

1100 F 594

1 /

200

300

400

1

ASME

SFA-5.24

序号	母材牌号 (SB658)	焊丝牌号(AWS)
1	R60702	ERZr2
2	R60704	ERZr3
3	R60705	ERZr4

2

2.1

2.2

5

2.3

2.4

0.5m/s

80%

3

3.1

3.2

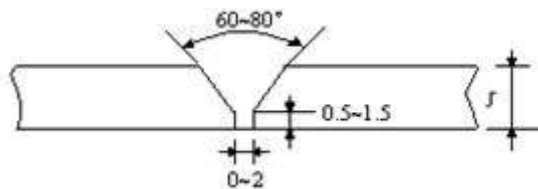
ASME

IX

3.3

试样厚度mm	弯轴直径mm	支撑间距mm	弯曲角度°
$T \leq 9.5$	10t	$12t + 3.2$	180

3.4



3.5

3.6

3/2

1

母材厚度 (mm)	钨极直径 (mm)	焊丝直径 (mm)	喷嘴孔径 (mm)	焊接电流 (A)	氩气流量 (L/min)			焊速 (m/h)	备注
					喷嘴	拖罩	背面		
0.8	1.6	1.2	10	45-55	8-10	-----	6-8	手工钨极氩 弧焊	
1.6	2.0	1.6	10	50-60	8-10	14-16	6-8		
2.0	3.0	2.0	12	60-70	8-10	14-16	6-8		
3.0	3.0	2.0	14	95-120	12-14	16-18	12-14		
4.0	4.0	2.0	16	140-150	12-14	16-18	12-14		
5.0	4.0	2-3	18-20	165-175	12-14	16-18	12-14		
6.0	4.0	2-3	18-20	165-185	14-16	16-18	14-16		
12.0	4.0	3.0	18-20	170-200	18-20	20	14-16		
0.5	1.6	1.2	10	40-50	8-10	-----	6-8	40-50	自动焊
1.0	2.0	1.2	12	60-70	8-10	-----	6-8	38.4	
1.6	3.0	1.6	14	70-80	8-10	14-16	6-8	38.4	

2

2.1

25mm

75mm

2.2

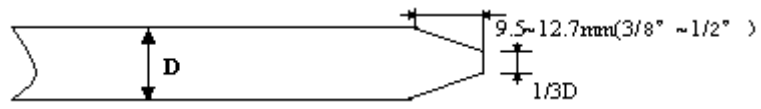
3

3.1

99.99%

0.978Mpa

3.2



3.3

3.4

3.5

15

20

100

3.6

3.7

3.8

3.9

300

3.10

25mm

3.11

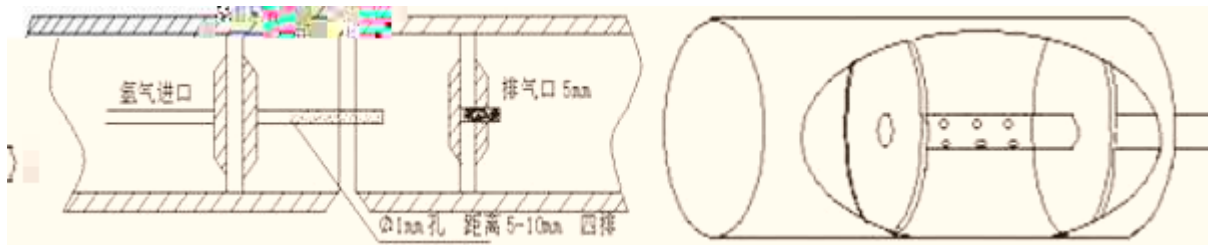
3.12

3.13

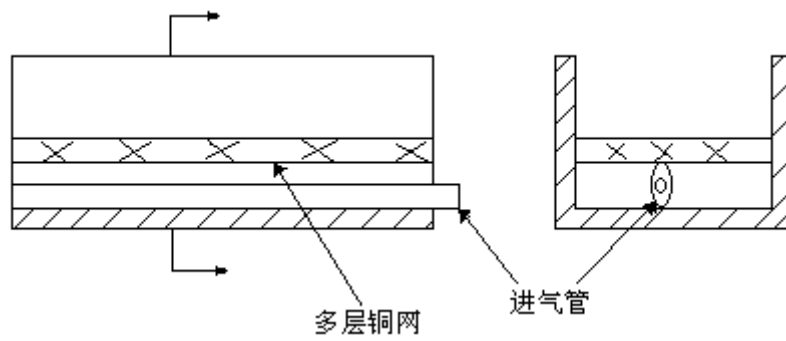
4 300

4.1

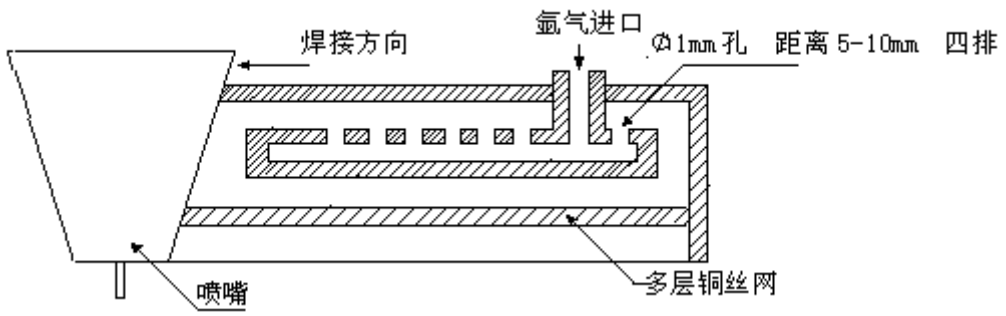
300



4.2



4.3



5

X

Zr0 Zr203 Zr02

30HB (5HRB),



TDN 5000MY



WSE-315

