

a Ar+5 10%CO₂+1 3%O₂
Ar CO₂ O₂

b Ar+10 20%CO₂+5%O₂

MIG

TIG

MIG

1 Ar+1 2%O₂

1-2%

2 Ar+2 5%CO₂

2-5%CO₂

CO₂ 5%

0.03%

3 Ar + 25%CO₂

TIG

+MAG

4 Ar+5%CO₂+2%O₂

5 Ar+He+CO₂

6 Ar+CO₂+ N₂

7 Ar+He 25%

625 MIG

100%CO₂

80%Ar+20%CO₂

CO₂/MAG

CO₂/MAG

	1993	IGBT		
70		2003		DSP
		2013	TD	



	TD		
		DSP	CO ₂ /MIG/MAG
TIG			/