

CO₂/MAG

,

CO₂

CO₂ 于

1 CO₂ 3 5kg/h 1 2.25 CO₂ Φ 0.8 Φ 1.6
 CO₂ 100 300A/mm² 10 25 A/mm², 且
 1 3 1 2

2 CO₂ CO₂
 32 45 50%

3 CO₂ CO₂
 50% 0.3 0.8

CO₂ 2.02 3.88
 1 2

4 0.72 1.08
 5 0.3 0.8

1 CO₂

3 CO₂ 于

4 CO₂ 于

5 CO₂

6 CO₂

CO₂

CO₂

CO₂/MAG

1 80 CO₂

CO₂

Mn

Mn

1.8 2.1% Mn/Si

Mn/Si

Mn

1.4

1.85%

Si

0.8

1.15%

CO₂

2 CO₂ 且

CO₂

且

CO₂

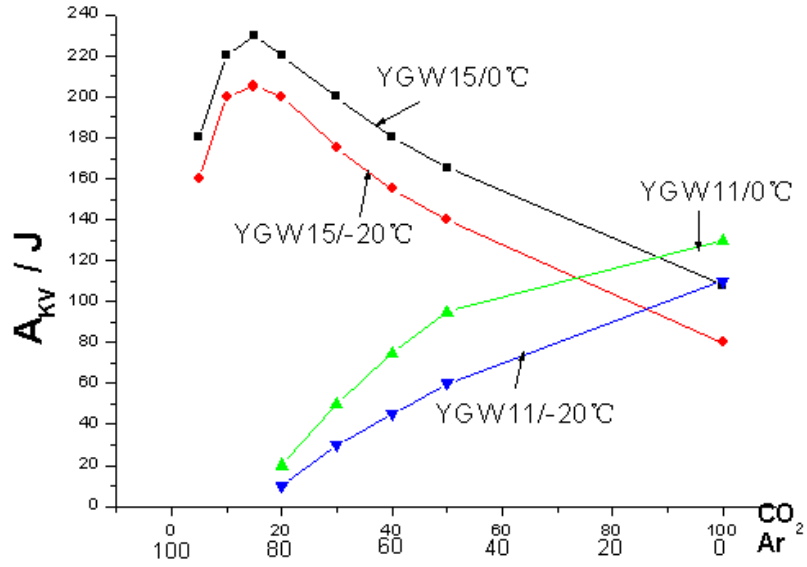
且[H]

且

| 焊丝型号 | C | Mn | Si |
|------------|-----------|----------|-----------|
| YGW 11 (日) | ≤0.15 | 1.4~1.9 | 0.55~1.0 |
| YGW 15 (日) | ≤0.15 | 1.0~1.6 | 0.4~1.0 |
| ER 49-1 | ≤0.11 | 1.8~2.1 | 0.5~0.95 |
| ER 50-3 | 0.06~0.15 | 0.9~1.4 | 0.45~0.75 |
| ER 50-6 | 0.06~0.15 | 1.4~1.85 | 0.8~1.15 |

1

%



1 下

1 1 Mn/Si YGW11
 80%Ar+20%CO₂ Mn Si
 Mn Si YGW15 MAG Mn Si
 Mn 1.0% Si 0.4%
 CO₂ MAG ER50-6
 Mn CO₂ Mn
 3 MAG
 MG-51T

2

| 焊接方法 | 屈服强度 σ_s (MPa) | 抗拉强度 σ_b (MPa) | 延伸率 δ (%) | 冲击韧性 Ak _v (J) |
|-----------------|--------------------------|--------------------------|---------------------|-----------------------------|
| CO ₂ | 460 | 560 | 32 | 110 |
| MAG | 580 | 600 | 31 | 160 |

2 MG-51T

Ar+CO₂ MAG
 且 75 95%Ar

4 MAG CO₂ 10
 20% MAG I>280A

5

6 CO₂

+

CO₂/MAG

1 CO₂ +

2 Ar+CO₂ MAG +

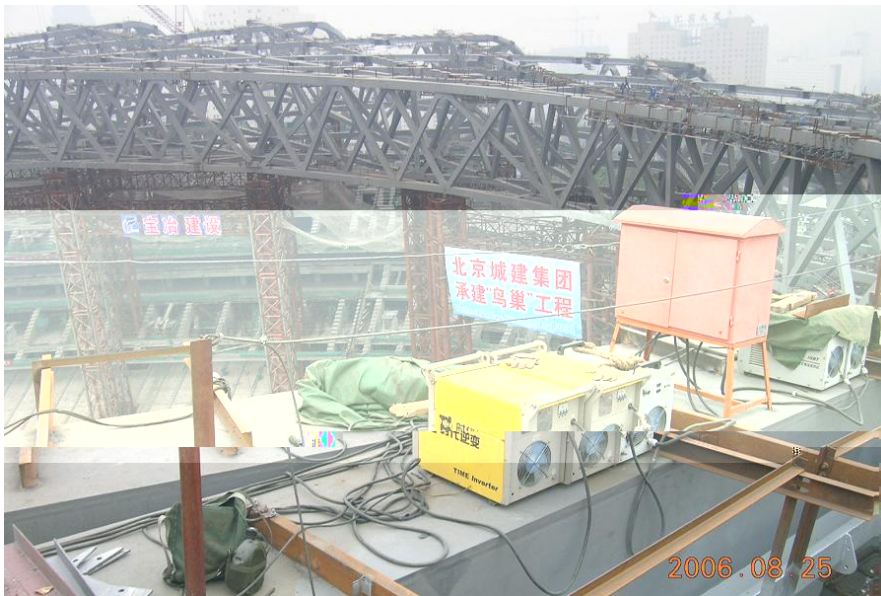
下

1 Φ 5mm 30mm

3 TIG +MAG
Dg100-800mm 5-70mm 800 X

100%

4



2

2 3