12.60%	Rm : 585Mpa A5: 42%	适用于超低碳 22%Cr-12%Ni 不锈钢的焊接。 Suitable forthe welding of ultra-low carbon 22% Cr-12% Ni stainless steel.
VTA309MoL(Q)	GB/T17853 E309LMoT1-1 AWS A5.22 E309LMoT1-1	C : 0.03% Mn : 1.42% Si : 0.35% S : 0.002% P : 0.018% Cr : 23.80% Ni : 12.80% Mo : 2.45%	Rm : 580Mpa A5: 39%	适用于异种钢或过渡层的焊接。 Suitable for the welding dissimilar steel or transition layer.
VTA310(Q)	GB/T17853 E310T1-1 AWS A5.22 E310T1-1	C : 0.12% Mn : 1.52% Si : 0.55% S : 0.002% P : 0.018% Cr : 25.50% Ni : 20.60%	Rm : 635Mpa A5: 32%	适用于石油化工、热处理炉、炉底管等耐热钢的焊接。 Suitable for the welding of heat-resistant steels such as petrochemical industry, heat treatment furnaces, furnace bottom tubes, etc.
VTA312(Q)	GB/T17853 E312T1-1 AWS A5.22 E312T1-1	C : 0.04% Mn : 1.51% Si : 0.45% S : 0.002% P : 0.018% Cr : 29.50% Ni : 9.50% Mo : 0.48%	Rm : 650Mpa A5: 28%	适用于高镍合金与其他金属的焊接。 Suitable for the welding high nickel alloys with other metals.
VTA316L(Q)	GB/T17853 E316LT1-1 AWS A5.22 E316LT1-1	C : 0.03% Mn : 1.38% Si : 0.38% S : 0.002% P : 0.018% Cr : 19.50% Ni : 12.80% Mo : 2.48%	Rm : 578Mpa A5: 41%	适用于超低碳 18%Cr-12%Ni 不锈钢的焊接。 Suitable for the welding of ultra-low carbon 18% Cr-12% Ni stainless steel.
VTA317L(Q)	GB/T17853 E317LT1-1 AWS A5.22 E317LT1-1	C : 0.03% Mn : 1.35% Si : 0.40% S : 0.002% P : 0.018% Cr : 19.35% Ni : 12.50% Mo : 3.50%	Rm : 582Mpa A5: 40%	适用于化肥、尿素或储存设备高耐腐蚀结构的焊接。 Suitable for the welding fertilizer, urea or storage equipment with high corrosion resistance structure.
VTA347L(Q)	GB/T17853 E317LT1-1 AWS A5.22 E317LT1-1	C : 0.03% Mn : 1.32% Si : 0.42% S : 0.002% P : 0.018% Cr : 18.85% Ni : 10.50% Nb : 0.52%	Rm : 600Mpa A5: 42%	适用于 321 型、347 型不锈钢的焊接。 Suitable for the welding of 321 and 347 stainless steel
VTA410(Q)	GB/T17853 E410T1-1 AWS A5.22 E410T1-1	C : 0.05% Mn : 1.22% Si : 0.45% S : 0.002% P : 0.018% Cr : 13.45%	Rm : — A5: —	适用于阀门、化工设备等耐蚀部位的焊接。 Suitable for the welding of corrosion-resistant parts such as valves and chemical equipment.
VTA430(Q)	GB/T17853 E430T1-1 AWS A5.22 E430T1-1	C : 0.06% Mn : 1.30% Si : 0.42% S : 0.002% P : 0.018% Cr : 17.25%	Rm : — A5: —	适用于阀门、化工设备、气门座等耐蚀部位的焊接。 Suitable for the welding of corrosion-resistant parts such as valves, chemical equipment and valve seats.
VTA2209(Q)	GB/T17853 E2209T0-1/4 AWS A5.22 E2209T0-1/4	C : 0.04% Mn : 1.42% Si : 0.40% S : 0.002% P : 0.018% Cr : 22.80% Ni : 8.50% Mo : 3.20% Cu : 0.25%	Rm : 705Mpa A5: 22%	适用于化学品、各类容器所使用的的双相不锈钢的焊接。 Suitable for the welding of duplex stainless steel used in chemicals and various containers.
VTA2553(Q)	GB/T17853 E2553T0-1/4 AWS A5.22 E2553T0-1/4	C : 0.04% Mn : 1.28% Si : 0.42% S : 0.002% P : 0.018%Cr : 25.50% Ni : 9.50% Mo : 3.50% Cu : 2.10%	Rm : 785Mpa A5: 18%	适用于 25%Cr 双相不锈钢的焊接。 Suitable for the welding of 25% Cr duplex stainless steel.

* 上表中所示的产品成分及性能数据均系该产品的典型例值



牌号 Grade	执行标准 Standard	熔敷金属化学成分 Chemical Composition of Deposited Metal	熔敷金属力学性能 Mechanical Properties of Deposited Metal	应用 Applicaton
VTD101Mo-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 B	硬度 HRC>60 (焊态)	适用于辊压机挤压辊、立磨磨辊、磨盘等的堆焊修复。 Suitable for overlay welding repair of squeeze rolls, vertical grinding rolls, grinding discs of roller presses, etc.
VTD101Mo(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 B	硬度 HRC>60 (焊态)	适用于辊压机挤压辊、立磨磨辊、磨盘等的堆焊修复。 Suitable for overlay welding repair of squeeze rolls, vertical grinding rolls, grinding discs of roller presses, etc.
VTD101MoNb-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD101MoNb(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD101MoV-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 V 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD101MoV(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 V 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD101W-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 W 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD101W(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 W 、 B	硬度 HRC>62 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD103-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb 、 B	硬度 HRC>62 (焊态)	适用于辊压机挤压辊、立磨磨辊、磨盘等的堆焊修复。 Suitable for overlay welding repair of squeeze rolls, vertical grinding rolls, grinding discs of roller presses, etc.
VTD103(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb 、 B	硬度 HRC>62 (焊态)	适用于辊压机挤压辊、立磨磨辊、磨盘等的堆焊修复。 Suitable for overlay welding repair of squeeze rolls, vertical grinding rolls, grinding discs of roller presses, etc.
VTD104Ni(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态)	适用于低合金钢零部件的堆焊修复或作过渡层填充使用。 Suitable for surfacing repair of low alloy steel parts or as a transition
VTD14(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr	硬度 HRC<25 (焊态)	适用于低合金钢零部件的堆焊修复或作过渡层填充使用。 Suitable for surfacing repair of low alloy steel parts or as a transition layer filling.



牌号 Grade	执行标准 Standard	熔敷金属化学成分 Chemical Composition of Deposited Metal	熔敷金属力学性能 Mechanical Properties of Deposited Metal	应用 Applicaton
VTD1996-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>45 (加工硬化)	适用于奥氏体锰钢表面堆焊或作为过渡层。 Suitable for surfacing welding of austenitic manganese steel or as a transition layer.
VTD1996(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>45 (加工硬化)	适用于奥氏体锰钢表面堆焊或作为过渡层。 Suitable for surfacing welding of austenitic manganese steel or as a transition layer.
VTD212(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC>50 (焊态)	适用于堆焊热锻模、挤压模、轧辊等金属件磨损件。 Suitable for surfacing hot metal forging dies, extrusion dies, rolls and other metal parts.
VTD224A(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 V	硬度 HRC>50 (焊态)	适用于热轧支撑辊、导向辊、矫直辊的堆焊修复。 Suitable for surfacing repair of hot-rolled support rolls, guide rolls and straightening rolls.
VTD224B(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 V 、 W	硬度 HRC>50 (焊态)	适用于热轧支撑辊、导向辊、矫直辊的堆焊修复。 Suitable for surfacing repair of hot-rolled support rolls, guide rolls and straightening rolls.
VTD250(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC<30 (焊态)	适用于堆焊金属间磨损件以及部件打底修复。 Suitable for surfacing welding metal wear parts and repairing of parts.
VTD260-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr	硬度 HRC>58(焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD260(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr	硬度 HRC>58 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD260Mo-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC>58 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD260Mo(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC>58 (焊态)	适用于筛板、溜槽、热尘传输管、铲斗、衬板等的堆焊修复。 Suitable for surfacing repair of sieve plate, chute, hot dust transfer pipe, bucket, liner, etc.
VTD350(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 30~40 (焊态)	适用于堆焊金属间磨损件及轻度土砂磨损部件。 Suitable for surfacing welding metal wear parts and light sand wear parts.
VTD350(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 30~40 (焊态)	适用于堆焊金属间磨损件及轻度土砂磨损部件。 Suitable for surfacing welding metal wear parts and light sand wear parts.



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VTD37(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>45 (加工硬化)	适用于奥氏体锰钢表面堆焊或作为过渡层。 Suitable for surfacing welding of austenitic manganese steel or as a transition layer.
VTD37-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>45 (加工硬化)	适用于奥氏体锰钢表面堆焊或作为过渡层。 Suitable for surfacing welding of austenitic manganese steel or as a transition layer.
VTD390(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>48 (加工硬化)	适用于硬面堆焊过渡层焊接。 Suitable for hard surface surfacing welding.
VTD390-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>48 (加工硬化)	适用于硬面堆焊过渡层焊接。 Suitable for hard surface surfacing welding.
VTD397(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni 、 V	硬度 HRC 40~50 (焊态)	适用于中、大型机锻模下部和锤锻模的堆焊修复。 Suitable for surfacing repair of the lower part of the forging die and hammer forging die of medium and large machines.
VTD410(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni	硬度 HRC 35~45 (焊态)	适用于堆焊蒸汽轮机部件、离心泵叶片、安全阀等。 Suitable for surfacing of steam turbine components, centrifugal pump blades, safety valves, etc.
VTD410NiMo(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni	硬度 HRC 35~45 (焊态)	适用于水电站、阀门、连铸辊等耐磨耐蚀工况部件的堆焊修复。 Suitable for surfacing repair of wear-resistant and corrosion-resistant parts such as hydropower stations, valves, and continuous casting rolls.
VTD411(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni 、 Mo	硬度 HRC <25 (焊态)	适用于阀门、液压支架表面等耐腐蚀部位的堆焊修复。 Suitable for surfacing repair of corrosion-resistant parts such as the surface of valves and hydraulic supports.
VTD414N(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni 、 N	硬度 HRC 35~45 (焊态)	适用于连铸辊的堆焊修复。 Suitable for surfacing repair of continuous casting rolls.
VTD414D(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni 、 W 、 Co	硬度 HRC 35~45 (焊态)	适用于芯棒的堆焊修复。 Suitable for surfacing repair of mandrel.
VTD420NiMo(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Ni	硬度 HRC 45~55 (焊态)	适用于轻微腐蚀环境下的耐磨堆焊修复。 Suitable for wear-resistant surfacing repair in slightly corrosive environment.
VTD430(M)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr	硬度 HRC <20 (焊态)	适用于不锈钢复合钢的打底堆焊。 Suitable for underlaying and surfacing welding of stainless steel composite steel.



牌号 Grade	执行标准 Standard	熔敷金属化学成分 Chemical Composition of Deposited Metal	熔敷金属力学性能 Mechanical Properties of Deposited Metal	应用 Applicaton
VTD45(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 45~55 (焊态)	适用于冷轧支承辊、热轧工作辊的堆焊修复。 Suitable for surfacing repair of cold-rolled back-up rolls and hot-rolled work rolls.
VTD450(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 40~50 (焊态)	适用于耐土砂及耐金属间磨损部件的堆焊修复。 Suitable for surfacing repair of parts that are resistant to earth sand and wear between metals.
VTD507(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 30~45 (焊态)	适用于堆焊轴、过热蒸汽阀门等。 Suitable for surfacing shafts, superheated steam valves, etc.
VTD507-26(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 30~40 (焊态)	适用于堆焊轴、过热蒸汽阀门等。 Suitable for surfacing shafts, superheated steam valves, etc.
VTD507-50(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 40~50 (焊态)	适用于堆焊轴、过热蒸汽阀门等。 Suitable for surfacing shafts, superheated steam valves, etc.
VTD507-80(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni 、 Mo	硬度 HRC <25 (焊态)	适用于阀门、液压支架表面等耐腐蚀部位的堆焊修复。 Suitable for surfacing repair of corrosion-resistant parts such as the surface of valves and hydraulic supports.
VTD507Mo(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo	硬度 HRC 30~45 (焊态)	适用于堆焊工作温度低于 510℃的轴及阀门等。 Suitable for surfacing welding of shafts and valves with a working temperature below 510 ° C.
VTD507MoNb(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb	硬度 HRC 30~45 (焊态)	适用于堆焊工作温度低于 450℃的中低压阀门密封面。 Suitable for sealing surface of medium and low pressure valves whose welding working temperature is lower than 450 °C.
VTD547MoNb(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 Nb 、 Ni	硬度 HRC 30~45 (焊态)	适用于堆焊工作温度 600℃的高压阀门密封面。 Suitable for surfacing welding of high-pressure valves with a working temperature of 600 °C.
VTD600(Q)	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Mo 、 W 、 V	硬度 HRC >58 (焊态)	适用于耐土砂磨损的部件堆焊修复。 Suitable for surfacing repair of earth sand-resistant components.
AP-O	企业标准 Enterprise Standard	C 、 Mn 、 Si 、 Cr 、 Ni	硬度 HRC<25 (焊态) 硬度 HRC>48 (加工硬化)	适用于抗冲击部件的堆焊。 Suitable for surfacing welding of impact-resistant parts.
WC-O/M	企业标准 Enterprise Standard	大量碳化钨粒子 、 Ni 、 Co	硬度 HRC >62 (焊态)	适用于较高工作温度磨粒磨损工况下部件的堆焊。 Suitable for surfacing welding of components under high-temperature abrasive wear conditions.

WRPlate 系列抗磨损堆焊复合板

WRPlate series anti-wear overlay welding composite plate

WRPlate 系列抗磨损堆焊复合板是专供大面积磨损工况使用的板材产品，其基于塑韧性优良的普通低碳或低合金钢表面通过堆焊方法制备双金属复合高硬度抗磨损复合金属板材。WRPlate 系列抗磨损堆焊复合板硬度较高、抗磨损性能优异、环境适应性好。实际工况使用时，其基体提供抵抗外力的强度和塑性等综合性能，其耐磨层提供满足指定需求的抗磨损性能。

基于其抗磨损性能强的特点，广泛应用于冶金、电力、水泥、煤炭、玻璃等行业。WRPlate 系列抗磨损堆焊复合板主要分为通用性 G，抗冲击型 I 和耐高温型 H 三大类，其总厚度最小可以达到 5 毫米，最大可以达到 30 毫米；并可以根据客户的需要加工成满足不同工况要求的耐磨件。

本公司拥有经验丰富的耐磨材料研发工程师团队以及专业的复合耐磨钢板的生产加工工艺和国内先进高效的生产线，24 条全自动堆焊设备，产品的抗磨损性能、平整度、卷板变形能力等技术指标均为行业领先水平。江苏维特高科焊业有限公司必将不断优化耐磨层冶金成型技术为客户提供最佳的耐磨工况解决方案。

WRPlate series anti-wear surfacing composite board is a sheet product designed for large-area wear conditions. It is based on ordinary plastics with excellent toughness. The surface of the low-carbon or low-alloy steel is prepared by a surfacing method to prepare a bimetal composite high-hardness and wear-resistant composite metal plate. WRPlate series anti-wear surfacing. The composite board has high hardness, excellent abrasion resistance and good environmental adaptability. When used under actual working conditions, its matrix provides strength and toughness against external forces. Comprehensive properties such as performance, its wear layer provides anti-wear performance that meets specified requirements.

Based on its strong anti-wear properties, it is widely used in metallurgy, power, cement, coal, glass and other industries. WRPlate series anti-wear loss surfacing composite boards are mainly divided into three categories: general-purpose G, impact-resistant I and high-temperature-resistant H. The minimum thickness can reach 5 mm and the maximum it can reach 30 millimeters; and can be processed into wear parts that meet the requirements of different working conditions according to customer needs.

The company has an experienced team of R & D engineers for wear-resistant materials as well as professional production and processing technology of composite wear-resistant steel plates and domestic advanced Efficient production line, 24 fully automatic surfacing equipment, the product's anti-wear performance, flatness, coil deformation ability and other technical indicators are all industries Leading level. Jiangsu Velvet Hi-tech Welding Consumables Co., Ltd. will continue to optimize the wear-resistant metallurgical forming technology to provide customers with the best wear-resistant working conditions program.



产品性能 Product Properties

硬度与结合力 Hardness and adhesion force

WRPlate 系列抗磨损堆焊复合板的合金耐磨层和基体之间是结合强度极高的冶金结合，由具有固溶强化奥氏体结构的高硬度碳化铬合金与普通低碳钢板相结合而成，硬度能达到 HV600 以上（硬度实测值受堆焊层厚度影响）。

WRPlate series anti-wear surfacing composite plate is a metallurgical bond with extremely high bonding strength between the alloy wear-resistant layer and the substrate. The hardness can reach above HV600 (the measured value of hardness is affected by the thickness of the overlay layer).

适用温度范围 Temperature range

WRPlate 系列抗磨损堆焊复合板在最高温度达 850℃ 时仍然保持卓越的耐磨能力，同时能够抵抗高温氧化腐蚀。

WRPlate series anti-wear surfacing composite board still maintains excellent wear resistance at the highest temperature of 850 °C, and can resist high temperature oxidation corrosion.

宏观特征 Macro morphology

WRPlate 系列抗磨损堆焊复合板的表面有一系列宽度约 19mm~38mm 的焊缝和无数穿透表面且细如发丝的应力纹。这些适当分布的细裂纹是堆焊内应力自然释放造成的，能抵抗残余应力引起的残余变形等焊接缺陷。

The surface of the WRPlate series anti-wear surfacing composite board has a series of welds with a width of about 19mm ~ 38mm and numerous stress penetrating surfaces that are as thin as hair. These properly distributed fine cracks are caused by the natural release of stresses in the surfacing, and can resist welding defects such as residual deformation caused by residual stress.

耐磨性 Wear resistance

实验表明，在常温磨损条件下，WRPlate 系列抗磨损堆焊复合板的耐磨性是普通中碳钢的 30 倍，是经过热处理的普通耐磨板的耐磨能力的 15 倍以上。多种摩擦介质下的磨损实验证明，WRPlate 系列抗磨损堆焊复合板具有稳定的摩擦系数和相对较低的磨损量。



Experiments show that under normal temperature wear conditions, the wear resistance of WRPlate series anti-wear surfacing composite plate is 30 times that of ordinary medium carbon steel, and more than 15 times that of heat-treated ordinary wear-resistant plate. Abrasion experiments under various friction media prove that WRPlate series anti-wear surfacing composite plate has stable friction coefficient and relatively low wear.

耐冲击性 Anti impact

WRPlate 系列抗磨损堆焊复合板可以承受持续的中等强度冲击，可以根据客户要求满足的受冲击工况定制特殊合金成分的复合耐磨板。

WRPlate series anti-wear surfacing composite plate can withstand continuous medium-strength impact, and can be customized with special alloy composition according to the impact conditions that customers require.

化学成分 Chemical Composition

WRPlate 系列抗磨损堆焊复合板的碳 C 含量为 3.5%~5.5%，铬 Cr 含量为 16%~40%，与此同时还添加 Mo、Ni、Nb、W、V 等其他合金成分。不同型号的耐磨复合板具有不同的合金元素含量和配比，本公司可根据客户的实际应用工况定制特殊化学成分的复合板材并保证其成型性。

The WRPlate series wear-resistant surfacing composite plate has a carbon C content of 3.5% to 5.5% and a chromium Cr content of 16% to 40%. At the same time, other alloy components such as Mo, Ni, Nb, W, and V are also added. Different types of wear-resistant composite plates have different alloy element contents and proportions. Our company can customize composite plates with special chemical components and ensure their formability according to the actual application conditions of customers.

微观组织形貌 Microstructure

采用精密的堆焊工艺焊接使耐磨合金层组织中形成一次碳化物 M7C3 型（显微硬度高达 HV1700），其生长取向垂直于熔合线，组织中其体积占比约达 40%~60%，其微观形貌为塑韧性较好的奥氏体基体组织中弥散分布着取向生长的碳化物强化相。

Adopting precise surfacing welding to form primary carbide M7C3 type (microhardness up to HV1700) in the wear-resistant alloy layer structure, its growth orientation is perpendicular to the fusion line, and its volume proportion in the structure is about 40% ~ 60%. Its micro-morphology is a well-oriented austenite matrix structure with dispersedly distributed carbide-reinforced strengthening phases.



堆焊层表面碳化物分布形貌（50x，碳化物分布体积百分数50%以上）
The distribution morphology of carbide in surfacing layer (50x. The volume fraction of carbide reaches over 50%)



熔合线附近垂直生长的碳化物（50x）
The growth of grains oriented perpendicular to the fusion line (50x)



堆焊层表面碳化物分布形貌（200x，典型六棱柱碳化物硬质相）
The distribution morphology in surfacing layer (200x, typical hexagonal prism carbide hard phase)



熔合线附近垂直生长的碳化物（200x）
The growth of grains oriented perpendicular to the fusion line (200x)

复合耐磨板用基材标准 Standard for substrates for composite wear plates

- 低于 350℃ 工况下使用
- 采用 GB/T 3274 《碳素结构钢和低合金结构钢热轧厚钢板和钢带》中 Q235 或 Q355
- 350℃~500℃ 工况下使用
- 采用 GB/T 713 《锅炉用钢板》中 12Cr1MoV 钢板
- 高于 500℃ 工况下使用（建议不高于 650℃）
- 采用 GB/T 4237 《不锈钢热轧钢板》中 1Cr18Ni9Ti 或 1Cr18Ni9 钢板
- Use below 350 °C
- It adopts Q235 or Q355 in GB/T 3274 "Carbon structural steel and low alloy structural steel hot rolled thick steel plate and steel strip"
- Use at 350 °C ~ 500 °C
- Use 12Cr1MoV steel plate in GB / T 713 "Boiler steel plate"
- Use under 500 °C working condition (recommended not higher than 650 °C)
- 1Cr18Ni9Ti or 1Cr18Ni9 steel plate in GB / T 4237 "Stainless steel hot-rolled steel plate"

质量控制 Quality Control

WRPlate 系列抗磨损堆焊复合板的质量控制主要从厚度、硬度和外观等方面进行检测。

The quality control of WRPlate series anti-wear surfacing composite plate is mainly tested from the aspects of thickness, hardness and appearance.

检测项目 Test items	检测内容 Test content	工具和方法 Tools and methods
外观检测 External assessment	外形尺寸 Dimensions	卷尺 Tape measure
	平整性 Flatness	钢板尺等 Steel ruler, etc.
	焊接裂纹 Welding crack	目测：相对均匀 Visual inspection: relatively uniform
	焊接缺陷 Welding defect	目测：每平方米焊接缺陷数不多于 5 处 Visual inspection: Less than 5 welding defects per square meter
厚度检测 Thickness detection	基板厚度 Substrate thickness	测厚规 Gauge
	耐磨合金层厚度 Wear-resistant alloy	测厚规 Gauge
	复合钢板总厚度 Total thickness	测厚规 Gauge
内在质量 Intrinsic quality	表面硬度 Surface hardness	台式硬度计、便携式手持硬度计 Desktop hardness tester, portable handheld hardness tester
	合金成分 Alloy composition	多通道直读光谱仪、高频红外碳硫仪 Multi-channel direct spectrometer Infrared carbon and sulfur analyzer
	金相组织 Microstructure	金相显微镜 Metallographic microscope
	抗磨损性能 Anti-wear performance	湿砂橡胶轮磨损试验机 Wet sand rubber wheel wear tester
其他检测 Other tests	按照技术协议要求 Technical agreement	相关仪器及设备 Related instruments and equipment



可供尺寸 Available Stock Size

规格 Size	标准总厚度(mm) Total Thickness	硬度(HRc) Hardness	标准尺寸(mm) Regular Size
3+3t	6 ± 1	52~60	1480 × 3050
5+3t	8 ± 1	52~60	1480 × 3050
6+4t	10 ± 1	55~62	1480 × 3050
6+6t	12 ± 1	55~62	1480 × 3050
8+4t	12 ± 1	55~62	1480 × 3050
8+6t	14 ± 1	55~62	1480 × 3050
10+4t	14 ± 1	55~62	1480 × 3050
10+6t	16 ± 1	55~62	1480 × 3050
10+10t	20 ± 1	55~62	1480 × 3050

- 可按照用户要求生产其他规格的耐磨钢板，按用户要求切割成任意尺寸和加工任意形状零部件；
Anysize, shape and specification of wear-resistant plate can be made according to requirement from custom.
- 基板厚度推荐系列 5mm, 6mm, 8mm, 10mm；合金耐磨层推荐厚度 3mm, 4mm, 6mm；
The thickness of substrate recommend 5mm, 6mm, 8mm, 10mm；The thickness of wear-resistant layer recommend 3mm, 4mm, 6mm；
- 由于基材钢板存在厚度偏差，合金耐磨层和基材钢板间存在熔合层，钢板总厚度与标称值之间存在偏差；
There is deviation on the total thickness between the actual products and specification as fusion layer between the wear-resistant alloy layer and substrate plate existed..
- 常用规格耐磨板库存备货充足，供货及时。
The storage of common specification wear-resistant plate is plentiful, deliver on time



行业应用 Application

水泥行业 Cement Industry

主要应用于选粉机叶片、冲击盘、管道、泵壳、磨机内衬、破碎机零件、出渣槽、各种底盘、振动筛板等。
Mainly used in powder separator blades, impact disks, pipes, pump casings, mill linings, crusher parts, slag discharge tanks, various chassis, vibrating screens, etc.

冶金行业 Metallurgical Industry

主要应用于料仓衬板、料车、喉管、布料器及底座、料斗、称量斗、管道、泵壳、破碎机部件、出渣槽、风机外壳、风机叶片、振动筛板等。
Mainly used in silo liners, carts, hoses, distributors and bases, hoppers, weighing hoppers, pipes, pump casings, crusher components, slag discharge tanks, fan casings, fan blades, vibrating screens, etc.

发电行业 Power-generation Industry

主要应用于出灰口、料仓、风机叶片、燃烧器管线、输料槽和料斗内衬、破碎机部件、磨煤机进出口部件、空气处理系统和输送机等。
Mainly used in ash outlets, silos, fan blades, burner pipelines, linings of hoppers and hoppers, crusher parts, coal mill import and export parts, air handling systems and conveyors.

矿山行业 Mining Industry

主要应用于洗选煤和采掘及矿物运输，卡车货箱衬板、料仓衬板、刮板输送机中板及底板、输料槽内衬、选煤厂衬板、振动筛板等。
Mainly used in coal washing and mining and mineral transportation, truck container linings, silo linings, scraper conveyor middle and bottom plates, linings of conveying tanks, coal preparation plants, vibrating screens, etc.

其他行业 Other Industry

工程机械、玻璃、造纸、制砂、航道疏浚、砖瓦机械、焦化行业、农业机械、港口码头等。
Construction machinery, glass, papermaking, sand making, channel dredging, brick and tile machinery, coking industry, agricultural machinery, ports and docks.

供货标准 Delivery Standard

基板厚度/mm	Substrate thickness	标称值 ± 0.5 Nominal value ± 0.5
合金耐磨层厚度/mm	Alloy layer thickness	标称值 ± 1.0 Nominal value ± 1.0
总厚度/mm	Total thickness	± 1.0
标准板外形尺寸/mm	Standard dimensions	± 5.0mm，保证有效尺寸不低于技术要求 ± 5.0mm, ensuring that the effective size is not less than the technical requirements
焊接缺陷	Welding defect	每平方米面积内不多于5处 Not more than 5 per square meter
切割加工	Cutting	数控等离子切割 CNC plasma cutting
整板供货	Complete board supply	切割边缘或不切割边缘，表面喷漆或不喷漆 Cut or uncut edges, painted or unpainted surface
其他要求	Other requirements	双方约定 The two sides agreed

WRPipe 系列抗磨损堆焊复合管道

WRPlate series anti-wear overlay welding composite plate

WRPipe 系列抗磨损堆焊复合管道是以低碳钢管道为基体，采用特殊的堆焊熔敷工艺使抗磨合金层与基材达到冶金结合的双金属复合抗磨损堆焊复合管道，其堆焊合金层厚度可达 3~15mm。WRPipe 系列抗磨损堆焊复合管道具备优异的耐磨性、耐高温和耐冲击性能，广泛应用于大型绞吸式挖泥船、耙吸式挖泥船等，特别适合较大颗粒物料的磨损，如冶金水渣系统，废井填充，矿山干物料输送等，与其他耐磨管道制品相比，使用寿命长且经济实惠。



WRPipe series anti-wear surfacing welding composite pipe is a bimetal composite anti-wear surfacing welding composite pipe based on low-carbon steel pipe, and adopts special surfacing welding technology to make the anti-wear alloy layer and substrate reach metallurgical combination. The thickness of the alloy layer can reach 3 ~ 15mm. WRPipe series anti-wear surfacing welded composite pipe has excellent abrasion resistance, high temperature resistance and impact resistance. It is widely used in large cutter suction dredgers, rake suction dredgers, etc., especially suitable for the wear of larger granular materials. Such as metallurgical water slag system, waste well filling, mine dry material transportation, etc., compared with other wear-resistant pipeline products, long life and economic benefits.

基材 Substrate	Q235 、Q355 、CSSA36
基材壁厚/mm Substrate wall thickness	5mm、6mm、8mm、10mm、12mm、14mm、15mm
合金层厚度/mm Alloy layer thickness	3mm、4mm、6mm、8mm、10mm
合金类型 Alloy type	铁基高铬合金 Iron-based high chromium alloy
合金耐磨层成分 Alloy wear layer composition	C:4~5%，Cr:28~31%，Fe:余量
合金耐磨层硬度 Alloy wear layer hardness	58~63HRC
切割方式 Cutting method	等离子切割 或 高压水刀切割 Plasma cutting or high-pressure waterjet cutting
管道安装方式 Installation method of pipeline	焊接 或 法兰连接/固定Welded or flanged / fixed

HFC 硬面堆焊修复再制造服务

HFC hardfacing surfacing repair and remanufacturing services

HFC 硬面堆焊能使零部件具有更好的抗磨损特性，优于铸造或锻造的替换零备件。硬面堆焊层的材料组织成分和堆焊层厚度可控，能显著提高及延长设备的运转效率和寿命，拥有极好的经济效益。

江苏维特高科焊业有限公司的 HFC 硬面堆焊再制造技术在国内处于领先水平，形成了完整的堆焊材料、焊接专用设备、焊接专机以及耐磨堆焊再制造服务等全面抗磨损技术的研发、生产和销售服务体系，其金属耐磨材料及其堆焊施工工程在水泥、电力、冶金、矿山等基础工业中有着非常广泛的应用，为火电厂、水泥厂和钢铁厂提供立磨、辊压机挤压辊的堆焊再制造服务。江苏维特高科焊业有限公司在堆焊复合新品制造、耐磨件堆焊再制造、立磨检修及配件制造等领域全面开展优质的服务，欢迎国内外广大客户选择维特高科焊业的 HFC 硬面堆焊再制造服务。



HFC hard surface surfacing can make parts have better anti-wear properties, which is better than casting or forging replacement parts. The material composition and thickness of the hard surface surfacing layer can be controlled, which can significantly improve and extend the operating efficiency and life of the equipment and has excellent economic benefits.

Jiangsu Velvet Hi-tech Welding Consumables Co., LTD. is the leading domestic manufacturer of HFC hardfacing remanufacturing technology, forming a comprehensive anti-wear technology including complete surfacing materials, welding special equipment, welding machines and wear-resistant surfacing remanufacturing services. R & D, production and sales service system, its metal wear-resistant materials and its overlay welding construction engineering have a wide range of applications in basic industries such as cement, power, metallurgy, mining, etc., providing vertical mills for thermal power plants, cement plants and steel plants, Overlay welding remanufacturing services for roller press rolls. Jiangsu Velvet Hi-tech Welding Consumables Co., LTD. has comprehensively carried out high-quality services in the fields of surfacing welding new products manufacturing, wear-resistance surfacing remanufacturing, vertical mill maintenance and parts manufacturing. Welcome customers at home and abroad to choose Velvet Hi-tech Welding's HFC hard surface Surfacing welding remanufacturing services.



应用实例

Application Of Figure





应用实例

Application Of Figure



产品销售网络

完善的营销网络
覆盖全国重点市场区域
贴近重点客户

Perfect marketing network,
covering key market areas in the country,
close to key customers

