

## 磐固合金®药芯焊丝产品目录

Milestone Metal Flux Cored Welding Wire Products Catalog



## Company Profile

Milestone Metal (Changzhou) Co., Ltd. was established in 2019 and is located in Liyang, Changzhou, Jiangsu PRC. We are dedicated to providing high-quality, high-performance welding materials through independent research and innovation, meeting the needs of the domestic market and enhancing the overall competitiveness of China's manufacturing industry. Our goal is not only to develop the domestic market but also to promote "Made in China" welding consumable globally, offering superior welding solutions to both domestic and international customers and striving to become a leader in the international welding consumable industry.



### Our products:

We specialize in producing high-performance specialty cored wires, particularly in the following diameter specifications:

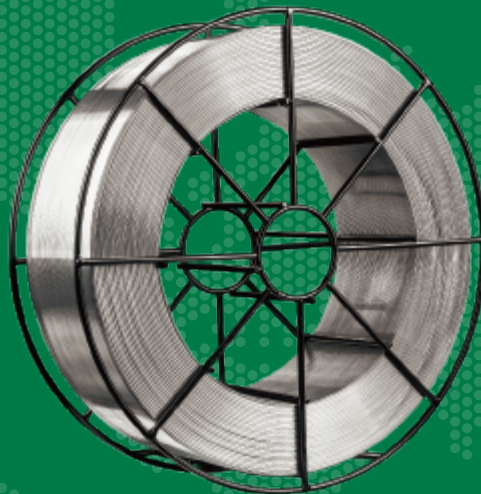
- Cobalt-based alloy cored wire: 1.2mm, 1.6mm, 2.0mm
- Tungsten carbide cored wire: 1.6mm, 2.0mm
- Nickel-based alloy cored wire: 1.2mm, 1.6mm
- Iron-based alloy cored wire: 1.2mm, 1.6mm

### Core advantages:

**Customized Solutions:** Providing various specifications and compositions based on customer needs to ensure optimal matching.

**Exceptional Wear Resistance:** Outstanding performance under extreme conditions, especially suitable for high-wear environments.

**Excellent Corrosion Resistance:** Offering superior protection against both high temperatures and chemical erosion.



### Corporate Vision:

We uphold the spirit of integrity, professionalism, and excellence, striving to become a leader in the specialty welding materials industry. While pursuing commercial success, we place even greater emphasis on the growth and well-being of our employees, working hard to create an ideal living and working platform for each one of them. Here, every employee can realize their self-worth in a harmonious and innovative environment, growing together with the company.

### Corporate Mission:

**Innovation Driven:** Relying on continuous technological research and development and innovation to enhance product performance and service quality.

**Quality First:** A strict quality control system ensures that every product meets the highest standards.

**Customer Satisfaction:** Listening to customer needs, providing customized welding solutions, and earning long-term trust and cooperation from customers.

## 公司介绍

磐固合金（常州）有限公司成立于2019年，位于江苏常州溧阳。我们一直致力于通过自主研发和创新，提供高质量、高性能的焊接材料，满足国内市场的需  
求，提升中国制造业的整体竞争力。我们的目标不仅限于国内市场的开拓，更以将“中国制造”的焊材推向全球为目标，为国内外客户提供卓越的焊接解决方案，努力成为国际焊接材料行业的领导者。

### 我们的产品

专注于生产高性能的特种药芯焊丝，特别是以下直径规格的产品：

钴基合金药芯焊丝：1.2mm、1.6mm、2.0mm

碳化钨药芯焊丝：1.6mm、2.0mm

镍基合金药芯焊丝：1.2mm、1.6mm

铁基合金药芯焊丝：1.2mm、1.6mm

### 核心优势

定制化解决方案：根据客户需求，提供多种规格和成分的选择，确保最佳匹配。

卓越的耐磨性：在极端工况下表现出色，特别适用于高磨损环境。

优异的抗腐蚀性能：无论是高温还是化学侵蚀，我们的焊材都能提供出色的保护。

### 企业愿景

我们秉持诚信、专业和卓越的精神，致力发展成为特种焊材行业的领先者。在追求商业成功的同时，我们更加关注员工的成长与幸福，努力为每一位员工打造理想的生活和工作平台。在这里，每位员工都能在和谐、创新的环境中实现自我价值，与企业共同成长。

### 企业使命

创新驱动：依靠持续的技术研发和创新，不断提升产品性能和服务质量。

品质至上：严格的质量控制体系确保每一件产品都能达到最高标准。

客户满意：倾听客户需求，提供定制化的焊接解决方案，赢得客户的长期信任与合作。

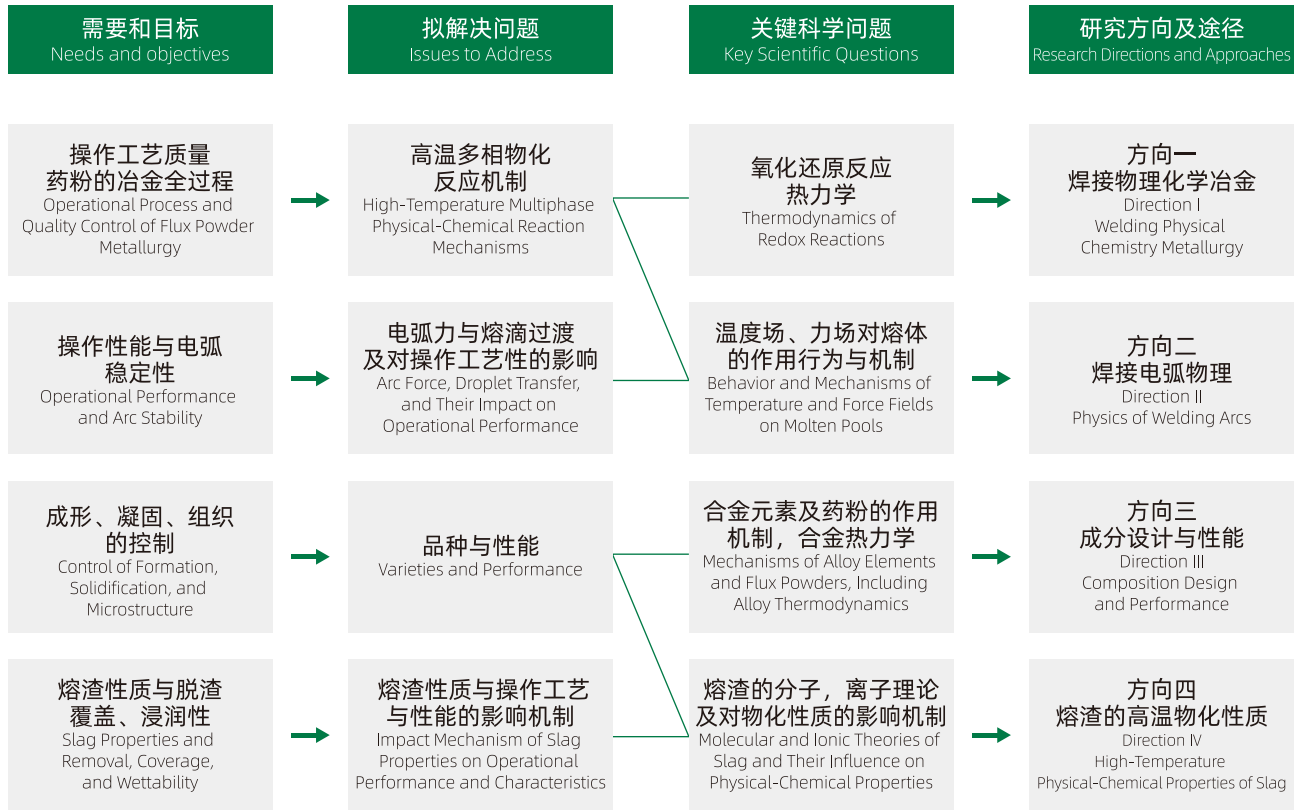
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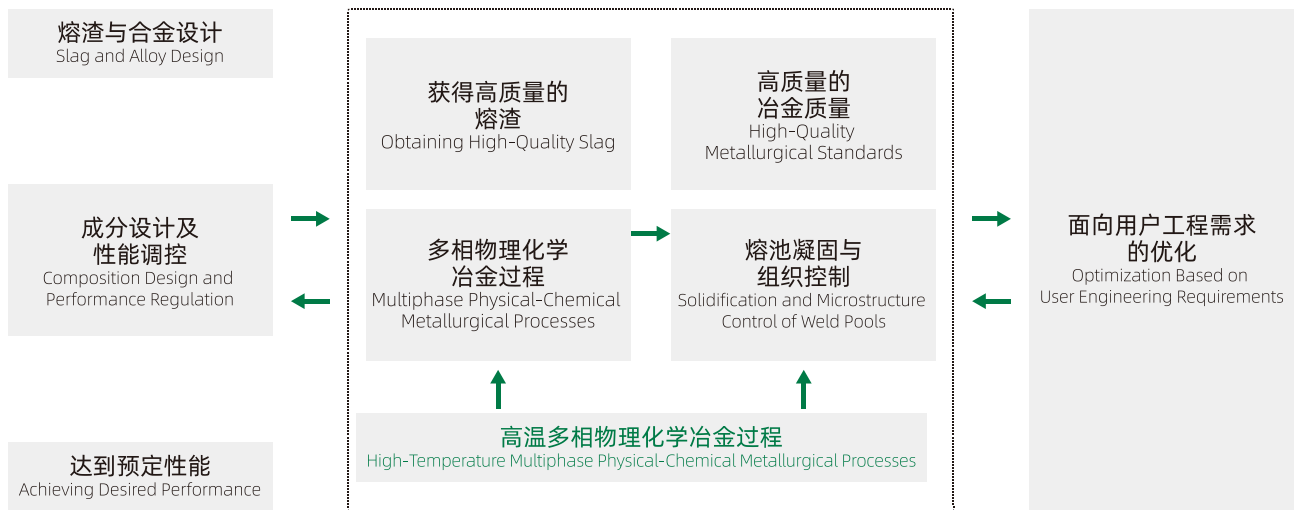
## 研发理念 R&D Philosophy



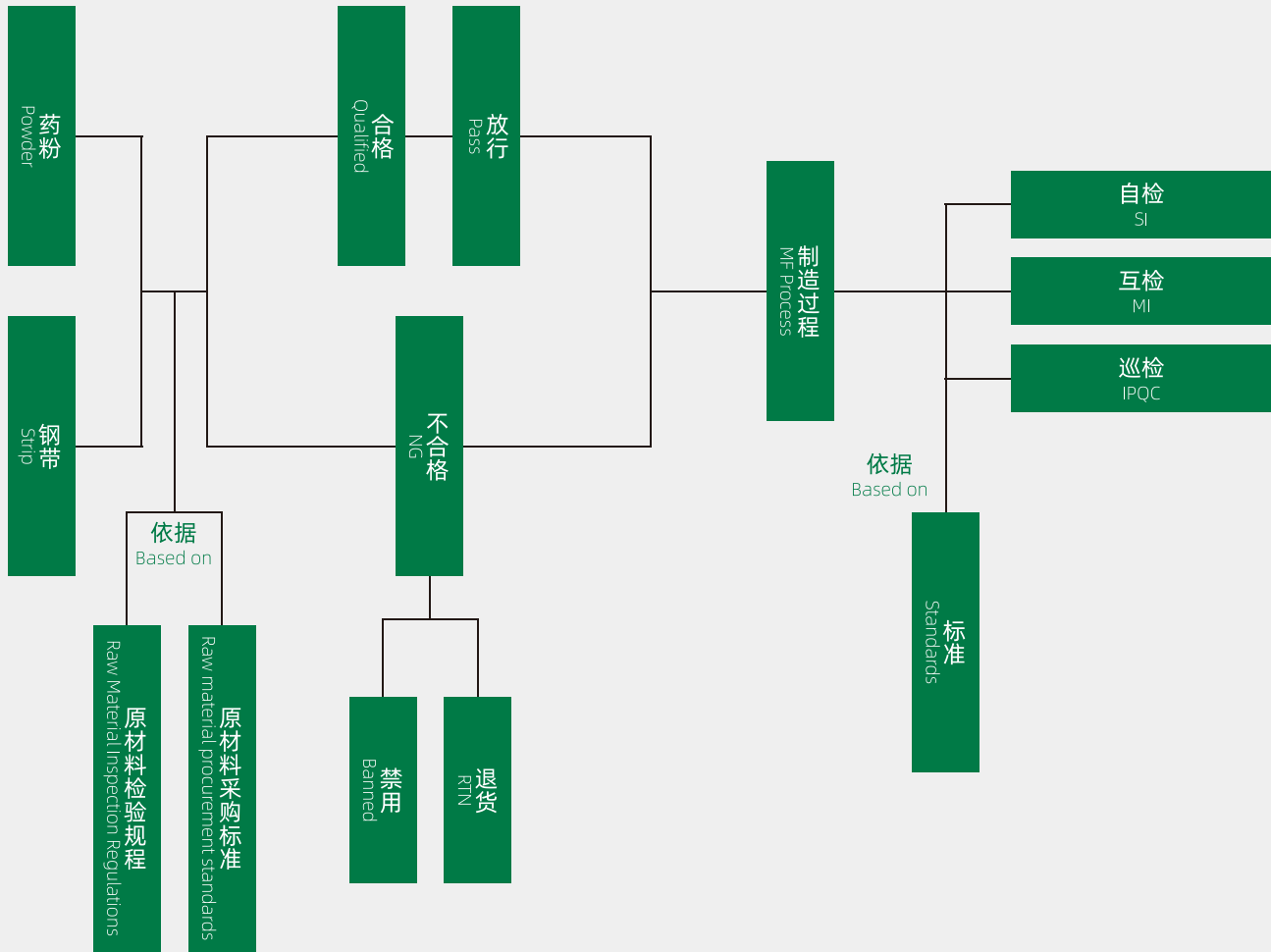
**扎实理论、联系实际、  
不断学习、不断创新。**  
Solid Theory, Practical Application,  
Continuous Learning, and Innovation.



**高品质, 高性能, 高效益**  
High-Quality, High-Performance, High-Efficiency



# 制造过程与质量控制 Quality Control



## 原料控制

- > 采购控制程序
- > 产品控制程序
- > 记录控制程序

## Raw Material Control

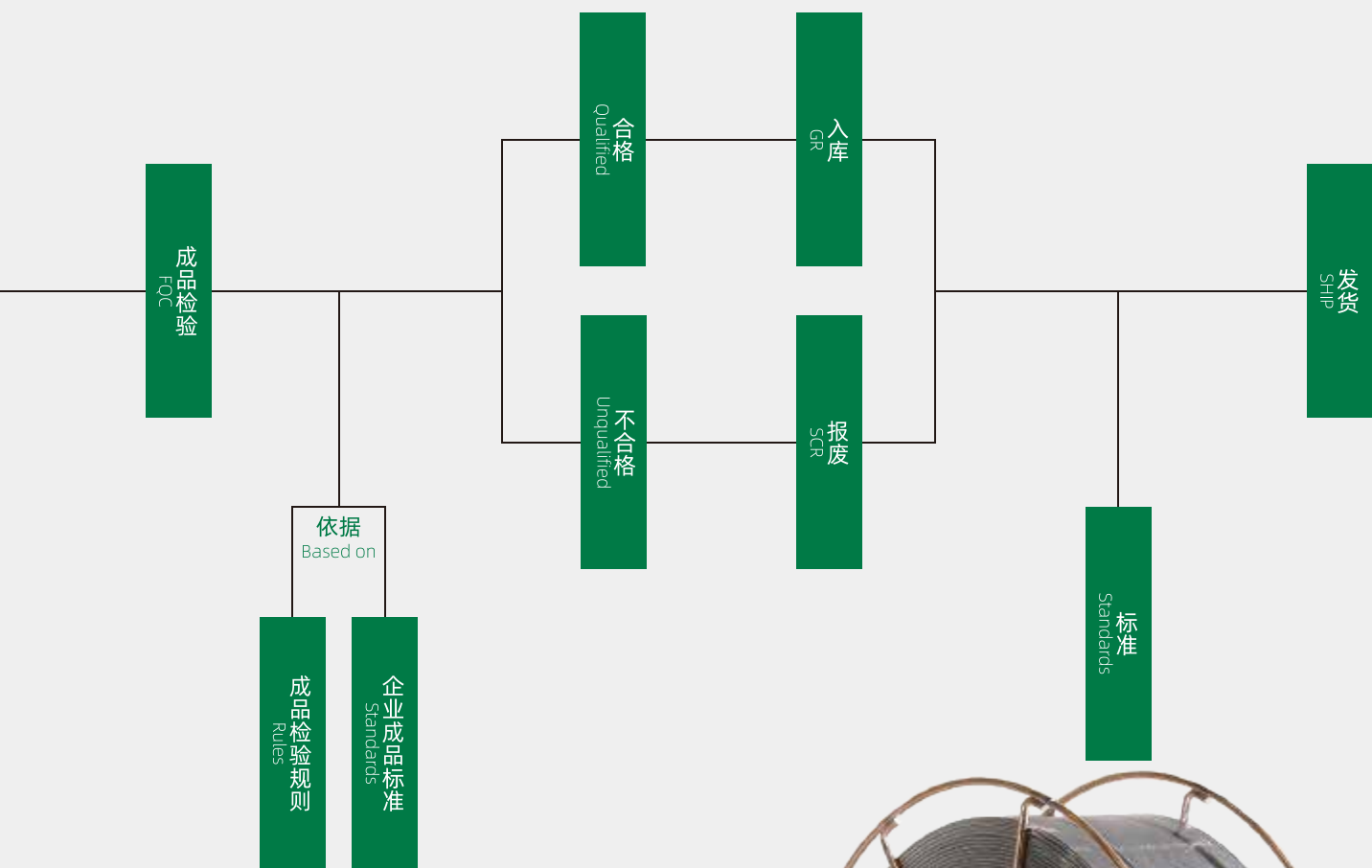
- > Procurement Control Procedure
- > Product Control Program
- > Record Control Program

## 过程控制

- > 半成品控制程序
- > 记录控制程序

## Process Control

- > Semi-finished Product Control Program
- > Record Control Program



### 出厂控制

- > 成品控制程序
- > 记录控制程序
- > 纠正和预防措施控制程序

### Factory Control

- > Finished Product Control Program
- > Record Control Program
- > Corrective and Preventive Action Control Procedure



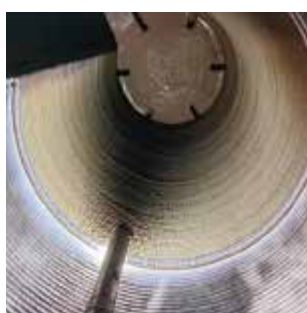
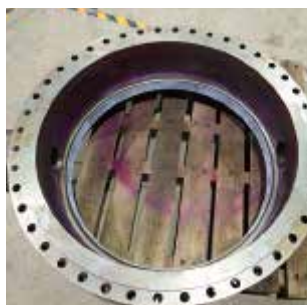
# 钴基合金药芯焊丝 Cobalt-based Alloy Cored Wire

产品 Product	规格 Dia(mm)	硬度 Hardness(HRC)	化学成分分析 Analysis						
			Co	Cr	C	W	Ni	Mo	Fe
Milestone Co1	1.2 1.6 2.0	50-55	Bal.	25-33	2.0-3.0	11-14	<3.0	<1.0	<5.0
Milestone Co6	1.2 1.6 2.0	38-44	Bal.	25-32	0.7-1.4	3.0-6.0	<3.0	<1.0	<5.0
Milestone Co6 TIG	1.2 1.6	38-44	Bal.	25-32	0.7-1.4	3.0-6.0	<3.0	<1.0	<5.0
Milestone Co12	1.2 1.6 2.0	45-50	Bal.	25-32	1.2-2.0	7-10	<3.0	<1.0	<5.0
Milestone Co21	1.2 1.6 2.0	28-42	Bal.	25-30	0.15-0.40	<0.5	1.5-4.0	4.5-7.0	<5.0
Milestone Co21 TIG	1.2 1.6	28-42	Bal.	25-30	0.15-0.40	<0.5	1.5-4.0	4.5-7.0	<5.0
Milestone Co25	1.2 1.6 2.0	20-45	Bal.	18-22	3.0-4.0	12-16	10	<1.0	<3.0
Milestone Co190	1.6	50-55	Bal.	24-30	3.0-4.0	12-16	<4.0	<1.0	<5.0
Milestone Co250	1.6	20-28	Bal.	26-30	0.09-1.1	-	-	-	19-23
Milestone Co706	1.6	39-44	Bal.	29-33	1.0-1.4	-	<3.0	2-6	<3.0
Milestone Co712	1.6	46-51	Bal.	29-33	1.4-1.7	-	<3.0	6-10	<3.0
Milestone CoUTM	1.2 1.6	28-45	Bal.	24-28	0.05-0.1	-	7-11	3-7	<3.0
Milestone UMCo50	1.6		Bal.	27-31	0.1-0.2	-	<3.0	-	12-16
Milestone Co401	1.6	46-52	Bal.	15-19	1.5-2.5	-	<1.5	20-24	<5.0



每一个里程碑都见证着  
我们的成长与成就。  
Every Milestone Witnesses  
Our Growth and Achievements.

			标准 Standard	
Si	Mn	Others	UNS	UNS
<2.0	<2.0	<1.0	W73031	(SFA)A 5.21 ERCCoCr-C
<2.0	<2.0	<1.0	W73036	(SFA)A 5.21 ERCCoCr-A
<2.0	<2.0	<1.0	W73036	(SFA)A 5.21 ERCCoCr-A
<2.0	<2.0	<1.0	W73042	(SFA)A 5.21 ERCCoCr-B
<1.5	<2.0	<1.0	W73041	(SFA)A 5.21 ERCCoCr-E
<1.5	<2.0	<1.0	W73041	(SFA)A 5.21 ERCCoCr-E
<1.0	<2.4	<1.0	-	-
<2.0	<1.0	<1.0	W73032	(SFA)A 5.21 ERCCoCr-G
<1.0	<2.6	<1.0	-	-
<1.0	<2.7	<1.0	-	-
<2.0	<2.8	<1.0	-	-
-	<2.9	<1.0	R31233	
<2.0	<2.10	<1.0	-	-
<2.0	<2.11	—	-	-



## 典型工艺:

GMAW or CMT	
保护气体	Ar100% (I1)
电流	100-350A
电压	16-30V
极性	DC+
干伸长	15-30mm
焊接位置	1G 2G



GTAW	
保护气体	Ar100% (I1)
电流	100-300A
电压	10-15V
极性	DC-
干伸长	15-30mm
焊接位置	1G 2G



SAW	
焊剂	PG-9000
电流	200-400A
电压	20-24V
极性	DC+



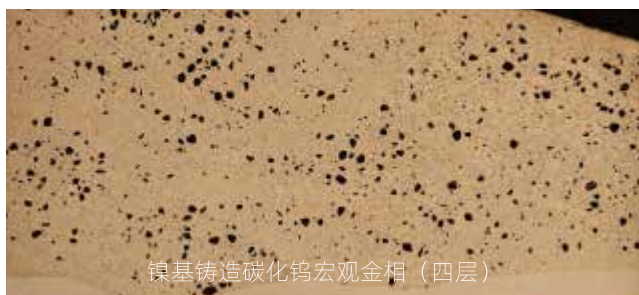
## 碳化钨药芯焊丝 Tungsten Carbide Cored Wire



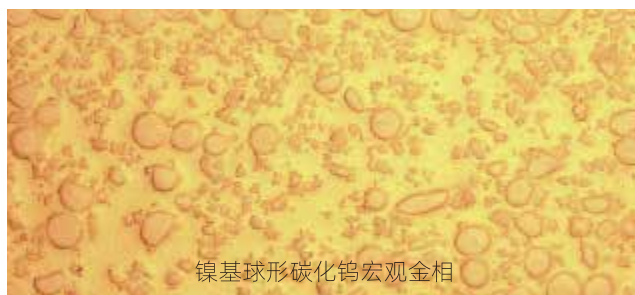
**只有最坚韧的材料  
能经受住沙丘的考验。**  
Only the Most Resilient Materials can  
Withstand the Test of the Dune.

## 碳化钨类专用焊材

产品 Product	组织形态 Microscopic structure	宏观硬度 Matrix hardness(HRC)	硬质相微观硬度 Hard phases microhardness(HV)	焊丝直径 Diameter(mm)
Dune FF150	Fe+50%Dune FTC	≥40	≥2200	1.6、2.0
Dune FS150	Fe+50%Dune SFTC	≥40	≥2300	1.6、2.0
Dune NF150	Ni+50%Dune FTC	≥42	≥2300	1.6、2.0
Dune NS150	Ni+50%Dune SFTC	≥42	≥3000	1.6、2.0
Dune NF250	NiFe-Matrix+50%Dune FTC	≥45	≥2300	1.6、2.0
Dune NF340	NiBSi+40%Dune FTC	≥55	≥2300	1.6、2.0
Dune NF450	NiCrBSi+50%Dune FTC	≥60	≥2300	1.6、2.0
Dune NS250	NiFe-Matrix+50%Dune SFTC	≥45	≥3000	1.6、2.0
Dune NS340	NiBSi+40%Dune SFTC	≥55	≥3000	1.6、2.0
Dune NS450	NiCrBSi+50%Dune SFTC	≥60	≥3000	1.6、2.0
Dune CT150	Co-Matrix+50%Dune TC6	≥45	≥1950	1.6、2.0



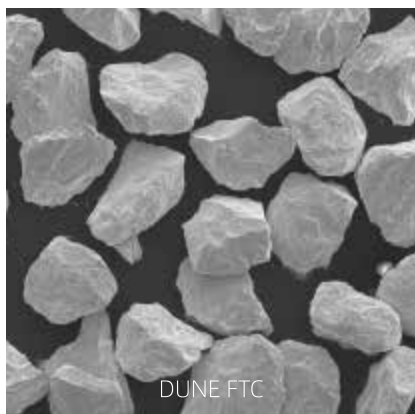
镍基铸造碳化钨宏观金相（四层）



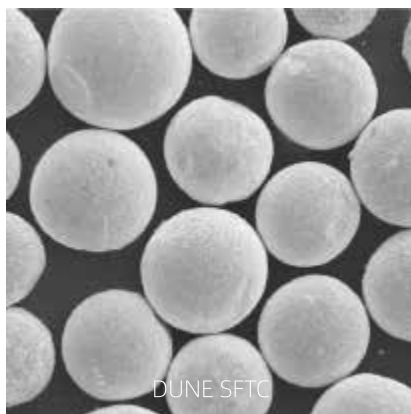
镍基球形碳化钨宏观金相

## 基体材料：Fe、Co、Ni、NiFe、NiBSi、NiCrBSi

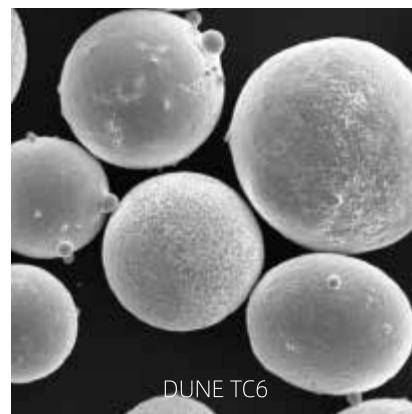
碳化钨类型 Tungsten carbide type	硬质相硬度 Hard phase hardness
铸造碳化钨 Dune FTC	HV <sub>0.1</sub> ≥2300
球形碳化钨 Dune SFTC	HV <sub>0.1</sub> ≥2500
钴基包覆碳化钨 Dune TC6	HV <sub>0.1</sub> ≥1950



DUNE FTC



DUNE SFTC

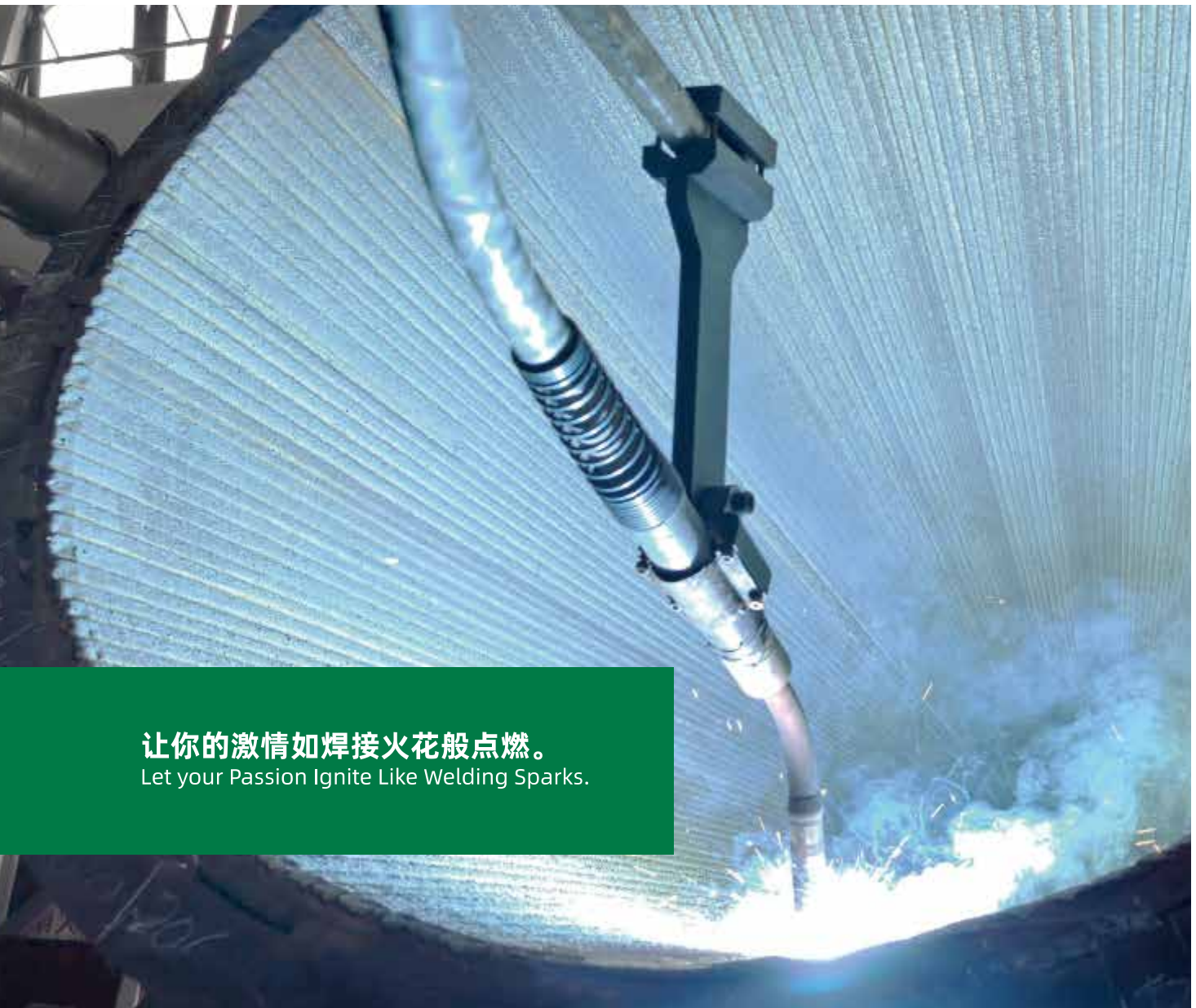


DUNE TC6

# 镍基合金药芯焊丝 Nickel-based Alloy Cored Wire

## 镍基合金专用焊材

产品 Product	Ni	C	Cr	W	Mo	Co	Fe	Si	B	Others
Spark C	Bal.	<0.5	15.0-20.0	3.0-8.0	15.0-20.0	-	3.0-8.0	-		<1.0
Spark 40	Bal.	0.2-0.6	6.5-14	-	-	-	1.0-3.5	1.2-4.0	1.5-3.0	<1.0
Spark 50	Bal.	0.3-0.8	9.5-16	-	-	-	2.0-5.0	3.0-5.0	2.0-4.0	<1.0
Spark 60	Bal.	0.5-1.0	12-18	-	-	-	3.0-5.5	3.0-5.5	2.5-4.5	<1.0
Spark CCo	Bal.	<0.1	12.0-18.0	3.0-6.0	13.0-18.0	1.0-3.0	1.0-3.0	0.5-1.0	-	-
Spark Ni520	Bal.	<0.1	10.0-15.0	0.5-2.0	3.0-8.0	10.0-14.0	1.0-2.0	<0.5	-	-
Spark Ni519	Bal.	<0.1	17.0-22.0	0.5-2.0	3.0-8.0	10.0-14.0	<0.5	<0.5	-	-



让你的激情如焊接火花般点燃。  
Let your Passion Ignite Like Welding Sparks.

UNS	ASME/AWS	Hardness	
		As welded	Workhardened
N30002	-	200HB	350HB
W89634	(SF)A 5.21 ERCNiCr-A	38-42HRC	-
W89635	(SF)A 5.21 ERCNiCr-B	46-51HRC	-
W89636	(SF)A 5.21 ERCNiCr-C	49-56HRC	-
-	-	220HB	350 HB
-	-	250HB	38-42 HRC
-	-	250HB	32-40 HRC



## 铁基合金药芯焊丝 Iron-based Alloy Cored Wire



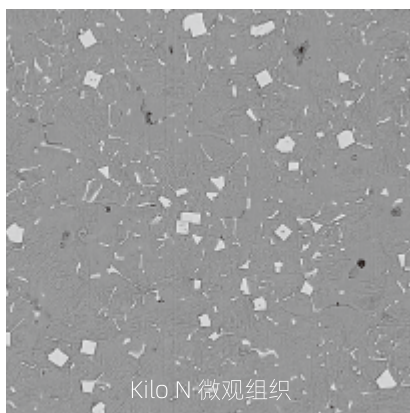
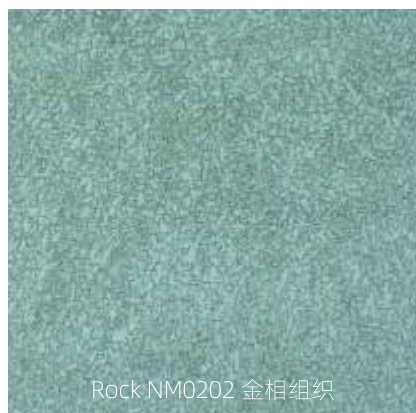
在艰苦的工作期间，  
我们是你的支柱。  
We were Your Rock During the Hard Work.

## 工具钢专用焊材

产品 Product	C	Si	Mn	Cr	Ni	Mo	V	W	Co	Fe	Hardness (HB/HRC)
Rock 250	√	< 1.0	1.0-1.5	1.60	-	√	-	-	-	balance	250HB
Rock 350	√	0.5-1.0	1.0-2.0	2.00	-	√	-	-	-	balance	350HB
Rock 400	√	0.5-1.0	1.0-2.0	3.00	-	√	-	-	-	balance	40-44
Rock 450	√	0.5-1.0	1.0-2.0	2.0-3.0	-	√	-	-	-	balance	450HB
Rock 500	√	< 0.5	1.0-2.0	1.0-2.0	-	-	-	-	-	balance	50-52
Rock 600	√	0.6-0.8	1.0-1.5	6.00	-	√	-	-	-	balance	54-57
Rock 650	√	1.0-1.5	1.0-1.5	5.0-6.0	-	√	√	√	-	balance	57-62
Rock NM0202	√	< 0.5	< 0.5	5.0-10.0	√	√	√	√	-	balance	52-55
Rock CM1202	√	0.5-1.0	< 0.5	10.0-15.0	√	√	-	-	√	balance	45-50

## 钻杆耐磨带专用焊材

产品 Product	C	Si	Mn	Cr	Ni	Mo	Nb	V	Ti	Fe	Hardness (HRC)
Kilo C	√	0.5-1.0	1.0-2.0	6.0-10	-	√	-	-	-	balance	55-57
Kilo N	√	1.0-2.0	0.5-1.0	5.0-8.0	-	-	√	√	√	balance	55-59
Kilo T	√	1.0-2.0	1.0-2.0	3.0-7.0	-	√	√	√	√	balance	57-61



## 焊材 Welding Consumable

### 磐固合金（常州）有限公司

江苏常州溧阳市苏高新南大创新园北区G7  
邮编：213376  
电话：0519-87805959  
手机：13911136930  
邮箱：sales@milestone-metal.cn

### Milestone Metal (Changzhou) Co., Ltd.

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213376, Changzhou, Jiangsu, China  
TEL:+86-519-87805959  
FAX:+86-519-87805959  
E-mail: sales@milestone-metal.cn

## 焊接专机 Welding Equipment

### 埃迈特智能装备(天津)有限公司

天津市西青区盛源道1号4号厂房  
邮编：300385  
电话：022-59653718  
传真：022-59653716  
support@ametchina.cn

## 焊接服务 Welding Service

### 埃迈特智能制造(江苏)有限公司

江苏常州溧阳市苏高新南大创新园北区G7  
邮编：213376  
电话：0519-87805959  
传真：0519-87805959  
market@ametchina.cn

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